

TECHNICAL INFORMATION

Date drafted:
07.12.2021



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23.06.2023

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Modular Industrial Line **Product name: Polyurethane primer for wet-on-wet** **working or sanding** **APP Primer PUR 30-630 Grey WoW 5:1. APP No.: 0276631.**

Fast-drying, two-component polyurethane primer available in matt grey. Intended for priming surfaces made of any metal, such as: iron, steel, galvanised steel, aluminium and for covering without grinding with any topcoat from the APP Modular Industrial Line system.

Product and accessories. APP Primer PUR 30-630 Grey WoW,
APP Hardener PUR 30-710,
APP Thinner Universal 30-810.

Basic ingredients. APP Primer PUR 30-630 Grey WoW – polyurethane-acrylic binder and additives,
APP Hardener PUR 30-710 – isocyanate hardener:
fast/FAST, standard/STANDARD, and slow/SLOW
APP Thinner Universal 30-810 – universal thinner.

Colour. Grey.

Surface texture. Smooth.

Gloss. Matt.

Specific weight. 1.5 kg/L at 20°C

Binder solids content. 65-69% (by weight)
39-44% (by volume)

Solids content of ready-to-use primer without thinner. 65-70% (by weight)
42-47% (by volume)

Theoretical efficiency. For binder:
• 440-640 m²/L for 1 µm dry layer.
For ready-to-use primer without thinner:
• 425-475 m²/L for 1 µm dry layer.

Note!

In practice, efficiency depends on factors, such as the shape of the object, the roughness of the substrate, the application method and the working conditions.

The above information is in line with the current state of knowledge of our products and their possible applications. This does not guarantee specific properties or suitability for use under specific conditions. Follow the notes and warnings on the product labels and on the safety data sheet. We assume no liability if the final result of the work was influenced by factors beyond our control.

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Corrosion protection class according to ISO 12944.

For (100µm + +45µm): APP Primer PUR 30-630 Grey WoW + APP Lack AY/PUR 30-200 Gloss:

- for corrosion class C3 durability L (> 7 years).

Application.

Designed for priming commercial vehicles, tractor frames and trailers, agricultural machinery, tanks, machine parts and steel structures.

Advantages

- Direct adhesion to iron, steel, galvanised steel, cast iron, aluminium.
- Can be applied by air, hydrodynamic and mixed spraying systems, as well as electrostatically.
- Can be coated with any APP system topcoat.

Substrate

Direct adhesion to iron, steel, galvanised steel and aluminium. Pre-sanded factory coatings.

Substrate preparation.

Steel.



- Blasting treatment to a cleanliness grade of Sa 2½.
- Manual cleaning to St 3.

The treated surface should be free of rust, scale, oil, grease, loose old coating, dust and other contaminants. It should have a uniform metallic sheen.

Galvanised steel and aluminium.

- Dry sand with P150-P240 abrasive paper.
- Very gentle blasting treatment.



Existing finishes.

- Dry sand with P120-P180 abrasive paper

Before spraying APP Primer PUR 30-630 Grey WoW, clean the surface to be primed of dust and degrease with APP WB910 or APP W900 remover using APP Standard CT cleaner.

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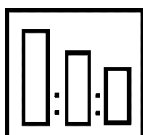
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Application

Mixing ratios.

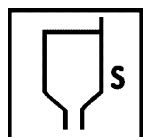


Mixing ratios by volume:

5 volumes APP Primer PUR 30-630 Grey WoW.

1 volume APP Hardener PUR 30-710.

0-20% APP Thinner Universal 30-810.



Spray viscosity at +20°C: 25-30 s F/4.

Note!

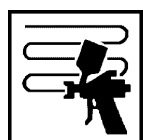
Use only APP Hardener PUR 30-710.

Do not exceed the recommended hardener amount.

Application.

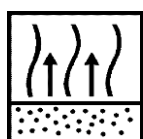


Apply with a spray gun equipped with a $\varnothing 1.6$ - $\varnothing 1.8$ mm nozzle at an air pressure of 2.0 to 3.0 bar.



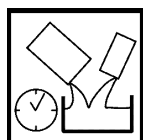
Number of layers: 2 x 1.

Dry coating thickness: 100 μm .



Evaporation time between coats at +20°C:

- 3-5 minutes.



Shelf life of ready-to-use paint mixture:

- 5 hours.

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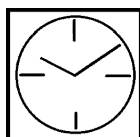


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Drying.



At +20°C:

Time to coat without sanding: from 30-45 min to max 7 days
After curing, machine dry sand with P320-P400.

At +60°C:

Time to coat without sanding: 30 min.

The coating achieves its full performance properties after a seasoning period, i.e. after 10 to 15 days at 18-22°C.

Coverability

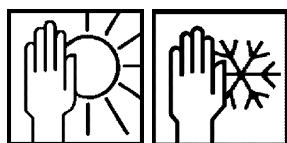
Intended for coating with any topcoat from the APP Modular Industrial Line system.

When completely dry, requires sanding with P320-P400.

Equipment cleaning.

Nitrocellulose, PUR or acrylic solvent.

Storage



Store in closed original packaging in a dry and well-ventilated room, at +5°C to + 30°C.

Protect from frost and direct sunlight.

OHS regulations



For professional use only.

See text on product labels or SDS.

The user must comply with the OHS regulations in force in the country concerned.

VOC

VOC in g/L: 2004/42/EC – II A (j) (500)

Permissible VOC content in g/L in the ready-to-use product:

500 g/L for APP Primer PUR 30-630 Grey WoW.

Maximum VOC content in g/L in the ready-to-use product:

>500 g/L for APP Primer PUR 30-630 Grey WoW.

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