

Farmline Primer

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Reference: UG
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Product Description	A single pack alkyd primer/undercoat for agricultural equipment and vehicle exteriors.				
Features & Use	<ul style="list-style-type: none"> • Tough and durable primer with good adhesion and mechanical properties • For application to agricultural plant, machinery and steelwork • Use with Farm Oxide Sheen or Farmline finishes • For brush or spray application 				
Approvals/ Certification	Conforms to Category (i) of Directive 2004/42/EC which has a VOC limit of 500 gm/ltr				
Finish	Matt				
Volume Solids	50 ± 2% (varies with colour)				
VOC Content	295 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Typical	40 µm	80 µm	12.5 m ² /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
Drying Times	Applied to 40 microns DFT	+10°C	+23°C	+35°C	
	Dust Free	2½ hr	1½ hr	1 hr	
	Hard Dry	6 hr	4 hr	3 hr	
	Overcoating	Minimum	18 hr	16 hr	14 hr
		Maximum	Indefinite (see product Notes)		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
Colours	Red Oxide, Grey, Buff, Black				
Product Code	04FAP				
SG	1.42 kg/ltr (varies with colour)				
Storage Conditions	Store in dry, cool conditions and protect from frost				
Shelf Life	Minimum 12 months if stored as above in unopened containers				
Flash Point	23-60°C				



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Surface Preparation	<ul style="list-style-type: none"> All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams The surface should ideally be prepared to standard St2 of ISO 8501-1:2007 (thorough wire brushing/scraping/abrading) taking care to avoid 'polishing' the steel surface 														
Mixing	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.														
Thinner / Cleaner	Axalta Thinner TH400 (formerly called No.3 Thinner)														
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.														
Application Methods	<table border="1"> <thead> <tr> <th data-bbox="464 875 687 954">Method</th> <th data-bbox="687 875 936 954">Airless Spray</th> <th data-bbox="936 875 1184 954">Conventional Spray</th> <th data-bbox="1184 875 1355 954">Brush</th> <th data-bbox="1355 875 1503 954">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="464 954 687 1003"></td> <td data-bbox="687 954 936 1003">Yes</td> <td data-bbox="936 954 1184 1003">Yes</td> <td data-bbox="1184 954 1355 1003">Yes</td> <td data-bbox="1355 954 1503 1003">No</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	No
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	Yes	Yes	Yes	No											
<ul style="list-style-type: none"> Brush application is recommended – use as supplied. Roller application is not recommended, as film build and surface penetration is likely to be less than by brush For spray application, first consult the product Safety Data Sheet (SDS) and ensure compliance with all safety requirements Conventional spray: use up to 10% of TH400 Thinner with 40-60 psi pressure and 1.4 - 1.8mm nozzle Airless spray: thin up to 5% with TH400 Thinner and use 2000-2500 psi pressure and 11-17 thou tip (0.28-0.43mm) 															
Product Notes	<ul style="list-style-type: none"> This product is white spirit based, only overcoat with other white spirit based products - Farm Oxide Sheen (low-gloss) and Farmline (gloss) finishes are recommended Overcoating – maximum overcoating time is indefinite if clean and sound, but for best results overcoating within 48 hours is recommended (at 20°C) 2 coats of primer are recommended over bare steel for best results before applying topcoats 														
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.														

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