



213 Plus PRIMER

Quick Drying Primer

PRODUCT DATA SHEET

- Contains zinc phosphate** = **Added corrosion protection for greater durability**
- Quick drying** = **Helps to improve productivity**
- Suitable for a wide range of application equipment** = **Simple application**
- High build** = **Covers surface profile**

Product & Ancillaries	213 Plus Primer 05-46 Thinner 85-72 Thinner Electrostatic Thinner		
Suitable Substrates & Preparation	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 903 chromate-free etch primer	
Thinning ratio (by volume)	5 parts 213 Plus Primer 1 part 05-46 Thinner (dependent on application equipment)		
Spraying viscosity	25 - 30 seconds ISO Cup4 @ 20°C		
Spraying equipment	<i>Spray Gun</i>	<i>Fluid tip size</i>	<i>Working pressure</i>
	Conventional Suction feed HVLP Pressure pot HVLP Airless Air Assisted Airless	1.6 – 1.8 mm 2.3mm 1.4mm 11 – 15 thou 13 thou	3.5 – 4.2 bar 0.7 bar (max) 0.7 bar (max)
	Electrostatic	Thin to equipment manufacturers recommended resistivity using Cromadex Electrostatic Thinner	
Approved thickness	40 - 80 microns DFT		95 - 190 microns WFT
Volume Solids	45 - 47% (Dependent on colour)		

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FOR PROFESSIONAL USE ONLY
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Overcoatable with	Cromadex 222, 233 & 400 Topcoats ONLY			
Drying times Substrate temp	<u>Drying Times</u>		<u>Overcoating Times</u>	
	Touch Dry	Through Dry	Minimum	Maximum
20°C	15 mins	6 hours	25 mins	unlimited
35°C	10 mins	5 hours	15 mins	unlimited
Force drying	Flash-off for 10 – 15 mins, then 80°C for 30 mins			
Full properties	7 days			
Coverage	13 m ² /l @ 35 microns, assuming 100% transfer efficiency, dependent on colour			
Shelf Life	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.			
Colour	White (nr RAL 9016), Light Grey (nr RAL 7035), Dark Grey (nr RAL 7037), Red Oxide, Buff (nr RAL 1011) and Yellow.			
Gloss	N/A			
Properties	VOC		Specific Gravity	
	213 Plus Primer	458 - 464 g/l	1.45-1.49	
		(dependent on colour)	(dependent on colour)	
	05-46 Thinner	870 g/l	0.87	
	85-72 Thinner	870 g/l	0.87	
Electrostatic Thinner	850 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.