










# APPLICATION DATA SHEET



Edition : october 2018  
 Review : 4

## ALKYD PRIMER CHROMATE FREE

TT-P-1757 B TYPE I CLASS N

	<b>Mixing ratio</b>	<b>By weight</b>		<b>By volume</b>		
		Comp. A	-	Comp. A	-	
		Comp. B	-	Comp. B	-	
	<b>Hardener</b>	-				
	<b>Thinner / Reducer</b>	<b>THINNER MIL-DTL-81772B Type I</b>				
	<b>Homogeneization</b>	<i>It is advisable to make homogeneous the product before its reduction. We strongly suggest a mechanical mixing (better than a "shaking" process) at least for 2 ÷ 3 minutes after each operation.</i>				
	<b>Application viscosity <sup>(1)</sup></b>	-				
	<b>Pot life</b>	-				
	<b>Induction time</b>	<b>not required</b>				
	<b>Application temperature</b>	<b>15 ÷ 25°C</b>				
	<b>Application procedure</b>	<b>Thinner ratio <sup>(2)</sup></b>	<b>Coats</b>	<b>Materiale pressure</b>	<b>Spraying pressure</b>	<b>Nozzle diameter</b>
	<b>Airless/Airmix <sup>(3)</sup></b>	5% MAX	2 <sup>(4)</sup>	140 ÷ 160 bar	4,0 ÷ 5,0 bar	0,013"/40
	<b>Electrostatic equipment</b>	-	-	-	-	-
	<b>Gravity spray gun</b>	5% MAX	2 <sup>(4)</sup>		2,5 ÷ 3,0 bar	1,4 ÷ 1,6 mm
	<b>Rt gumt g'gs wlr o gpv</b>	5% MAX	2 <sup>(4)</sup>	2,5 ÷ 2,8 bar	2,5 ÷ 2,8 bar	1,4 ÷ 1,6 mm





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 <b>Drying: (5)</b>  <b>Flash-off at 22 ÷ 25°C (6)</b>  <b>Drying time:</b>  <b>a) aria a 22 ÷ 25°C</b>  <b>b) by oven at 45 ÷ 50°C (11)</b>	-			
	<b>30 minutes</b>			
	<b>Set to touch</b>	<b>Overcoatable (7)</b>	<b>Dry hard (8) (9)</b>	<b>Full cure (10)</b>
	<b>1 h</b>	<b>2 h</b>	<b>24 h</b>	-
	-	<b>30 min</b>	<b>24 h</b>	-
 <b>Dry film thickness (12)</b>	<b>advised 15 ÷ 23 µm</b>			
 <b>Theoretical yield (13)</b>	<b>By weight</b>		<b>By volume</b>	
	<b>&gt; 20 m<sup>2</sup>/kg</b>		<b>&gt; 25 m<sup>2</sup>/lt</b>	
 <b>Equipment cleaning</b>	<b>Fresh product</b>		<b>THINNER MIL-T-81772B Type II</b>	
	<b>Dried product</b>		<b>THINNER MIL-T-81772B Type II</b>	

- NOTE**
- (1) The application viscosity data is not reported because it is strictly related to the spraying equipment will be used.
  - (2) The data reported about product reduction is referred to the amount of thinner, by weight, to add at the prior mixed product, that is after its catalysis.
  - (3) The reported data is referred to an application using a WAGNER equipment having compression ratio as 40:1.
  - (4) "2 coats" means a crossed layer of product. It is advisable to observe the suggested thickness.
  - (5) The reported data are only referred to a static boot drying. For equipment where dynamic drying is expected/required (for instance "chain" equipment) these data has to be up-dated upon check of this type of equipment by NVSC.
  - (6) The reported flash-off time has to be observed only when a forced drying by oven is expected/wished.
  - (7) The reported data is referred to a minimum time to be observed beyond which the product can be overcoated with a topcoat.
  - (8) The reported data is referred to the minimum time before to handle the painted parts.
  - (9) Considered that it is a two-component product, its cross-linking will be complete at least after 24 hours, independently if dried by air or by oven. After this time it is advisable to carry out a light scuff-sanding by fine abrasive paper, so to guarantee a perfect adhesion of the subsequent product will be used.
  - (10) The reported data is referred to the minimum time to be observed before to expose the painted parts to external environment and/or to carry out the expected acceptance test.
  - (11) The product is formulated to dry at room temperature. Data regarding a drying by oven is only supplied in order to ease, if necessary (see note 6), a specific customer request.
  - (12) The advised thickness data is referred to the limits expected from the corresponding Technical Specification.
  - (13) The advised theoretical yield is referred to the product use in compliance with thickness expected from the corresponding Technical Specification.

For a safe use of the product, consult the correspondent "Safety Data Sheet". The products are suitable for professional use only.

All the information contained in this Application Data Sheet are based on better practice and/or on laboratory experience. Customer and/or user have the responsibility to check if the product will be suitable to intended use. The manufacturer disclaims any responsibility due to a not proper use of the product not in compliance with data reported in this document. This Application Data Sheet cancels and replaces previous edition. The data contained can be changed, upon new review, every time if necessary.