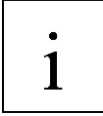


Always use correct Personal Protective Equipment

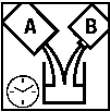
81A 2K ETCH PRIMER

Description



An acid-cured vinyl-butyrac/phenolic resin combination-etch primer suitable for use on all ferrous and non-ferrous metals. This highly rust inhibitive primer is applied as a 'wash primer'. It is non-sanding with excellent metal adhesion qualities and may be over coated with any RALI one pack or two-pack primer / surfacer / filler.

Products



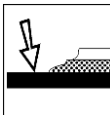
Product Type:	Vinyl-Butyral / Phenolic
Colour:	Transparent Green/Yellow.
Finish:	Matt
Pot Life:	24 - 30 hours
Density:	0.976 kg/L
Recommended D.F.T:	10 microns
Theoretical Coverage:	10 m ² /L @ 10 microns DFT

Properties



VOC:	698.12 g/L
Volume Solids:	17%
Dry Time @ 20°C:	Tack free: 10 minutes
	Handle: 20-30 minutes
	Topcoat: After 3 hr (preferably overnight).

Substrates



81A-Two Pack Etch Primer provides excellent adhesion for ferrous and non-ferrous metals. It is recommended for all properly prepared bare metal surfaces.

Surface

Preparation



Aluminium-New:

1) **Clean** the surface with water and soap (large areas). Water blasting is ideal, adding a cleaning agent such as 'Break' diluted 1 part to 10 parts of clean water or 'C' Power diluted 1 part to 20 parts of clean water.

2) Thoroughly **degrease** the surface using Wax & Grease Remover, changing rags frequently to avoid contamination.

3a) Abrading

Sandblasting is the best method of surface abrading but may well be impractical in some situations.

3b) Power Tool Abrading

This system is perfectly satisfactory and involves surface sanding the entire area with 80 - 120 grit aluminium oxide discs.

3c) Hand Abrading

Can be carried out using various grades of abrasive paper - up to 320 grit. On the intricate and flimsy constructions 3M Scotchbrite™ pads can be used to clean and abrade.

Surface

4) Acid Etching

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Preparation (cont)



Hydrafos can be applied, follow with a thorough fresh water scrub down and allow to dry. Particular attention must be paid to rinsing seams and difficult access areas and removing all contamination, residues and swarf. Immediately after the aluminium is dry, wipe clean with Wax & Grease Remover or General Purpose Thinner changing the rags frequently. It is vital that 81A-Two Pack Etch Primer is applied promptly to ensure optimum adhesion. 81A-Two Pack Etch Primer must be over coated with a Resene Automotive and Performance Coatings single or two pack primer/surfacer/filler after drying 3 hours min, but preferably overnight (refer data sheets).

New Steel:

Degrease thoroughly with Wax & Grease Remover.

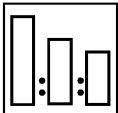
The main requirement in preparing steel for painting is to completely remove all mill scale and rust. Mill scale is a layer of iron oxide that forms on the surface as the iron or steel cools after hot rolling. As the scale is not an integral part of the steel, painting over the mill scale can never be satisfactory because corrosion begins as the mill scale lifts from the steel surface. Mill scale and surface rust should be removed by mechanical abrasion or by blasting to white metal to ensure coating contact with the metal itself. When this has been done, re-clean surface with Wax & Grease Remover. Apply 81A-Two Pack Etch Primer to a dry surface.

General Preparation

Ensure all metal surfaces to be painted are clean dry and free from oil, grease and other contamination by thorough cleaning with Wax & Grease Remover. All surfaces should be abraded with 320 grit Wet and Dry paper or scoured with 3M Scotchbrite pads.

Note: The performance success or failure of surface coatings over any metal surface is predetermined by the standard of preparation employed on the substrate itself.

Directions For Use



Mixing Ratio:

1 part 81A-Two Pack Etch Primer
1 part 81B -Hardener

Add 81B Hardener slowly to 81A-Two Pack Etch Primer and thoroughly mix. Strain the mixture.

Induction:

30 minutes, re-stir after mixing before use.

Application Method:

Apply by Compliant / Conventional suction or gravity spray gun. Apply a light even continuous coat. The result should be a green yellow transparent coat.

81A-Two Pack Etch Primer is a wash primer and is designed as an adhesion promoter only.

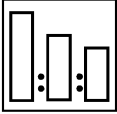
Directions For Use

Application of heavy films will lead to adhesion problems.

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(cont)



Do not apply below 10°C metal temperature.

Note: 1) It is important to protect from weather elements during the period prior to overcoating.

2) 81A-Two Pack Etch Primer is non-sanding and must be over coated with a RALI primer/surfacer/filler, after a minimum of 3 hours drying (preferably overnight).

Spray

Equipment:



Compliant / Conventional Suction and Gravity feed

Tip size: 1.4-1.8 mm

Air pressure: 310 - 380 KPA (44 - 55 PSI)

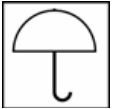
Clean up: GP Thinners

Health & Safety



For detailed information refer to Safety Data Sheet (SDS). Mixed product contains isocyanates. Inhalation of vapours or dust from sanding may cause respiratory sensitisation. Splashes to eyes will cause irritation. Contact with skin may cause irritation. Applicators should use protective clothing and respiratory equipment. Product is flammable, use and store away from heat and ignition sources

Transport & Storage



Sizes: 1L, 4L
Dangerous Goods: 3A
UN: 1263
Hazchem: 3(Y)E
Packing Group: II
Shipment name: PAINT Flammable
Flash point: -17°C

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