

Centrecoat Protect Cladding Primer / Finish

Key Features

- ◆ Formulated for outstanding adhesion
- ◆ Excellent coating flexibility and durability
- ◆ Zinc phosphate anti-corrosive pigmentation
- ◆ High Build for easy application
- ◆ Quick drying for minimum downtime
- ◆ Gives a long life to first maintenance

Colours

Available in a wide range of colours including most British Standard and RAL Shades. Corporate, bespoke and other shades available by arrangement. Some colours contain lead chromate so please state when ordering if lead free pigmentation is required.

Typical Uses

- ◆ Application through most types of spray equipment
- ◆ Steel fabrications
- ◆ Galvanised surfaces including hot dip-galvanised
- ◆ Plastisol Coating
- ◆ Glass

Packaging

5 litres and 20 litres

Shelf Life

6 months in unopened containers when stored under cover within the temperature range 5 - 35 °C.

Technical

Gloss Level	Low Sheen	Flash Point	25 °C (BS EN ISO 3679 Closed Cup)
Volume Solids	32 ± 6% <i>(dependent on shade)</i>	V.O.C.	588 g/l ± 9% <i>(dependent on shade)</i>
Drying Times @ 20 °C	Touch dry 35 minutes Handle dry 4 hours Full Cure 7 days Care must be taken when stacking of coated articles to prevent blocking		(times are quoted at 20 °C and will vary with film thickness, air movement, temperature and humidity)

Application Guide

	<i>Airless/Airmix</i>	<i>Conventional/(H.V.L.P)</i>	<i>Brush/Roller</i>
Mixing ratio	Ready for use	Ready for use	Ready for use
Thinning	Ready for use	5 – 10% 003:000:9999	5 – 10% 019:000:9999
Tip sizes	13 – 17 thou	2.0 – 2.2 mm	N/A
Spray pressure	120 – 140 bar 1700 – 2000 psi	3 – 4 bar (1 – 2 bar) 40 – 60 psi (15 – 30 psi)	N/A
Pot life	Unlimited	Unlimited	Unlimited
Spray viscosity	N/A	N/A	N/A
Number of coats	1	2	Small areas only
W.F.T. per coat	235 microns	130 microns	Small areas only
Time between coats	N/A	15 mins	N/A
Overall D.F.T.	75 microns	75 microns (2 coats)	Small areas only
Theoretical coverage	4.2 m ² /l	3.8 m ² /l	Small areas only

(practical coverage will be affected by surface profile, uneven application, overspray and losses in containers and equipment)

Spray equipment details given are intended as a guide only. Fluid hose length and diameter, paint temperature and job shape and size all have an effect on the spray tip and operating pressure chosen.

Health and Safety

See packaging label for relevant MSDS reference. Copies can be obtained by telephoning 01462 421333.

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Substrates

Steel Fabrications

Once the surfaces to be coated are clean, dry and free from all contamination, grind down any sharp edges and shot blast to Sa2½ (as defined in ISO 8501-1) with an average surface profile of at least 50 microns. As an alternative to shot blasting, mechanically prepare the surfaces to St3-C or St3-D (as defined in ISO 8501-1). Painting should then be carried out within four hours.

Galvanised Steel

Ensure the surfaces to be coated are clean, dry and free from oily residues and other contaminants. New, bright, galvanised steel may be oiled or chemically treated and this surface layer must be cleaned, degreased and tested by application of Mordant Solution – T Wash (028:000:9999) to a small area. If the area of application turns entirely black, paint can be applied directly to the metal. If the colour change is uneven or fails to occur, degrease and repeat the test. For further advice telephone us on 01246 857777.

Plastisol Coating

Thoroughly wash and allow to dry. Remove any remaining contamination with a suitable degreaser and wipe with clean cloth or disposable paper towel. Localised repairs or damage should be lightly sanded to remove loose or flaky material until a sound edge is achieved. There is a tendency for the plasticisers in the Plastisol Coating to migrate in to the paint film and become tacky. This effect can be minimised by application of 200:026: primer and allowing 30 mins drying time before proceeding.

Existing paintwork

Once the surfaces to be coated are clean, dry and free from all contamination, remove loose flaky paintwork back to a firm edge then lightly flat to give a smooth surface with an adequate key. Apply the material to a small test area to ensure there are no adverse reactions with the existing coating before painting can be carried out.

Application Process

Do not apply or dry when the air or substrate temperature is below 5 °C or in excess of 30 °C otherwise film appearance and coating properties may be adversely affected. Surface temperature must also be a minimum of 3 °C above dew point. Outdoors preparation, painting and drying should only be undertaken during good weather conditions and never when rain is imminent or on days when a drop in temperature could result in condensation forming on the paint during the initial drying period or overnight.

Mix thoroughly before use. Best results will be achieved using a power mixer.

Airless or airmix spray systems

Flush all lines with a compatible solvent before application to avoid 'throw out' and blocking of the filters. Using a brush to provide a 'strike coat' on difficult to reach areas such as internal welds, rough spots, bolts or corners before application of the spray coat is a good method of ensuring adequate build is achieved. One even coat applied in parallel passes, overlapping 50% on each pass to avoid bare areas, pinholes or holidays, at the stated W.F.T. is satisfactory for most purposes. However, should additional coats be required for higher film builds or blast cleaned profiles these should be applied after 15 minutes or when the film is touch dry.

Conventional or H.V.L.P. spray systems

Add thinner as required to achieve the correct atomisation but care should be taken not to over thin as this will greatly affect the performance and build of the material resulting in additional coats to achieve the required build. A full even coat should be applied in parallel passes, overlapping 50% on each pass.

Brush or Roller

Slight thinning may be required. Care should be taken not to over brush or lay-off the material. Best practice is to apply a generous even coat to a manageable area to help maintain a suitable wet edge. This material has limited capabilities when coating large areas or panels due to the speed of drying and is therefore recommended for small areas only. Subsequent coats of this material are not recommended by brush or roller application. However, should they be necessary allow the first coat to dry overnight to prevent possible reaction.

Overcoating

For spray application anytime under normal conditions of temperature and humidity. For brush application allow overnight drying between coats.

Cleaning

Clean all equipment immediately after use with 003:000:9999 thinner or 010:000:9999 Gunwash. Ensure all lines, tips, etc. are thoroughly flushed out. It is not sufficient to leave equipment filled up with thinner or Gunwash.

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Test Results

When used at an overall D.F.T. of 90 microns

Flexibility	Pass – 6 mm bend (test carried out in accordance with BS EN ISO 1519)
Scratch Resistance	Pass – 1200 g (test carried out in accordance with BS EN ISO 1518)

Conformity

ISO 12944-5-2018, Categories C2, C3 and C4 for Vinyl Chloride Copolymers (PVC) when used as part of a system.

Disclaimer

The foregoing information is given in good faith on the basis of practical experience and extensive laboratory tests. Quoted figures are either theoretical values or typical of production batches. However, as we have no control over the conditions of application or the quality and standard of preparation of the substrate and the many other factors affecting the use and application of the product, the customer must determine the suitability of the delivered product for the intended application. Therefore unless we specifically agree in writing to do so, we do not accept any liability whatsoever or howsoever arising for the performance of this product or for any loss or damage arising out of the use of the product, or its use in conjunction with other manufacturer's product(s). Stir the paint well before use and always check the shade as no responsibility for a colour complaint is accepted after application. The information in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous improvement. For professional use only.