

**PRODUCT NAME**  
Speedbuild 3 Primer

**ORIGINALLY ISSUED** 22/09/2005  
**PRODUCT CODE** PRISPEED105

**VERSION** 1.0  
**VERSION DATE** 22/09/2005



**PRODUCT DESCRIPTION**

A 1K, high build, high solids, anti-corrosive primer. It combines a long wet edge time with quick drying and can be overcoated with either 1K or 2K topcoats.



**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**

- Properties can be enhanced with the use of Fleetline 9029 Zip Hardener @ 10:1 or 9030 Overdrive 1K activator @ 10:1



**MAXIMUM VOC CONTENT (RFU)**

0.54Kg/L

**REGULATIONS / COMPLIANCE**

- 2004/42 IIB (C) 540



**COLOUR RANGE**

- Available in Blue, Buff, Light Grey, Dark Grey, Off White & Red Oxide



**GENERAL INFORMATION**

Coverage	10 square metres per litre @ 55 microns dft
Flashpoint	25°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



**ADDITIONAL TECHNICAL INFORMATION**

2604 is the preferred thinner when spraying larger items, such as commercial vehicles.



**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.



**SUITABLE SUBSTRATE & THEIR SUITABLE PREPARATION**

**MILD STEEL**  
Remove millscale and thoroughly degrease using suitable HMG Prep Clean  
Abrade with P80-P180 if necessary before applying HMG Primer

**SHOT BLASTED STEEL**  
Remove all traces of blast grit/sand before applying HMG Primer

**GRP**  
Abrade with P180-P320  
Degrease using suitable HMG Prep Clean before applying HMG Primer

**ALUMINIUM**  
Abrade with P180-P320  
Degrease with suitable HMG Prep Clean  
Coat with appropriate HMG Etch Primer, and if required HMG Primer

**GALVANISED STEEL**  
Abrade with P180-P320  
Degrease with suitable HMG Prep Clean  
Apply HMG Mordant Wash  
Coat with appropriate HMG Etch Primer, and if required HMG Primer



**SUGGESTED PRIMER / FILLER / SEALER SYSTEMS**












- 2K Etch Primer ST3000



**HEALTH AND SAFETY**

- Refer to SDS and tin label prior to use.
- Suitable respiratory equipment should be worn when spraying.
- Contaminated Rags, Spray Booth Filters or other substrates should be segregated from other chemical waste, soaked with Water and disposed of in a non-combustible container with a tight fitting Lid.

## APPLICATION METHODS

	COMPLIANT SPRAY GUN		PRESSURE POT		AIRLESS/AIR-ASSISTED			
	<b>MIXING RATIO</b>							
	Base	3	Base	3	Base	5		
	Thinner	1	Thinner	1	Thinner	1		
	<b>THINNER OPTIONS</b>							
	Thinner 2601		Thinner 2601		Thinner 2601			
	Thinner 2602		Thinner 2602		Thinner 2602			
	Thinner 2603		Thinner 2603		Thinner 2603			
	Thinner 2604		Thinner 2604		Thinner 2604			
	<b>VISCOSITY</b>							
	30-35	seconds DIN4	30-35	seconds DIN4				
	<b>SPRAY GUN SETUP</b>							
	1.2-1.4		1.8-2.0		11-15 thou 40/50°			
	<b>NUMBER OF COATS (GUIDE ONLY)</b>							
	1-2 full coats		1-2 full coats		1 full coat			
	<b>FLASH OFF</b>							
	10-15 mins between coats		10-15 mins between coats					
	<b>DRYING TIME</b>							
	Touch dry	30mins @20°C	Touch dry	30mins @20°C	Touch dry	30mins @20°C		
	Hard dry	24 hours	Hard dry	24 hours	Hard dry	24 hours		
	<b>RECOATABILITY / OVERCOATING</b>							
	Minimum 45mins -1hr @ 20°C. After 24 hours, either flat prior to applying Topcoat or recoat with itself.							
	<b>POT LIFE</b>							
	Unlimited, stirring required over time		Unlimited, stirring required over time		Unlimited, stirring required over time			
	<b>WET FILM THICKNESS*</b>							
	100 microns		100 microns		100 microns			
	<b>DRY FILM THICKNESS*</b>							
	55 microns		55 microns		55 microns			

\* - 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.

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 particular use. For professional use only.