








**TECHNICAL DATA SHEET (TDS)**

Jun 2019

<b>Product Name:</b>	Metalact H-15 (Etching Primer)																									
<b>Description:</b>	A 2 Component Long Exposure Type "Wash Primer" Based On Vinyl Butyral Resin With Phosphoric Acid Additive																									
<b>Recommended Uses:</b>	As A Pretreatment Primer For Both Ferrous And Non Ferrous Metal: <ul style="list-style-type: none"> <li>• Galvanized Iron</li> <li>• Aluminum</li> <li>• Steel</li> <li>• Zinc</li> </ul>																									
<b>Performances:</b>	<ul style="list-style-type: none"> <li>• Good Adhesion To Substrates</li> <li>• Fast Drying</li> <li>• Excellent Compatibility With Subsequent Coats</li> <li>• Good Gas Cutting And Welding Properties</li> </ul>																									
<b>Physical Properties:</b>																										
<b>Volume Solids:</b>	28%																									
<b>Theoretical Coverage:</b>	5.98 - 8.0 m <sup>2</sup> / Litre @ 15-20 Micron DFT																									
<b>Type:</b>	Two Component (Base: Additive 3.2K : 0.8K)																									
<b>Packing Ratio:</b>	None																									
<b>Colour Availability:</b>	Dark Green																									
<b>Flash Point:</b>	24°C																									
<b>Recommended Thickness:</b>	10 - 15 Microns DFT																									
<b>Recommended Thinner:</b>	Thinner 810-0251																									
<b>Practical Application:</b>		Airless Spray	Conventional Spray	Brush Roller																						
<b>Rates - Microns Per Coat</b>	Dry	10 - 15	10 - 15	10 - 15																						
	Wet	50 - 60	50 - 60	50 - 60																						
<b>Average Drying Time</b>	<table border="1"> <tr> <th rowspan="2">Ambient Temp</th><th rowspan="2">Touch</th><th rowspan="2">Hard</th><th colspan="2">Overcoating Interval</th></tr> <tr> <th>Min.</th><th>Max.</th></tr> <tr> <td>15°C</td><td>20 mins</td><td>2 hours</td><td>2 hours</td><td>Indfinite</td></tr> <tr> <td>25°C</td><td>10 mins</td><td>1 hour</td><td>1 hour</td><td>Indfinite</td></tr> <tr> <td>35°C</td><td>5 mins</td><td>0.5 hour</td><td>0.5 hour</td><td>Indfinite</td></tr> </table>				Ambient Temp	Touch	Hard	Overcoating Interval		Min.	Max.	15°C	20 mins	2 hours	2 hours	Indfinite	25°C	10 mins	1 hour	1 hour	Indfinite	35°C	5 mins	0.5 hour	0.5 hour	Indfinite
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<b>Packing</b>	4 Kgs																									
<b>Shelf life</b>	24 Months Under Normal Condition																									
<b>Surface Preparation</b>	<u>Non Ferrous Metals</u> Remove All Wax, Oil And Grease By Solvent Cleaning In Accordance With The Guideline Given By Spcc-Sp1. A Dry Abrasion Using Abrasive Paper Will Improve Subsequent Adhesion And Ensure Removal Of All Surface Contaminates. The Surface To Be Coated Must Also Be Clean And Dry.																									

<b>Surface Preparation</b>	<p><u>Galvanised Steel Or Zinc Metal Spray</u></p> <p>Ensure That Only White Zinc And Other Surface Contaminants Are Removed By Abrading With Abrasive Paper Or Suitable Mechanical Tools. Remove All Wax, Oil And Grease By Solvent Cleaning In Accordance With The Guideline Given By Spcc-Sp1. The Surface To Be Coated Must Also Be Clean And Dry.</p>
<b>Application Data</b> <b>Application Methods</b> <b>Mixing Ratio (By Volume)</b> <b>Thinner</b> <b>Thinner Consumption</b>  <b>Airless Spray</b>  <b>Conventional Spray</b>  <b>Brush Roller</b>	<p>Brush / Roller, Conventional Spray and Airless Spray</p> <p>None</p> <p>810-0251</p> <p>Brush / Roller - 5%</p> <p>Conventional Spray - 5 - 10%</p> <p>Airless Spray - 0.5%</p> <p>Nozzle Size: 0.33 - 0.43mm (13 - 17 thou)</p> <p>Fan Angle: 40°</p> <p>Operating Pressure: 110 - 150 kg/cm<sup>2</sup> (1600 - 2100 psi)</p> <p>Nozzle Size: 1.27mm (50 thou)</p> <p>Atomising F 3.5 kg/cm<sup>2</sup> (50 psi)</p> <p>Fluid Pressure: 0.7 - 1.0 kg/cm<sup>2</sup> (10 - 15 psi)</p> <p>This product is suitable for brush application</p> <p>This product is suitable for roller application</p> <div style="display: flex; justify-content: space-around; align-items: center;">    </div> <div style="display: flex; justify-content: space-around; align-items: center; font-size: small;"> <span>Application method</span> <span>45° spraying tip</span> <span>Practice proper cleaning</span> </div>
<b>Application Conditions And Overcoating</b>	<p>This product should preferably be applied at temp. in excess of 10°C. In conditions of high humidity i.e. 80-85%, good ventilation conditions are essential. Substrate temp. should be at least 3°C above the dew point.</p> <p>At application temp below 10°C, drying and curing time will be significantly impaired.</p> <p>All application below 5°C is not recommended.</p> <p>If it is desired to overcoat outside the times stated on the data sheet, please seek advice from KPS representative.</p>
<b>Health And Safety</b>	<p>Consult chemical safety Data Sheet for information on safe handling and application of this product.</p> <div style="display: flex; justify-content: space-around; align-items: center;">     </div> <div style="display: flex; justify-content: space-around; align-items: center; font-size: small;"> <span>Keep seal tight</span> <span>Secure upright</span> <span>Wear proper protection</span> <span>Practice proper disposal</span> </div> <p>For Any Further Information On Product Data, Kindly Contact:</p> <p>Kansai Paint (Singapore) Pte Ltd</p> <p>2 Tanjong Penjuru Singapore 609017</p> <p>Telephone: 6264 0779 / Fax: 6264 0730</p> <p>Email: enquiry@kps.sg</p>