

Date: 23rd July, 2021

Technical Data Sheet

Version:02

Product Name	
Full Product Name	330 1K Etch Primer Base (Tintable Primer)
Type of Product	1K etch primer base
Description	Concept 330 1K Etch Primer base is a chromate free 1K epoxy modified PVB etch and primer in one. It is characterised by its excellent adhesion properties over a wide range of metal substrates. It can also be used on previously painted surfaces in a sound condition. This is used with the Unicote 300 system making it tintable with concentrates to achieve any colour from the formula data base.

Products						
Product Name	Volume Solids	Weight Solids	Density		VOC	
	%	%	g/mL	lbs/US gal	g/L	lbs/US gal
330 1K Etch Primer Base 808 Multi-Thinner	26.8	47.7	1.130	9.40	590.0	4.95
	0.0	0.0	0.805	6.71	803.5	6.71

Properties
<ul style="list-style-type: none"> Fast dry Chromate free Two in one (etch and primer)

Substrates

- Mild steel surfaces
- Aluminium
- Stainless steel grade 316
- Galvanised steel, Zincalume, Zinccanoeal
- Glass reinforced polyester (GRP & general types of fibreglass body parts)
- Sound existing enamel and acrylic lacquer surfaces

Substrate Preparation



All Substrates

All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept 025 Rust Converter.

Product Preparation



Reducer

40-100% (v/v) of Concept 808 Multi-Thinner.



Pot life @ 25°C (77°F)

N/A









Spray viscosity @ 25°C (77°F)



BSB 4 Cup
Ford 4 Cup

18-19 s
16-17 s

Product Preparation cont

 Spray equipment	Gun type	Fluid tip	Spray pressure	Spray Distance
	Gravity feed	1.8-2.0 mm 0.071-0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
	Suction feed	1.8-2.0 mm 0.071-0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
	HVLP	1.5-1.8 mm 0.059-0.071"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch
 Number of coats	2-3	Apply one coat followed by two even full coats. Avoid heavy wet coats.		
 DFT Recommended	40-50 µm 1.6-2.0 mils			
 Flash off time @ 25°C (77°F)	3-5 min between coats			
 Drying	Air Dry @ 25°C (77°F)	40-60 min		
 Sanding	Wet sand with P600-P800 before applying finish coat or Dry sand with P400-P500 using an orbital sander			
This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.				

Remarks

	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Equipment Cleaning

Use recommended Concept Paints 035 Gunwash

Dry Film Properties

After 7 days drying,
when compared to similar technology products.

Adhesion	Excellent
Corrosion protection	Excellent
Sanding	Excellent

Product Data

Colour	Unicote 300 colour data base
Theoretical Coverage	Approx. 5.0 m ² /L (205 ft ² /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature away from sunlight.

Product Packaging

Product Code	Product Name	Package Size
IN33090003.60 AU8089200000X	330 1K Etch Primer Base Multi-Thinner	3.6L 1L, 4L, 20L

Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

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This Technical Data Sheet supersedes all previous issues.

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