



## 2100 PRIMER

## One Pack Universal

### PRODUCT DATA SHEET

- Contains zinc phosphate** - **Added corrosion protection for greater durability**
- Superb flow and laydown** - **Excellent topcoat appearance**
- Fast drying** - **Helps to improve productivity**
- Range of tinted options** - **Helps opacity of most difficult topcoat shades**
- Can be air dried or stoved** - **Suitable for all applications**

<b>Product &amp; Ancillaries</b>	2100 Primer 05-46 Thinner Electrostatic Thinner		
<b>Suitable Substrates &amp; Preparation</b>	Steel	Degrease and abrade with P180. If necessary blast clean to remove millscale, minimum surface preparation SA2	
	Aluminium & Galvanised steel	Degrease and abrade with P240 to remove surface oxide layer. Apply Cromadex 903 chromate-free etch primer	
<b>Thinning ratio (by volume)</b>	5 parts 2100 Primer 1 part 05-46 Thinner (dependent on application equipment)		
<b>Spraying viscosity</b>	45 - 55 seconds ISO Cup4 @ 20°C		
<b>Spraying equipment</b>	<i>Spray Gun</i>	<i>Fluid tip size</i>	<i>Working pressure</i>
	Conventional	1.4 - 1.8mm	3.5 - 4.2 bar
	Suction feed HVLP	1.4 - 1.8mm	0.7 bar (max)
	Pressure pot HVLP	1.0 - 1.4mm	0.7 bar (max)
	Airless	11 - 18 thou	
	Air Assisted Airless	11 - 15 thou	
	Electrostatic	Thin to equipment manufacturers recommended resistivity using Cromadex Electrostatic Thinner	
	Heated Methods	Reduce thinning ratios as required.	
<b>Approved thickness</b>	25 - 50 microns DFT		70-140 microns WFT

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<b>Volume Solids</b>	35.6% (dependent on colour)			
<b>Overcoatable with</b>	All Cromadex Topcoats except 700, 740 & 742			
<b>Drying times</b> <b>Substrate temp</b>	<b>Drying Times</b>		<b>Overcoating Times</b>	
	<b>Touch Dry</b>	<b>Through Dry</b>	<b>Minimum</b>	<b>Maximum</b>
20°C	25 mins	6 hours	25 mins	Unlimited
35°C	15 mins	5 hours	15 mins	Unlimited
	Note: If primer is not overcoated within 14 days then abrade with either P240 or P320 and clean with Cromadex 678 Spirit Wipe			
<b>Force drying</b>	Flash-off for 10 - 15 mins, then 60 - 80°C for 30 mins			
<b>Stoving</b>	Flash-off for 10 - 15 mins, then 120°C for 30 mins			
<b>Full properties</b>	7 days			
<b>Coverage</b>	13 - 15 m <sup>2</sup> /l @ 25 microns, assuming 100% transfer efficiency, dependent on colour			
<b>Shelf Life</b>	12 months, in an unopened, original container from date of manufacture Storage should be in accordance with the instructions in Section 7 of the relevant Material Safety Data Sheet.			
<b>Colour</b>	White (nr RAL 9010), light grey (nr RAL 7035), dark grey (nr RAL 7031), red oxide & buff (nr RAL 1001) Other tinted shades are available on request – all lead chromate-free			
<b>Gloss</b>	N/A			
<b>Properties</b>	<b>VOC</b>		<b>Specific Gravity</b>	
2100 Primer	527-575 g/l		1.21	
	(dependent on colour)		(dependent on colour)	
05-46 Thinner	867 g/l		0.87	
Electrostatic Thinner	781 g/l		0.85	

**Before using this product please refer to the Cromadex Material Safety Data Sheet.**

**Disclaimer :** The information contained in this data sheet is not intended to be exhaustive, and any person using the product without first obtaining written confirmation from us as to the suitability of the product for the intended purposes, does so at their own risk. Whilst we endeavour to ensure that all advice we give about the product (whether in this sheet or otherwise) is correct, we have no control over either the quality or condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree to do so, we do not accept any liability whatsoever arising from the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of the use of this product. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

It is the user's responsibility to check that this data sheet is current prior to using the product.