



404 N/S Primer / Undercoat

PRODUCT DESCRIPTION

404NS Protec Zinc Phosphate Primer / Undercoat is a single pack, high build alkyd resin based primer with zinc phosphate anticorrosive pigments to maximize corrosion protection. It is a relatively fast drying primer with excellent durability. It is recoatable within 1 hour as a "wet on wet" application and does not need to be sanded to give excellent topcoat adhesion and gloss holdout. It can be topcoated with alkyd enamels and 2-pack topcoats.

SUBSTRATES & PREPARATION

404NS Protec Primer / Undercoat can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE

Bare steel

PREPARATION

Startline® P150 - dry

Do not use directly over zinc coated substrates or galvanised steel.

VIN Vinyl etch or EPS EchPro must be used over Zinc coated steel and Aluminium first before 404 N/S

Surfaces showing heavy scale or surface rust should be treated with 971-9119 Protec Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 Protec Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

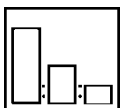
Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

PRODUCTS

CPC 404 NS Primer / Undercoat 404-6291 Grey

Protec Reducers *All conditions* AER30 Enamel Slow Reducer

MIXING RATIO BY VOLUME



PRODUCT

404NS Primer / Undercoat

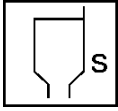
Protec Reducer

PARTS

100

10 - 20%

SPRAY VISCOSITY



20 - 25 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY 1.8 mm - 2.2 mm
- SUCTION 1.8 mm - 2.2 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)
- HVLP / RP 2 - 3 bar

APPLICATION & FLASH OFF



Apply 2 - 3 wet, even coats

Allow 5 - 10 minutes flash off between coats at 25°C

DRYING TIMES



AIR DRY (25°C)

- DUST FREE: 10 - 15 minutes
- TOUCH DRY 30 minutes
- WET ON WET: 1 hour
- HARD DRY: Overnight - (must be sanded after 16 hours)



Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied.

RECOAT

Allow 1 hour drying before recoating as a wet on wet primer. In cooler conditions and depending on film build, a longer re-coating period may be necessary. After 16 hours drying the primer must be sanded prior to topcoat application. 404NS Primer / Surfacer can be re-coated with RDE Rapid Dry Enamel, ACE Acrynamel, PET Performance Enamel Topcoat, Paraglaze DG and 625 Polythane.

Not recommended for top coating with lacquers.

TOTAL DRY FILM BUILD

40 - 60 µm

TECHNICAL PARAMETERS

| | |
|------------------------------|---|
| VOLUME SOLIDS | 37% |
| COVERAGE | 8-11 metres squared per litre (m ² /L) |
| RESISTANCE PROPERTIES | |
| WEATHERING | Poor |
| ABRASION | Good |
| SOLVENT | Fair |
| CHEMICAL | Fair |
| HEAT | Satisfactory up to 120°C Dry Heat |
| IMMERSION | Not recommended |

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. 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.

Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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