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| PRODUCT NAME |
| Speedbuild 3 Primer |



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|--------------|-----------|
| ISSUE DATE | 22/9/2005 |
| FORMULA NO | 10571 |
| PRODUCT CODE | PRISPEED3 |

**PRODUCT DESCRIPTION**

Speedbuild 3 is a 1K superior high build, high solids, anti-corrosive primer/undercoat.

It combines a long wet edge with quick drying that can be overcoated with either 1K or 2K topcoats.

**SPECIAL PROPERTIES**

- Properties can be enhanced by the addition of Hardener 9029 (Zip)

**MAXIMUM VOC CONTENT (RFU)**

0.54kgs/ltr

REGULATIONS / COMPLIANCE

2004/42 IIB (C) 540

**COLOUR RANGE**

Available in Black, Blue, Buff, Grey, Lt.Grey, Red, Red Oxide and Off White.

**TECHNICAL INFORMATION**

FLASHPOINT

25°C

STORAGE

12 months in original sealed containers

**CLEANING**

Ensure surfaces to be coated are dry and free from all traces of contaminants.

HMG produce a full range of cleaners, silicone removers, degreasers and preparatory cleaners suitable for the cleaning process.

Please refer to Preparatory Cleaner index.

**SURFACE PREPARATION**

Please refer to HMG Technical Library for details on surface preparation.

**SUGGESTED PRIMER / FILLER / SEALER SYSTEMS**

2K Etch Primer High Build Washfiller; 2K Etch Primer NT2000.











**HEALTH AND SAFETY**

Refer to MSDS and tin label prior to use.

Suitable respiratory equipment should be worn when spraying.

APPLICATION METHODS

| COMPLIANT SPRAY GUN | | PRESSURE POT | | AIRLESS/AIR-ASSISTED | |
|---------------------|---|--------------|---|----------------------|--|
| MIXING RATIO | | | | | |
| Base | 3 | Base | 3 | Base | |
| Thinner | 1 | Thinner | 1 | Thinner | |

| | | | | | | |
|---|--|--|--|--------------------------------|-----------------------|--------------------------------|
|  | | | | | | |
|  | THINNER OPTIONS | | | | | |
| | Thinner 2601 Thinner 2602 Thinner 2603 Thinner 2604 | Thinner 2601 Thinner 2602 Thinner 2603 Thinner 2604 | Thinner 2601 Thinner 2602 Thinner 2603 Thinner 2604 | | | |
|  | VISCOSITY | | | | | |
| | 28-35 seconds DIN4 | 28-35 seconds DIN4 | | | | |
|  | SPRAY GUN SETUP | | | | | |
| | 1.2-1.4 | 1.8-2.0 | 13-15 thou 40/50° | | | |
|  | NUMBER OF COATS | | | | | |
| | 2 full coats | 2 full coats | 1 full coat | | | |
|  | FLASH OFF | | | | | |
| | 10-15 mins between coats | 10-15 mins between coats | | | | |
|  | DRYING TIME | | | | | |
| | Touch dry Hard dry | 30 mins @ 20°C 2 hrs @ 20°C | Touch dry Hard dry | 30 mins @ 20°C 2 hrs @ 20°C | Touch dry Hard dry | 30 mins @ 20°C 2 hrs @ 20°C |
|  | RECOATABILITY / OVERCOATING | | | | | |
| | Min 1 hr / Max 24 hrs | Min 1 hr / Max 24 hrs | Min 1 hr / Max 24 hrs | | | |
|  | WET FILM THICKNESS | | | | | |
| | 100 microns | 100 microns | 100 microns | | | |
|  | DRY FILM THICKNESS | | | | | |
| | 55 microns | 55 microns | 55 microns | | | |

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