

PRODUCT NAME

ST3000 Chromate Free 2K Etch Primer

ORIGINALLY ISSUED

01/12/2015

VERSION

1.0

PRODUCT CODE

PRIST3000

VERSION DATE

01/12/2015



PRODUCT DESCRIPTION

A Chromate free translucent 2K Etch Primer offering outstanding adhesion and corrosion resistance when applied to metals, especially aluminium and alloys.



IMPORTANT INSTRUCTIONS BEFORE USE

- Read and follow SDS, TDS and label instructions
- Stir all paints thoroughly before use
- Always use the same batch number on the same job
- Check colour & sheen. HMG will not accept any discrepancies arising after use
- Filter the product immediately before use
- Reduce emissions and maintain quality by replacing tin lid after use
- If in any doubt speak HMG Technical Service Department on (0161) 205 7631



MAXIMUM VOC CONTENT (RFU)

0.780Kg/L

REGULATIONS / COMPLIANCE

- 2004/42 IIB (C) 780
- 2011/65/EU



COLOUR RANGE

- Translucent Yellow



GENERAL INFORMATION

Coverage 20 square metres per litre @ 5 microns dft
Flashpoint -9°C
Temp Resistance 200°C
Storage Store between 5°C - 25°C. When not in use, cans must be kept sealed
Shelf Life 12 months from delivery date in original sealed containers



ADDITIONAL TECHNICAL INFORMATION

Due to the temperature resistance of ST3000 it is suitable as an Etch Primer underneath wet and Powder Coatings.



CLEANING

Ensure surfaces to be coated are dry and must be cleaned using the appropriate HMG product to remove 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 our website for Knowledge Base article Prep-Cleaning Techniques (KNB0009) and Preparatory Cleaners from the Product Guide.



SURFACE PREPARATION

Due to the variations in quality and nature of substrates, and in processing techniques, it is always advisable to carry out process compatibility trials prior to production commencement.
This is especially pertinent when using ST3000 Chromate Free 2K Etch Primer, compared to chromate containing products.

Please refer to Knowledge Base for details on Surface Preparation.



ADDITIONAL INFORMATION

It is no longer recommended to use an etch primer under an epoxy primer. Residual acid from the etch primer can interfere with the proper curing of the epoxy. This may lead to extended dry times, potential blistering, and even adhesion failure. So next time you are planning to paint bare metal with an epoxy, follow the recommendations on the datasheet and use the epoxy directly on the properly cleaned and sanded bare metal substrate.



HEALTH AND SAFETY

- Refer to SDS and tin label prior to use.
- Suitable respiratory equipment should be worn when spraying.

APPLICATION METHODS



MIXING RATIO

COMPLIANT SPRAY GUN		PRESSURE POT					
Base	1	Base	1				
Activator	1	Activator	1				



HARDENER OPTIONS

3173 Activator		3173 Activator					
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THINNER OPTIONS

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VISCOSITY

13-17	seconds B4 cup	13-17	seconds B4 cup				
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	SPRAY GUN SETUP			
	1.6-1.8	1.0-1.1		
	NUMBER OF COATS (GUIDE ONLY)			
	1 even coat	1 even coat		
	FLASH OFF			
	10-15 mins between coats	10-15 mins between coats		
	DRYING TIME			
	Touch dry Hard dry	30mins @20°C 60mins @ 20°C	Touch dry Hard dry	30mins @20°C 60mins @20°C
	RECOATABILITY / OVERCOATING			
	Can be overcoated after 30 mins without sanding with either HMG 1K or 2K Primers or HMG 1K or 2K Topcoat systems. Epoxy Primers / Topcoats are not recommended.			
	POT LIFE			
	8 hrs @ 20°C	8 hrs @ 20°C		
	WET FILM THICKNESS*			
	25 microns	25 microns		
	DRY FILM THICKNESS*			
	5 microns	5 microns		
	* - HMG Technical Data Sheets indicate a Dry Film Thickness that will be achieved when applying a particular Wet Film Thickness. These values are a guide only and are not to be used as specifications. Film thickness will vary depending on actual use and specification. Great care should be taken to achieve the dft stated in the agreed specification and to avoid areas of excessively low or high thickness.			

This information relates only to the specific material designated and may not be valid for such material used in combination with any other materials or in any process. Such information is to the best of HMG's knowledge and belief accurate and reliable as of the date indicated. However, no representation, warranty or guarantee is made as to its accuracy, reliability or completeness. It is the user's responsibility to satisfy themselves as to the suitability and completeness of such information for their own particular use. For professional use only.