

50-1007

## PRODUCT DATA SHEET | ข้อมูลผลิตภัณฑ์



# ANTI-CORROSION PRIMER GREY

## Akyld Nitrocellulose I Primer

**VERSION**

Version 1

Date 9 December 2018

**PRODUCT DESCRIPTION**

50-Line is Industrial coating paint base on Alkyd Nitrocellulose resin. It's provided good adhesion on metal, fast dry and also good corrosion resistance.

**SUITABLE SUBSTRATE**

Direct to steel

Direct to galvanized steel

Good adhesion on metal

**KEY CHARACTERISTICS**

- Quick dry
- Primer or sealer
- Fast dry
- Industrial coating

**PHYSICAL PROPERTIES**

|                    |  |
|--------------------|--|
| Color              | Grey color   |
| Supply viscosity   | 69 – 79 KU at 30 °C  |
| Specific gravity   | 1.20 – 1.30 g/cm <sup>3</sup>  |
| Total non Volatile | 65 – 71% at 150°C x 30 minutes   |
| Shelf Life         | 1 Year, Store in average temperature between 40 – 95 °F (5 – 35 °C). Avoid too much temperature fluctuation or direct contact with sunlight. Suitable storage temperature is 70 °F or 21°C |

**MIXING AND RELATED PRODUCTS**

|                 |                          |
|-----------------|--------------------------|
| Mixing Ratio    | Paint : Thinner          |
|                 | 100 : 100 [ by Volume ]  |
| Reducer Thinner | Standard thinner #86-100 |

**APPLIED CONDITION**

|                         |   |                          |                   |           |
|-------------------------|---|--------------------------|-------------------|-----------|
| Spray Viscosity at 25°C | FORD 4  | 10 – 15 s                |                   |           |
| Spray equipment         |   | Fluid tip                | Spray distance    |           |
|                         | Gravity feed  | 1.2-1.4 mm               | 15-20 cm          |           |
|                         | Suction feed  | 1.4 -1.6 mm              | 15-20 cm          |           |
|                         | HVLP  | 1.2-1.4 mm               | 10-15 cm          |           |
|                         | Pressure feed   | 1.0-1.2 mm               | 15-20 cm          |           |
| Spray pressure          |   | Overall and panel repair | Spot repair       |           |
|                         | Gravity feed  | 3-4 bar                  | 2.0-2.5 bar       |           |
|                         | Suction feed  | 3-4 bar                  | 2.0-2.5 bar       |           |
|                         | HVLP  | 0.7 bar at nozzle        | 0.7 bar at nozzle |           |
|                         | Pressure feed   | 4-6 bar                  | -                 |           |
| Number of coats         | 2   |                          |                   |           |
| Film Thickness          | 40-50 micron [Total dry film]   |                          |                   |           |
| Cover rate              | Approximately 10-12 m <sup>2</sup> / liters of un-mixed paint per single coat.  |                          |                   |           |
| Drying time             | 15-20 °C  | 21-25 °C                 | 25-30 °C          | 30-40 °C  |
|                         | 50-60 min   | 40-50 min                | 30-40 min         | 20-30 min |
| Surface Preparation     | with soap and water. Rinse and wipe dry with clean cloth. Finally, clean surface using Wiping Solvent #85-4 (slow) or #85-7 (fast) with clean cloth.<br>Sand steel, aluminum, or galvanized metal with 150 – 240 grit sand paper. Primer can be applied direct to metal; however, for improved adhesion to metal, we recommend priming with Epoxy Primer #58-xxxx or Etch Primer/Wash Primer #82-xxxx.<br>OEM or Original Paint must be cured and sanded with 150 – 240 grit sand paper. Clear or lacquer must be sanded with 150 – 240 grit sand paper before to avoid lifting. Body filler or fiberglass must be sanded with 150 – 240 grit sand paper. |                          |                   |           |
| Sanding step            | Final dry sanding by #P500 to #P600 before apply Topcoat  |                          |                   |           |
|                         | - Initial sanding steps may be executed with a coarser sanding grit #P320 to #P400  |                          |                   |           |
|                         | Final wet sanding step #P800 before apply Topcoat   |                          |                   |           |
|                         | - Initial sanding steps may be executed with a coarser sanding grit P600 – P800t a maximum 200 sanding grit step difference or less throughout the sanding procedure.   |                          |                   |           |
| Surface cleaning        | Remove any surface contamination prior to the application of topcoat using an appropriate surface cleaner   |                          |                   |           |

**PRECAUTION**

|         |  |
|---------|--|
| Warning | For professional or trained applicator use only. Not for sale or use by the general public. Before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep outreach of children. Always wear approved organic vapor goggle and safety mask when using product. Apply paint in good ventilating area. |
|---------|--|

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