TECHNICAL DATA SHEET

Writing up: September 2021 Printed: 01/06/2023

Voc Compliant

Line:	Primer Products	Type:	Polyester universal primers for metals
Category:	2k primers	Code:	1050.01 (Grey); 1050.03 (Beige); 1050.04 (White)

Name or commercial logo: **F33**

Nature: chemical paste with a base of inert mineral fillers and additives dispersed in unsaturated polyester resins and solvents; low emission of VOC. Light specific weight. It polymerizes through cyclohexanone peroxide paste in concentration between 1% and 3% w.p. according to the environmental temperature.

Use: coating intended to be applied for the first coat as spray filling primer before the application of the primer. Directly available on iron, steel and aluminium sheets, on reinforced resins by glass fiber (UP-GF) artifacts, on polyester fillers and on any kind of rust-proof primers except for wash-primers composed by acids hardeners and single component primers containing synthetic resins. Adhesion is not ensured if applied directly on galvanized sheets. In this case, use anchoring primer except for those listed above. If applied on old paint, make sure that they are completely dried and that they are not of acrylic thermosetting or elastic natured.

Peculiarities:
- high filling capacity, high flexibility and thixotropy, it is especially suitable for applications on surfaces subjected at strong vibrations, such as foundations of machineries, side of railways wagons, coaches, trucks, tankers, caravans, trailers, campers, vehicles, insulated vehicles, containers…
- it is an excellent support for acrylic or polyurethane in cycles of wet on wet painting;
- it can be diluted up to 5% with proper diluent our type D/Fp, in order to mitigate the peel effect on the second coat;
- it is compatible with water-based coats.

Physical features

Aspect:	Dense liquid	Supply viscosity:	28,5 Pa*s (Brookfield: RV 5, rpm 5)
Color:	Grey, Beige, White	Dry residue (mix A+B):	76% (±2%)
Odour:	Typical of styrene	Theoretical yield (mix A+B):	5,3 m²/l per 100 µm
Specific weight:	1,570 kg/l (± 0,030 kg/l)		

Directive 204/42/CE:	all. II B/c - Primer, Surfacer/filler and general (metal) primer, maximum VOC content limit value expressed in g/l (ready for use product 1.1.2007):	540
	F33 ready for use (+3% w.p. L/F hardener, +5% w.p. D/Fp diluent) VOC expressed in g/l:	248

Applicative data

	Roughen out the part to be worked with sand paper grain P 100. Then eliminate any trace of grease, oils, silicone, fingerprints, glues, detaching wax (over UP-GF) and dust by mean of an antisilicones thinner for washing (our type NOSIL SN/184). If applied on old varnishes roughen up with sand paper grain P 320.		
A + B	F33 primer: 100 g L/F hardener: 3 g D/Fp thinner: 0-5 g		Mix in homogeneous way primer, hardener and eventual diluent, then put into the airbrush cup.
A+B	Pot life a 23 °C: 20’	S	Application viscosity: Ford Cup Ø 8 at 23 °C: 35”
	Type / Ø nozzle / Pressure Standard: 2 - 2,5 / 2,5 - 3,0 bar		1 light coat (to anchor) then 2 full crossed coats. Advised thickness: max 800 µm.
	Dust free at 23 °C: 35’		Ready for sanding at 23 °C: 150’ - 180’ according to the applied thickness. Ready for sanding at 60 °C: 35’ - 45’ according to the applied thickness.
IR	Short waves, ready for sanding according to the applied thickness: 10’ - 12’		Total desiccation at 23 °C: 36 h
	Roughing out P 120 Middle stage P 220 Border finishing P 320	Roughing out P 150 Middle stage P 240 Border finishing P 360	Not recommended.
	The product lifetime is 12 months from delivery date, if the product is stored in a dry place at temperature between 10 °C and 35 °C, in unopened original containers, away from flames and sparks, according to general sales conditions.		

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Warnings & Precautions

- Read carefully the Safety Data Sheet before use;
- Product specifically for PROFESSIONAL USE;
- The mix F33 + hardener L/F doesn't like humidity; do not practice wet sanding; avoid the direct contact between primers surface and water-based products;
- It is not recommended the dilution with nitro, acrylic or polyurethane compounds: the possibility of the presence of water in this compounds may cause crackings on the final surface;
- Do not apply the filler on cold supports (< 10 °C), its sticking power and drying times would be compromised;
- Do not put residue from the A+B mix back into the container of the filler, the content would harden.

Consumer information:

The information here contained are based on our knowledge at the moment. We reserve the right to make changes in the characteristic data of the product in relation with technological progress or productive developments. Due to factors beyond our control in the applicative phase of the product, the information here contained are not a form of guarantee for specific qualities of the product itself, nor its suitability for a specific application. If a responsibility is determined, this will be limited to the value of the provided products used by the consumer. We guarantee however the constancy in the quality of our products. Our responsibility concerns only the area of the General Sales Conditions. This Technical Data Sheet supersedes all the previous.

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