

STOKES TWIN PACK ZINC TETROXYCHROMATE ETCH PRIMER

Reference
IP053

Revision No
4

Revision Date
2 July 2002

Printed
15 January 2008

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WWW.RJSTOKES.CO.UK MANUFACTURERS OF INDUSTRIAL, DECORATIVE & POWDER COATINGS Est 1899
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<p>Properties and Uses</p>	<p>PROPERTIES This yellow twin pack etch primer is formulated to improve the adhesion of coatings which are normally difficult to apply to metals (i.e. aluminium, zinc, galvanised iron and light alloys). Protection against corrosion when stored in dry conditions is good but not recommended to be left outside before finishing.</p> <p>USES This primer is suitable for use as a temporary rust preventative coating on metal fabrications etc. which are finished but awaiting assembly. The metal should be thoroughly cleaned and free from grease or moisture but there is no need to abrade the surface prior to painting. This primer is suitable for use with most air drying and stoving paints.</p>
<p>Technical Data</p>	<p>TYPE Two Pack Zinc Tetraoxychromate Etch Primer is supplied as a Base and an Acid Activator.</p> <p>DRYING TIME Surface dry within 10 - 15 minutes to BS3900 Part C2. It can be overcoated after a period of 1 hour air drying.</p> <p>THEORETICAL SPREADING CAPACITY Approximately 6 square metres per litre on smooth non-porous surfaces to achieve a dry film thickness of 13 microns. This etch primer should be applied as a very thin film, it is not formulated to produce complete obliteration at 13 microns.</p> <p>FLASH POINT Below 21°C HIGHLY FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT By volume: 7% nominal. By weight: 15% nominal.</p> <p>THINNERS AND CLEANING SOLVENT Stokes Cellulose Thinners TH001.</p> <p>HEAT RESISTANCE Up to 150°C.</p> <p>LEAD CONTENT Contains no added lead.</p> <p>COLOUR RANGE Yellow only.</p>
<p>Stock Container Sizes</p>	<p>Base supplied as 2.5 litres in 5 litre tins. Acid activator supplied as 2.5 litres in 2.5 litre polythene bottles.</p>

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<p>Processes</p>	<p>PREPARATION The surface to be painted must be clean, dry and free from grease, dust, dirt, rust, peeling or loose material or any other contamination. Etch primers should not be sprayed in conditions of high relative humidity, as this type of primer is sensitive to water. Being sensitive to water it is advisable to proceed with finishing coats as soon as possible. The etch primer has no surface filling properties and will not conceal any imperfections in metal surfaces. It is essential that when applying this primer a continuous film of paint is applied in order to provide a satisfactory metal pre-treatment and thus promote the adhesion of further finishing coats to the whole of the surface. Best results are obtained by spray application of a `wet` coat of this primer, if a `dry` spray technique is attempted the adhesion of the primer will be inferior. On no account should the primer be rubbed down prior to further painting.</p> <p>FINISHING. Most types of paint can be applied over Stokes Twin Pack Etch Primer including, Quick Air Drying, Chlorinated Rubber, Cellulose, Stoving Enamels, Epoxies and Decorative Paints.</p> <p>NOTE: This material is supplied as two separate components which are to be mixed together immediately before use. The mixing proportions are one part by volume of Base : one part by volume of Acid Activator. Ensure that the Base is thoroughly stirred before mixing with the Acid Activator. The mixed material should be allowed to stand for approx. 20 - 30 minutes before use and then used within 8 hours. Any unused mixed material should be discarded at the end of this period.</p>
<p>Application</p>	<p>BRUSH Only one coat of this primer must be applied. Because of the fast drying nature of this primer only small areas /items can be coated in this manner.</p> <p>ROLLER Not recommended for this method of application.</p> <p>DIPPING Not practical because of its short pot life.</p> <p>CONVENTIONAL SPRAY Only one thin coat of this must be applied. Do not attempt to dry spray this primer otherwise satisfactory etching of the metal will not occur.</p> <p>AIRLESS SPRAY Only one thin coat of this must be applied. (See comments regarding dry spray under Conventional Spray heading).</p> <p>ELECTROSTATIC SPRAY This primer contains a large proportion of polar solvents and is unlikely to be satisfactory for use through hand guns. NOTE: For further advice refer to Stokes Technical Service Dept.</p>
<p>Storage</p>	<p>Use within 6 months of delivery. Keep in original containers until required for use. Partly used containers should be re-sealed securely and stored according to the recommended manner. (See section 7 of Stokes Material Safety Data Sheet Ref. TPEP).</p>
<p>Health and Safety</p>	<p>THIS MATERIAL IS HIGHLY FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. TPEP FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROL / PERSONAL PROTECTION AND DISPOSAL.</p>



TECHNICAL DATA SHEET

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Disclaimer

The above information is for guidance only. It is given in good faith but without warranty. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.

This Data Sheet supercedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond the control of R.J.Stokes & Co Ltd. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.

R.J.Stokes & Co. Ltd. employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.