

PRODUCT NAME

ST3000 LF 63 Chromate Free 2K Etch Primer

ORIGINALLY ISSUED

21/02/2020

VERSION

4.0

PRODUCT CODE

PRIST3000

VERSION DATE

29/11/2021



PRODUCT DESCRIPTION

A Chromate free translucent 2K Etch Primer offering outstanding adhesion and corrosion resistance when applied to metals, especially aluminium and alloys.



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



MAXIMUM VOC CONTENT (RFU)

0.750K_g/L

REGULATIONS / COMPLIANCE

- 2004/42 IIB (C) 780
- 2011/65/EU



COLOUR RANGE

- Translucent Yellow



GENERAL INFORMATION

Coverage 20 square metres per litre @ 5 microns dft
Flashpoint -6°C
Temp Resistance 200°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

Due to the temperature resistance of ST3000 it is suitable as an Etch Primer underneath wet and Powder Coatings.



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

Due to the variations in quality and nature of substrates, and in processing techniques, it is always advisable to carry out process compatibility trials prior to production commencement.

This is especially pertinent when using ST3000 Chromate Free 2K Etch Primer, compared to chromate containing products.

Please refer to Knowledge Base for details on Surface Preparation.



SUITABLE SUBSTRATE & THEIR SUITABLE PREPARATION

ALUMINIUM

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

GALVANISED STEEL

Degrease with suitable HMG Prep Clean
Apply HMG Mordant Wash
Coat with appropriate HMG Etch Primer, and if required HMG Primer



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 SDS and tin label prior to use.
- Suitable respiratory equipment should be worn when spraying.

APPLICATION METHODS

CONVENTIONAL SPRAY GUN

PRESSURE POT

ROLLER

	MIXING RATIO							
	Base Activator	1 1	Base Activator	1 1	Base Activator	1 1		
	HARDENER OPTIONS							
	3173 Activator		3173 Activator		3173 Activator			
	THINNER OPTIONS							
	VISCOSITY							
	13-17	seconds B4 cup	13-17	seconds B4 cup				
	SPRAY GUN SETUP							
	1.6-1.8		1.0-1.1					
	NUMBER OF COATS (GUIDE ONLY)							
	1 even coat		1 even coat		1 even coat			
	FLASH OFF							
	10-15 mins between coats		10-15 mins between coats		10-15 mins between coats			
	DRYING TIME							
	Touch dry Hard dry	30mins @20°C 60mins @ 20°C	Touch dry Hard dry	30mins @20°C 60mins @20°C	Touch dry Hard dry	30mins @20°C 60mins @ 20°C		
	RECOATABILITY / OVERCOATING							
	Can be overcoated after 30 mins without sanding with recommended HMG 1K or 2K Primers. Epoxy Primers / Topcoats are not recommended.							
	POT LIFE							
	8 hrs @ 20°C		8 hrs @ 20°C		8 hrs @ 20°C			
	WET FILM THICKNESS*							
	25-35 microns		25-35 microns		25-35 microns			
	DRY FILM THICKNESS*							
	5-10 microns		5-10 microns		5-10 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 own particular use. For professional use only.