

PRODUCT NAME

Chromate Free Etch Primer

ORIGINALLY ISSUED

05/05/2011

VERSION

3.0

PRODUCT CODE

PRIETCCFCOL

VERSION DATE

09/12/2020



PRODUCT DESCRIPTION

Quick drying Chromate free etch primer providing good anti corrosive properties and excellent adhesion to ferrous and non-ferrous metals.

It can be used as a 1 pack when mixed with thinner 2691 or 2711, or as a 2 pack wash primer when mixed with KR08 Activator (see application details).

Alternatively Chromate Free Etch can be used as a 1K in an aerosol.

Product can be overcoated with most HMG primers and can be used in conjunction with powder coatings.



IMPORTANT INSTRUCTIONS BEFORE USE

- Read and follow SDS, TDS and label instructions
- Stir all paints thoroughly before use
- Always use the same batch number on the same job
- Check colour & sheen. HMG will not accept any discrepancies arising after use
- Filter the product immediately before use
- Reduce emissions and maintain quality by replacing tin lid after use
- If in any doubt speak HMG Technical Service Department on (0161) 205 7631



SPECIAL PROPERTIES

- Chromate-Free
- Ease of use
- Quick drying



MAXIMUM VOC CONTENT (RFU)

0.79Kg/L



COLOUR RANGE

- Light Grey, special colours can be matched by request.



GENERAL INFORMATION

Coverage 11 square metres per litre @ 15 microns dft
Flashpoint 23°C
Storage Store between 5°C - 25°C. When not in use, cans must be kept sealed
Shelf Life 12 months from delivery date in original sealed containers



CLEANING

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove all traces of contaminants.

HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process.

Please refer to our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



SURFACE PREPARATION

Please refer to Knowledge Base for details on Surface Preparation.



ADDITIONAL INFORMATION

It is no longer recommended to use an etch primer under an epoxy primer. Residual acid from the etch primer can interfere with the proper curing of the epoxy. This may lead to extended dry times, potential blistering, and even adhesion failure. So next time you are planning to paint bare metal with an epoxy, follow the recommendations on the datasheet and use the epoxy directly on the properly cleaned and sanded bare metal substrate.



HEALTH AND SAFETY

- Refer to Health & Safety Data Sheet prior to use.

APPLICATION METHODS

COMPLIANT SPRAY GUN



MIXING RATIO

| | | | | | | | |
|-----------------|---|--|--|--|--|--|--|
| Base | 1 | | | | | | |
| Hardener for 2K | 1 | | | | | | |
| Base | 1 | | | | | | |
| Thinner for 1K | 1 | | | | | | |



HARDENER OPTIONS

| | | | | | | | |
|------------------------|--|--|--|--|--|--|--|
| 2K Etch Activator KR08 | | | | | | | |
|------------------------|--|--|--|--|--|--|--|










THINNER OPTIONS

| | | | | | | | |
|--------------|--|--|--|--|--|--|--|
| Thinner 2691 | | | | | | | |
| Thinner 2711 | | | | | | | |



VISCOSITY

| | | | | | | | |
|-------|----------------|--|--|--|--|--|--|
| 18-20 | seconds B4 cup | | | | | | |
|-------|----------------|--|--|--|--|--|--|

| | | | | |
|--|-------------------------------------|------------|--|--|
|  | SPRAY GUN SETUP | | | |
| | 1.4-1.8 | | | |
|  | NUMBER OF COATS (GUIDE ONLY) | | | |
| | 1 full coat | | | |
|  | FLASH OFF | | | |
| | 10-15 mins | | | |
|  | DRYING TIME | | | |
| | Touch dry | 20-30 mins | | |
| | Hard dry | 60 mins | | |
| | Full dry | 24 hours | | |
|  | RECOATABILITY / OVERCOATING | | | |
| | 15-30 mins | | | |
|  | POT LIFE | | | |
| | 4 hours @20°C | | | |
|  | DRY FILM THICKNESS* | | | |
| | 10-15 microns | | | |
| <p><small>* - HMG Technical Data Sheets indicate a Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film thickness will vary depending on actual use and specification. Great care should be taken to achieve the dft stated in the agreed specification and to avoid areas of excessively low or high thickness.</small></p> | | | | |

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.