

1K HIGH PERFORMANCE WATERBORNE PRIMER

PRODUCT CODE: SAT 1000 & 1030

TECHNICAL DATA SHEET

Product Description	A single pack waterborne anti-corrosive primer.																						
Intended Uses	Priming of Railway rolling stock.																						
Features & Benefits	<ul style="list-style-type: none">• A quick drying primer that can be overcoated with a wide range of finishing coats.• A premium performance primer which provides excellent corrosion protection.• It has excellent resistance to under film corrosion creep.• Has low odour during application.																						
Product Information	Colour	Light Beige (SAT 1000), French Grey (SAT 1030 Made to order)																					
	Volume solids	37 %																					
	Recommended DFT	50 – 60 µm per coat																					
	Recommended WFT	135 – 162 µm per coat																					
	Viscosity at 23 °C	90 - 95KU																					
	Theoretical Spreading Rate	6 m²/L per coat at 60 µm DFT																					
	Practical spreading rate	The practical spreading rate will vary depending on the surface profile of the substrate, as well as the application technique and tools used.																					
	VOC	11 g/L																					
Application Details	Mixing	Single pack. Stir until homogeneous,																					
	Method	Airless Spray: Suitable nozzle orifice: 15 thou. Thinning is not recommended for airless spray. Max wet film thickness: 170 µm Conventional spray: Suitable nozzle orifice: 1,5 mm. Nozzle pressure: 30 - 40 psi NOTE: Conventional spray could result in low applied DFT and two coats may be required to obtain specified thickness.																					
	Thinning	Water. Thin up to 10% by volume for conventional spray application. Thinning is not recommended for airless spray.																					
	Cleaning	Water. Equipment must be cleaned thoroughly with water immediately after use																					
	Drying time	<table><tr><td>Temperature</td><td>Touch Dry</td><td>Hard dry</td><td>Over coating</td></tr><tr><td>10 °C</td><td>4 h</td><td>>8 h</td><td>>8 h</td></tr><tr><td>23 °C</td><td>30 min</td><td>1h 45 min</td><td>2 h</td></tr><tr><td>32 °C</td><td>25 min</td><td>55 min</td><td>45 min</td></tr><tr><td>40 °C</td><td>20 min</td><td>40 min</td><td>30 min</td></tr></table>		Temperature	Touch Dry	Hard dry	Over coating	10 °C	4 h	>8 h	>8 h	23 °C	30 min	1h 45 min	2 h	32 °C	25 min	55 min	45 min	40 °C	20 min	40 min	30 min
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Application Environment	<table><tr><td>Surface Temperature</td><td>Ambient Temperature</td><td>Relative Humidity</td></tr><tr><td>Min: 10 °C</td><td>Min: 10 °C</td><td>Min: 10 %</td></tr><tr><td colspan="3">or 3 °C min. above dew point</td></tr><tr><td>Max.: 40 °C</td><td>Max.: 40 °C</td><td>Max: 70 %</td></tr></table>		Surface Temperature	Ambient Temperature	Relative Humidity	Min: 10 °C	Min: 10 °C	Min: 10 %	or 3 °C min. above dew point			Max.: 40 °C	Max.: 40 °C	Max: 70 %									
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Storage and Packaging	Store away from direct sun, heat and severe cold. Packaging: 5 L and 25 L																						

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Surface Preparation	<p>Surfaces may be damp but not wet, and must be clean, free from oil, grease or any other contaminants.</p> <p>1. MILD AND HOT ROLLED STEEL: Remove oil, grease and other contaminants using PLASCON AQUASOLV DEGREASER (GR 1) or REMOVAL HIGH STRENGTH DEGREASER (RCI 70) followed by clean water rinses, to a water break-free surface. Where Mill scale is present the preferred treatment is to abrasive blast clean steel surfaces using Garnet Mica to grade SA 2 ½ of the ISO Standard 8501-1:2007 with a blast profile of 30 – 35 µm. Rusted steel can be removed by mechanical wire brushing to grade ST 3 of the above standards or ST 2). Then degrease with PLASCON AQUASOLV DEGREASER (GR 1) followed by clean water rinses to a water break-free surface.</p> <p>2. GALVANISED IRON: Clean thoroughly with PLASCON GALVANISED IRON CLEANER (GIC 1) and a scouring pad. Follow with clean water rinses until a water break-free surface is obtained.</p> <p>3. PREVIOUSLY PAINTED SURFACES: Remove any loose paint, rust and other contaminants. Sand old paint thoroughly to provide a key.</p>
Cautions	<ul style="list-style-type: none"> • Low temperatures and high humidity retard drying. • Must not be used at air / substrate temperature below 10 °C. • 23 °C recommended substrate & ambient temperature.
Safety Precautions	<ul style="list-style-type: none"> • Always keep paint out of reach of children. • Ensure good ventilation during application and drying. • Avoid skin contact. If accidental contact with skin should occur, wash immediately with soap and water or a recognised skin cleaner. • Take care to avoid contact with the eyes. In case of contact, immediately rinse the eyes with plenty of water and seek medical attention. • Harmful if swallowed. Seek medical attention and do not induce vomiting. • Do not smoke while painting. • Refer to Safety Data Sheet for complete information.

DISCLAIMER:

The recommendations contained herein are given in all good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

N.B. Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

N.B: TO ORDER: Quote product name, product code number, packaging and colour.

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