

**SOLDER PRIMER 2/C**

**CODE:24.7**

**DESCRIPTION**

Reactive phenolic polyvinyl- butyric resin in combination with antirust pigments supplied in 2 components in order to preserve the acid's phosphatase action.

**USE**

Recommended for use on steel and iron surfaces to obtain an effective protection between sandblasting or deburring and the definitive paint coat. It also performs well on polished light alloy surfaces as well as on copper and lead surfaces. Recommended as a primer for systems that have to withstand temperatures of 200°C maximum.

**FEAUTURES**

MIXING RATIO	WEIGHT	VOLUME
COMPONENT A	18	18
COMPONENT B	2	2

w Finish	.....	Semi-matt
w Color	.....	Red, grey and black.
w Viscosity		Minimum 80+poises S/FR1002
w Density	.....	0,90 +/- 0,05 gr/cc S/ FR1001
w Drying	.....	10 min to the touch
Repaint		Minimum 24 hours.
Solid's volume		14% theoretical
w Thinner	.....	Primer (50.705)
Flash point		- 4°C)
w Performance	.....	9 m2/l for 15 microns
Pot life		8 hours
w COV's content	.....	700g/l.
Induction's time		15 minutes minimum at 20°C
Usage minimum temperature		Not below 5°C.
Degree of moisture content in the environment		Below 80%



Atmospheric conditions and temperature variations do not affect solder primer's hardening process.

## SURFACES PREPARATION

Sand- blast until reaching degree indicated , normally SA 2 ½.

## INSTRUCTIONS FOR USE

Using paint brush: according to viscosity supply or adding 5% of Primer solvent to compensate for quick evaporation-  
Using air-free gun: diluting with 10-15% Primer solvent.

It can be used in automatic sandblasting facilities while using guns.  
2 coats cannot be applied due to its phosphatising action nor can it be applied on old surfaces.  
The thickness of the dried paint coat is 15 microns.

## REPAINTING

All kinds of paints, of 1 or 2 components, can be used. It is not advisable to paint with nitrocellulose, chloro rubber, vinyl or with coal tar special paintings.

Repainting time:

With classic systems: 12 hours

With solvent energetic paints let it dry for 7 days.

There is no repainting limit but it is advisable to repaint as soon as possible to avoid contamination or damage.

## OBSERVATIONS

Welding:

It does not affect the welding lines nor create pores. The edge of the welding line remains intact and flames do not spread. It does not produce steam or toxicity.

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