



## 903 PRIMER *Two Pack Chromate-Free Etch*

### PRODUCT DATA SHEET

- Chromate-Free** = **Helps to reduce health and safety concerns**
- Direct adhesion to aluminium, galvanised steel & stainless steel** = **Suitable for many different applications**
- Overcoatable with both wet paint and powder coatings** = **Universal product can help to reduce stockholding**
- Can be air dried or stoved** = **Suitable for most paintshops**

<b>Product &amp; Ancillaries</b>	903 2-Pack Chromate-Free Etch Primer 903 Acid Reducer No.1 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 & Stainless steel	Thoroughly abrade or peen blast to remove the surface oxide layer, degrease and apply the primer within 6 hours to prevent reoxidation. We advise that an adhesion test should be carried out prior to full production.	
<b>Mixing ratio (by volume)</b>	1 part 903 base 1 part 903 acid reducer		
<b>Spraying viscosity</b>	30 - 40 seconds ISO Cup4 @ 20°C		
<b>Pot life</b>	6 hours at 20°C		
<b>Spraying equipment</b>	<i>Spray Gun</i>	<i>Fluid tip size</i>	<i>Working pressure</i>
	Conventional Suction feed HVLP Pressure pot HVLP	1.0 - 1.8mm 1.0 - 1.8mm 1.0 - 1.8mm	3.5 - 4.2 bar 0.7 bar (max) 0.7 bar (max)
	Other Application Methods	Not suitable due to excessive film build	
<b>Approved thickness</b>	15 - 20 microns DFT		
<b>Volume Solids</b>	15.0% (mixed)		

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Issue 5: September 2010

<b>Overcoatable with</b>	All Cromadex General Industrial primers and topcoats except 902. Also can be overcoated with Interpon Powder Coatings. Please contact your local Cromadex centre for advice.			
<b>Drying times</b> <b>Substrate temp</b>	<b><u>Drying Times</u></b>		<b><u>Overcoating Times</u></b>	
	<b>Touch Dry</b>	<b>Through Dry</b>	<b>Minimum</b>	<b>Maximum</b>
<b>20°C</b>	10 mins	2 hours	15 mins	10 hours
<b>35°C</b>	5 mins	1 hour	10 mins	10 hours
	Note: This primer must be overcoated within the recommended interval. If this interval is exceeded then adhesion failure may occur			
<b>Coverage</b>	10 m <sup>2</sup> /l @ 15 microns (mixed), assuming 100% transfer efficiency			
<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>	Buff (nr BS 630)			
<b>Gloss</b>	Matt			
<b>Properties</b>	<b>VOC</b>	<b>Specific Gravity</b>		
<b>903 Primer</b>	595 g/l	1.19		
<b>903 Acid Reducer</b>	806 g/l	0.83		
<b>No.1 Thinner</b>	868 g/l	0.87		

**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.*