

CT Coatings Technical Data Sheet



Product Name	High Build CT - 1K Primer 1K Zinc Phosphate Primer
---------------------	---

Issue date	17/04/2003
Formula Number	10562 Blk, 10563 Blue, 10564 Buff, 10565 off White, 10566 Grey, 10567 Red,
Product code	PR1HBCT

Packaging
High Build CT - 1K Primer is available in 5 litre, 20 litre or 205 litre pack sizes.

Product Description & Function
"High Build CT 1K Primer" is an Alkyd Phenolic based high build coating offering outstanding adhesion, moisture resistance and corrosion protection due to the incorporation of modified Zinc Phosphate. Designed for Airless or conventional application for Commercial Vehicle Chassis & Bodies. It is easy to apply without fear of runs or sags at high wet film thickness. High Build CT Primer can be used as a single pack or two pack primer when mixed with HMG Hardener (AIF249) @ 10:1 to enhance the general properties. High Build CT Primer is available in Light Grey, Dark Grey, Buff, Blue, Off White, Red, High Build CT Primer is Compliant to PG6/34 when used as a wet on wet primer.

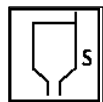
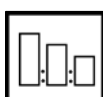


Substrates & Preparation
<p>Aluminium - Scuff with Scotbrite pad or 240g-320g depending on grade of Aluminium. Must be preprimed with HMG 2K Etch primer (NT2000) or 2K Washfiller (High Build Etch Primer) prior to High Build CT primer being applied.</p> <p>Steel - Sand with P180-P320g</p> <p>OEM / 2K / Aged Synthetic Finishes - Sand with P180-P320g</p> <p>GRP - Sand with P180-P320g being careful not to abrade through the Gel coat.</p>



Cleaning
All surfaces should be pre cleaned prior to preparation and prior to application of primer with a suitable HMG Prep Cleaner.

Application



	HVLP	Pressure Pot	Airless / AirAssisted
Mixing Ratio Base Thinner (see options)	4 Parts 1 Part	4 Parts 1 Part	10 Parts upto 10% as required. Optional
Spray Viscosity	(HVLP) 30 - 35 secs @ 20c (DIN 4)		
Gun Set Up	1.8 - 2.0 Fluid Tip	1.2 - 1.4 Fluid Tip	11 - 15 thou / 40 angle
No of Coats	2 Full Coats	2 Full Coats	1 Full Coat
Flash Off	10 - 15 mins between coats		
Drying	30 mins Touch Dry @ 20C 2 hrs Firm Dry @ 20C / Hard Dry Overnight @ 20C		
Pot Life	Unlimited, however, over time settlement will occur & stirring will be required.		
Film Build	100 microns WFT gives 55 microns DFT		
Overcoating	Minimum: 1 hour @ 20C / Maximum: 24 hrs. After which, flattening and recoating with primer is recommended.		
VOC (Ready for Use)	<540g/l	<540g/l	<540g/l

Thinner Options		
Thinner 2601	Fast	Dependant on temperature or size of vehicle to enable a Wet Edge to be retained. The choice of correct thinner will give optimum lay down of product and ease of application.
Thinner 2602	Medium	
Thinner 2603	Slow	
Thinner 2604	Extra Slow Thinner	

Hardener Option	
AIF249 Hardener	AIF249 Hardener is the only option available for High Build CT 1K Primer.

Technical Information	
Solids	Approximately 55%
Flashpoint	Between 22 to 32C
Storage	12 Months in Original sealed containers
Equipment Cleaning	HMG Gun Cleaner Thinner
Coverage	10 square metres per litre (theoretical)
VOC	450g/l

Special Properties	
Compliant as a wet on wet primer surfacer to PG6/34	

Health & Safety	
Refer to "Material Safety Data Sheet" and tin label prior to use.	
Wear suitable respiratory equipment.	