

WG 6650 - 2K ETCH PRIMER ZINC CHROMATE FREE

Definition

Product code	AW6650
Nature of product	EPOXY VINYL, ACID CATALYSIS
Famille (NFT 36-003) :	
Use / Destination	2K ETCH PRIMER ZINC PHOSPHATE BASE AND WITHOUT ZINC CHROMATES FOR FERROUS AND NON-FERROUS METALS (ZINC, ALUMINIUM, CHROME, ELECTROZINC), PLASTICS HIGH BUILD REACTIVE ETCH PRIMER (30 TO 40µ WET) GOOD STAND TO THE CORROSION ACCEPTS ALL TOPCOATS : 2K, 1K, ACRYL, CELLULOSE INSULATOR FOR DISCHARGING BOTTOMS
Colours	GREY GREENISH
Aspect	SATIN MATT

Physical Characteristics

Supply viscosity (NFT 30-014)	120 TO 150 SEC AFNOR CUP N 4 AT 20 C
Density (NFT 30-020)	1,050 (+/-0.050)
Solid content in weight (NFT 30-084)	52 % (+/-5)
Solid content in volume	42 % (+/-5)
Theoretical coverage	10 M /L FOR 25µ DRY
VOC	> 780 GR/L READY TO USE. IN CONFORMITY WITH DIRECTIVE 2004/42/CE

Supply Characteristics

Packaging	1 L - 5 L - 15 L
Flash point	> 23 C
Transport code	CLASS 3, GROUP 3.3, UN : 1263, IMDG : 3372

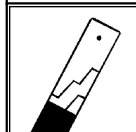
This data sheet is designed to inform our customers about the properties of the product. As we can't control the application it is up to the users to make tests to check if the product fits the application. These indicative information are given as objectively as possible and in no case they would involved our responsibility. This data sheet cancels and replaces any anterior edition. MSDS are given on demand.

Use



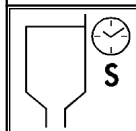
Substrate

CLEANING / SANDING : P 600 -800 WET OR P 280 -320 DRY
ON SAND BLASTED OR GRIT BLASTED PIECES IN 3 COATS SYSTEM



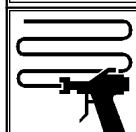
Preparation

SPRAY GUN :
1 + 1 IN VOLUME
ETCH PRIMER WG 6650 : 100 PARTS
THINNER 6650 : 100 PARTS



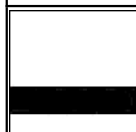
Viscosity of application

22 TO 28 AFNOR CUP N 4 AT 20 C



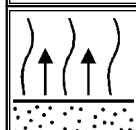
Application / Adjustment

	Nozzle (mm)	Pressure (bar)	Number of coats
HVLP	1.2	2.0	1 - 2
Membrane pump	1 - 1.2	0.5 - 0.8	1 - 2
Airless airmix	0.9 - 11	40 - 120	1 - 2
Pneumatic	1 - 1.5	3.5 - 5	1 - 2



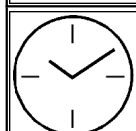
Thickness

DRY : 15 TO 25 μ MAXI
10 C < TEMPERATURE < 30 C HYGROMETRY 80%



Flash off time

10 MIN AT 20 C



Drying time

DUST FREE : 15 MIN AT 20 C
DRY TO TOUCH : 45 MIN AT 20 C
RECOATING AFTER 15 MIN AT 20 C

Keeping

POT LIFE : 8 HOURS AT 20 C
STORAGE : 2 YEARS IN A SEALED CAN OF ORIGIN STORED BETWEEN 10 AND 30 C

Notes :

WARNING ! DO NOT OVER SPRAY
MAXIMUM DRY THICKNESS TO BE 25 μ , OTHERWISE RISK OF UNSTICKING