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Introduction

Recommended for use as an anti-corrosive primer where good-quality chemical conversion pre-treatment is recommended or specified but may not be available. Intended to be overcoated with a suitable product from our range of coatings, depending on the end-use application. We recommend that the primer should be partially cured prior to application of the topcoat. The substrate must be in a clean, rust-free condition prior to application of the primer. Film thickness of the primer coat should be controlled to assist application of the second coat: trials are recommended to optimise application conditions.

Colour

Grey

Specific Gravity

2.64

Film Properties

Meets or exceeds the following criteria:

Mandrel bend	BS3900 Pt E1	Pass 13mm
Scratch resistance	BS3900 Pt E2	Pass 4kg
Impact resistance	BS3900 Pt E3	Pass 50 in/lbs
Adhesion	BS3900 Pt E6 (2mm)	No detachment
Salt fog resistance	ASTM B117 (1000hrs) (plain mild steel)	Max 0.5mm creep
Humidity	BS3900 Pt F2 (1000hrs) (plain mild steel)	No blistering

Curing Conditions

Recommended minimum cure schedule 180°C (5 mins at object temperature for partial curing or 10 mins if required fully cured).

Film Thickness

Recommended film thickness range for optimum performance is 45-55 microns.

Application

May be applied through most currently available equipment. Tests should be carried out to ensure suitability prior to full-scale application. Subsequent topcoats may require modified application conditions, e.g. lower voltage. Please note we strongly advise against the use of pre-treatment over the zinc primer between coats. Subsequent topcoats may require modified application conditions, e.g. lower voltage.

Pre-treatment

Thermaset Ltd's Zinc Rich Primer adheres to most metals and does not require other primers. Articles to be coated must be free from rust, grease, oil and mill scale. Solvent vapour degreasing is usually adequate. Phosphate or chromate conversion coatings may be used if even greater corrosion protection is specified.

Our technical service department will be pleased to offer further advice on this subject if required.

Storage and Handling

Store in dry, cool conditions, preferably below 25°C. Shelf life under these conditions will be approx. 12 months. For full information on handling this product type, refer to individual Safety Data Sheet, and the 'Code of Safe Practice' issued by the British Coatings Federation.

Individual Product Information

Reference number – TLE-6226-M

Colour – grey only

Gloss level – semi-matt only

Specific gravity – 2.64

Stoving schedule – 180°C/5 mins for partial cure

Health & Safety

We recommend all users of powder coatings to refer to the Code of Safe Practice: Application of Powder Coatings by Electrostatic Spraying (published by the British Coatings Federation of Great Britain Ltd) and our appropriate Health & Safety data sheet.

May 00