

## PROTEGATHERM SD-W

**DESCRIPTION** Compliant, waterborne stoving primer and one coat finish.

**PRODUCT FEATURES AND RECOMMENDED USES**

- ◆ Excellent metal adhesion.
- ◆ Designed for use in the general industrial and automotive markets.
- ◆ Compliant – below 350 gms/ltr VOC (minus water).
- ◆ Can be sprayed or dipped

### TECHNICAL DATA

**Volume solids** 35 ± 5% (ISO 3233) depending on colour.

**Weight solids** 40 - 60% depending on colour.

**Viscosity** 50 – 100 seconds BSB4 @ 25°C depending on colour.

**Specific gravity** 1.05 – 1.30 depending on colour.

**pH** 7.8 – 8.8

**Product code** Existing colours : 3897 series  
New colours : 3841 (SD20-W), 3842 (SD50-W), 3843 (SD90-W).

**Recommended film thicknesses and theoretical coverage**

Recommended film thicknesses		Theoretical coverage
dry	wet	
5 µm	17 µm	66.0 m <sup>2</sup> /l
20 µm	60 µm	16.5 m <sup>2</sup> /l

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated.

**Drying time**

@ 10 µm DFT	+ 23°C
Flash off time	10 - 15 minutes
Curing	10 - 15 minutes @ 150 – 170°C

Drying times and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation.

**Finish** Low gloss (SD20-W), Semi-gloss (SD50-W), High gloss (SD90-W).

**Colours** White, Grey, Black and RAL shades available.

## PROTEGATHERM SD-W

### APPLICATION DETAILS

<b>Surface preparation</b>	<p>Preliminary cleaning: remove oil grease with a suitable detergent. Remove salt and other contaminants by fresh water cleaning and allow to dry (ISO 12944-4). Pre-treatment improves adhesion and reduces corrosion under the paint film. The type of pre-treatment depends on the requirements for corrosion protection e.g.</p> <ol style="list-style-type: none"><li>1. Zinc phosphate with Cr-VI passivation.</li><li>2. Iron phosphate with demineralised water rinsing (insufficient rinsing can lead to the osmotic formation of bubbles).</li></ol>
<b>Application conditions</b>	<p>Only apply in conditions of good ventilation which must be maintained during drying. 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 ambient temperature should be above 10°C and the Relative Humidity should not exceed 80%. The steel temperature should remain at least 3°C above the dew point.</p>
<b>Mixing</b>	<p>Mix thoroughly before use.</p>
<b>Application</b>	<p>Dip with a viscosity of 29 – 40" BSB3 @25°C; Spray 35-65" BSB4 Cup</p>
<b>Thinner</b>	<p>Demineralised water (50 micro siemens or less ).</p>
<b>Cleaning of equipment</b>	<p>Remove remaining paint from equipment and rinse thoroughly with water. Repeat if necessary and rinse with cleaner for water borne paints reference ProtegaClean 1921.</p>
<b>FLASH POINT</b>	<p>Above 55°C</p>
<b>STORAGE</b>	<p>Store in dry, cool conditions and protect from frost.</p>
<b>VOC</b>	<p>Below 350 gm/lit (minus water basis), varies considerably with colour, please consult Protega Coatings for specific advice.</p>
<b>HEALTH AND SAFETY</b>	<p>Containers are provided with safety labels, which should be observed. Further information about hazardous influences and protection are detailed in individual health and safety data sheets. A health and safety data sheet is available on request from Protega Coatings Ltd.</p>