

Primer

503 1K Etch Primer

Product Description

503 is a high performance polyvinyl butyral and epoxy based, self-etch coating, to provide adhesion and anti-corrosive properties on ferrous metals, zinc coated steels and non-ferrous metals such as aluminium. Can be overcoated with 2-pack polyurethanes, enamels and lacquers.

Technical Characteristics






Color: Grey Shelf life: 12 months at 25°C Theoretical spreading rate: 250-300 m²/l (avg) at 1 µm

Pre-treatment

Structural steel: Abrasive blast class 2

Mild Steel, Zinc, gal, aluminium: Remove rust, corrosion products, grease, oil, dirt, moisture, degrease thoroughly.

Apply first coat wet (15 microns) Second coat wet (15 microns)

	Mixing Ratio	503 1K Etch 100 (vol) 504 Etch 0-30 (vol)																		
	Spray Viscosity Potlife	16 to 20 seconds DIN 4 cup 25°C 1.5-2 hours at 25°C																		
	Sprayguns	Gravity-feed spray gun 1.3 – 1.7 mm 1.5 – 2.0 bar 15 – 20 cm																		
	Application	Number of spray coats: 1 wet + 1 wet coat Flash-off: 8- 10 mins Film thickness: 30 microns																		
	Drying	<table border="0"> <tr> <td>Drying</td> <td>25°C</td> <td>60°C</td> </tr> <tr> <td>Dust free after</td> <td>5 mins</td> <td></td> </tr> <tr> <td>Touch Dry</td> <td>10 mins</td> <td></td> </tr> <tr> <td>Fully cured after</td> <td>3 – 4 hours</td> <td>30 mins</td> </tr> <tr> <td>Recoat Enamel</td> <td>30 – 60 minutes</td> <td></td> </tr> <tr> <td>Recoat Lacquer</td> <td>2 hours</td> <td></td> </tr> </table>	Drying	25°C	60°C	Dust free after	5 mins		Touch Dry	10 mins		Fully cured after	3 – 4 hours	30 mins	Recoat Enamel	30 – 60 minutes		Recoat Lacquer	2 hours	
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Further Treatment																				

The products are suitable for professional use only. The data contained in this publication are based on our current knowledge and experience. You can obtain the latest version of technical data sheet directly from your supplier.

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