

TECHNICAL DATA SHEET

ICI-PU-PRIMER Chromatefree
F 566-4200(LAB 310144), RAL1014 ivory

1. GENERAL INFORMATION

- 1.1 Material Performance Sheet : WL 5.7140, DOL 63
- 1.2 Identification No. DIN 9368 Part 7 : 5024
- 1.3 Technical delivery conditions and/or specification :
- 1.4 Vehicle basis : Polyurethane
- 1.5 Field of Application: Primer chromate free for moulded parts made out of fibre synthetic material for the interior and exterior parts of aircrafts. Topcoats:
Topcoat: 2-Pack-Polyurethane paints as well as PU-Antistatic-Paints.
On Aluminium alloy it is used over ICI-Washprimer N54628/..... with a Polyurethane-Topcoat.

2. TECHNICAL DATA FOR THE LIQUID COATING

- 2.1 Activator Reference : N 39/1327 as per WL 5.7052
- 2.2 Mixing Ratio : 5 : 1 by weight
- 2.3 Pre-reaction time : 15 minutes
- 2.4 Pot Life : 16 hours/+ 5 degree C.
: 8 hours/+ 23 degree C.
- 2.5 Thinner Reference : 8502-0013 or N 39/3091
- 2.6 Supply Viscosity (DIN 53211) : thixotropic
- 2.7 Density (DIN 53217) : ca. 1,4 g/cm³
- 2.8 Weight Solids (DIN 53216) : 66 % (approximately) (1)
- 2.9 Volume Solids (DIN 53219) : 52 % (approximately) (1)
- 2.10 Theoretical Coverage : 17 m²/l at 30 microns (1)
- 2.11 Shelf life : at least 12 months
- 2.12 Storage Temperature : max +35°C

(1) This data refers to the mixture (base paint plus hardener)

3. SAFETY DATA

See Safety Data Sheet

7. TECHNICAL DATA ON DRY FILM

- 7.1 Colour : RAL 1014, ivory
7.2 Surface Gloss (DIN 67530) :
Surface Gloss Reading :
7.3 Dry Film Thickness : 25 - 35 microns
7.4 Dry Film Weight : 51 g/m² at 30 microns film thickness
7.5 Special Properties : Temperature resistant from -55 degree
to +120 degree C., up to +150 degree C
for a short period; resistant to
condensed moisture and synthetic
hydraulic liquid, e.g. Skydrol 500 B.

All information is given in good faith but users must satisfy themselves that there are no circumstances requiring additional information or precautions or the verification of details given herein.

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4. SURFACE TREATMENT

Composites: Remove mould release agents with MEK or other suitable solvents. If necessary, light sanding or scotchbrite or other appropriate abrasives plus solvent cleaning.

If Primer is used over Washprimer no specific treatment is required.

5. APPLICATION ACC. TO DIN29597 - APPLICATION GUIDELINES FOR COATINGS OR OTHER SPECIFICATIONS

- 5.1 Brushing : limited (for repair)
- 5.2 Rolling :
- 5.3 Dipping :
- 5.4 Conventional Spraying : yes
 - Thinner : 8502-0013 or N 39/3091 (ca. 40-50 %)*
 - Spray Viscosity (DIN 53211): 14 - 18 sec./4 mm
 - (ISO 2431): 86 - 92 sec./3 mm
 - Nozzle Diameter : 1,2 - 1,5 mm
 - Spraying Pressure : 3 - 5 bar
- * add thinner only after prereaction time.
- 5.5 Airless spraying or spraying at highest pressure: yes
 - Thinner : 8502-0013 (short) or N 39/3091 (long)
 - Spray Viscosity (DIN 53211): 20 - 22 sec./4 mm
 - (ISO 2431): 160 - 170 sec./3 mm
 - Nozzle Diameter : 0,28 mm
 - Spraying pressure : 120 - 150 bar
- 5.6 Electrostatic spraying : yes

All information of paragraph 5 (application) can be used as a guideline only and need to be confirmed.

6. DRYING TIMES ACC. TO DIN 65046 PART 4 TEST PROCEDURES FOR SURFACE PROTECTION - OR ACC. TO DIN 53150

- 6.1 Dust Free : 30 minutes minimum
- 6.2 Tack Free : 6 hours minimum
- 6.3 Recoatable : 6 hours minimum, 72 hours maximum
- 6.4 Transportable : 24 hours minimum
- 6.5 Fully cured : 7 days minimum
- 6.6 Force Drying : 30 minutes/80 degree C.
- *Flash off period : 20 minutes

The information in 6.1 to 6.5 refers to normal climate 23/50 according to DIN 50014.