

DESCRIPTION

- an ultra-premium, two-part anticorrosive, polyurethane primer for mild steel

PRINCIPAL CHARACTERISTICS

- excellent adhesion to suitably prepared mild steel
- fast drying
- high build, filling minor surface imperfections
- sandable finish providing increased gloss and depth of image in Colourthane C-series topcoat
- tough, flexible and abrasion resistant
- can be air dried or force dried up to 60°C on metal to improve throughput

Note: we advise that you test this product to determine if it is suitable for your particular use.

COLOURS AND GLOSS

- beige, satin

RECOMMENDED FILM THICKNESS (PER COAT)

	Typical
Dry film thickness microns	50
Wet film thickness microns	100
Theoretical spreading rate m ² /l	10.0

BASIC DATA AT 25° C AND 50% RELATIVE HUMIDTY

- vehicle type..... acrylic polyurethane
- solids content approx..... 50 % by volume
- mix ratio 4A:1B by volume
- dust free after 30 minutes
- touch dry after 1 hour
- hard dry 24 hours
- full cure after 7 days

RECOMMENDED SUBSTRATE CONDITIONS AND TEMPERATURE

- best coating performance will be obtained with the highest degree of surface preparation
- degrease thoroughly to remove all oil, grease and other surface contaminants
- mild steel; remove all rust and any loose material by wire brush or mechanical sander, abrade entire surface with P80-180 grit sandpaper
- non-ferrous metals, stainless steel, galvanised iron, ZINCALUME[®], abrade using a Scotch-Brite[®] pad or wet and dry sandpaper. Do not use steel wool. Prime with Wattyl Super Etch[®] Primer (this system may be used on non-ferrous metals to allow for filling and sanding prior to application of Colourthane C-series Topcoat).
- suitable previous coat; degrease and dry sand with P180-280 grit sandpaper or wet sand with P280-400 grit sandpaper
- substrate temperature should be at least 3°C above dew point
- relative humidity should not exceed 75 % during application and before the dry to handle time

APPLICATION INSTRUCTIONS

- mixing ratio by volume 4A:1B
- mix Colourthane PF330 Part A with Colourthane PF330 Part B only
- induction time - none
- pot life at 25°C 40 minutes. Do not use after this time even if the mix is still liquid
- stir the components and mixed product well using a mechanical mixer
- the temperature of the mixed product must be above 15°C, otherwise extra thinner may be required to obtain application viscosity
- too much thinner will result in lower sag resistance and slower cure
- thinner should only be added after mixing the components
- freshly catalysed material should not be added to product that has been mixed for some time
- spray up to 3 coats allowing for flash-off time of 5-10 minutes between coats. Flash off time is dependent on temperature and reducer used
- for mechanical/manual wet sanding; initial sanding P500-600 grit paper, final sanding P800-1000 grit sandpaper
- for mechanical/manual dry sanding; initial sanding P280 grit paper, final sanding P320-400 grit sandpaper
- may be applied wet on wet with Colourthane C-series coloured topcoat but for the highest degree of finish, sanding is recommended prior to top coating.
- if recoating after 8 hours, dry sand with P320-400 between coats
- for recommendations outside those contained in this data sheet, refer to Wattyl

APPLICATION METHODS

- **AIRLESS SPRAY**
 - recommended thinner Colourthane Reducer or L748
 - volume of thinner up to 10 %
 - nozzle orifice approx. 0.48mm (0.019 inch)
 - nozzle pressure 15 MPa (2100psi)
- **AIR SPRAY**
 - recommended thinner Colourthane Reducer or L748
 - volume of thinner 10-20 %
 - nozzle orifice approx. 1.8-2.0 mm
 - nozzle pressure 350-450 KPa (50-60psi)

can be used as a primer surfacer with addition of 30% reducer
- **CLEANING SOLVENT** Colourthane Reducer or L748

REDUCER GUIDE

Temperature	<15°C	20°C	25°C	30°C	>35°C
Colourthane Reducer Fast					
Colourthane Reducer Standard					
Colourthane Reducer Slow					
Thinner L748					

* thinning recommendations are given as a guide and may vary depending upon substrate temperature and weather conditions

SAFETY PRECAUTIONS

- flammable. Avoid contact with heat and naked flame
- avoid contact with skin and eyes
- use gloves, mask and goggles during application
- provide adequate ventilation when using in confined spaces
- this paint contains 0.035% monomeric diisocyanate when mixed. Provide adequate ventilation during use. Breathing the vapour is dangerous. Avoid breathing of fumes. Where applied by spray, use suitable air-fed respiratory equipment/hood at all times
- this product is intended for use in industrial situations by professional applicators in accordance with the advice given on this sheet. All work involving the use and application of this product should be carried out in compliance with all relevant Health, Safety & Environmental standards and regulations and must not be used without reference to the Material Safety Data Sheet (MSDS)

ADDITIONAL DATA

Overcoating Table

Overcoating with Colourthane C-series topcoat

Substrate temperature	15°C	25°C	35°C	60°C
Minimum	8 hrs	4 hrs	2 hrs	30 mins
Maximum	Unlimited- provided surface is adequately degreased and abraded with P240-320 grit sandpaper			

*surface must be dry and free from chalking and contamination

Curing Table

Substrate temperature	15°C	25°C	35°C	60°C
Dry to Handle (ready to sand)	8 hrs	4 hrs	2 hrs	30 mins
Hard Dry	48 hrs	24 hrs	16 hrs	1 hr

* adequate ventilation must be continuously maintained during application and curing

Pot Life Table

Substrate temperature	15°C	25°C	35°C
20% thinner	1 hr	40 mins	20 mins

PRECAUTIONS

- for recommendations outside those contained in this data sheet, refer to Valspar

STORAGE AND PACKAGING

- shelf life at least 12 months in an unopened container
- all components shall be stored in a dry internal environment at between 5°C and 35°C
- packaging Part A- 4 Lts and 15Lts
Part B- 1 Lt.

For the most up to date information visit our website or Contact Valspar Customer Service Hotline on:



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ISO 9001

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Valspar's laboratory facilities are accredited for technical competence with the National Association of Tests Authorities, Australia (NATA) and comply with the requirements of ISO/IEC 17025. Accreditation No.104 (Footscray), 1154 (Glendenning) and 931 (Kilburn).



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