



PRODUCT TYPE	A two component polyvinyl butyral, phosphoric acid etch primer, chromate free, beige.				
INTENDED USES	As a pretreatment primer for unpainted non-ferrous metals such as aluminium, copper, brass, cadmium, zinc and nickel. IL3503 may also be used for priming galvanised steel surfaces.				
PRACTICAL INFORMATION	Colour	Beige			
	Gloss Level	Matt			
	Volume Solids	15.7% (of mix)			
	Typical Thickness	6 microns (0.25 mils) dry, of mix, equivalent to 38 microns (1.5 mils) wet			
	Theoretical Coverage	26.2 m ² /litre at 6 microns d.f.t of mix and stated volume solids 1051 sq.ft/US gallon at 0.25 mils d.f.t and stated volume solids			
	Practical Coverage	Allow appropriate loss factors			
	Application Method	Air spray, Brush, Roller			
	Drying Time	Overcoating interval with recommended topcoats			
	Temperature	Touch Dry	Hard Dry	Minimum	Maximum
	10 ⁰ C (50 ⁰ F)	8 minutes	25 minutes	2 hours	24 hours
15 ⁰ C (59 ⁰ F)	6 minutes	20 minutes	1 hour	24 hours	
25 ⁰ C (77 ⁰ F)	4 minutes	15 minutes	1 hour	24 hours	
40 ⁰ C (104 ⁰ F)	2 minutes	10 minutes	1 hour	24 hours	
REGULATORY DATA	Flash Point	Base (Part A) -7 ⁰ C	Curing agent (Part B) 12 ⁰ C	Mixed -7 ⁰ C	
	Product Density	1.22 kg/l (10.2 lb/gal) for base IL3503 1.02 kg/l (8.5 lb/gal) for mix			
	VOC	698 g/l (5.82 lb/gal) of mix. ISO 11890			
SURFACE PREPARATION	All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504:2001.				
	The preferred method of treating most surfaces prior to application of Carrs Coatings Protective Coating systems is to brush blast or abrade following treatment as described above. When blast cleaning is employed, a low air pressure should be used with a fine grade of abrasive (80 mesh) and the nozzle held 1 metre from the surface.				
	Non-Ferrous Metals Oil or grease should be removed. Ensure surface is clean, dry and free from metal corrosion products.				
	When substrate is aluminium or light alloy, the surface should be solvent cleaned and then either etched chemically, or physically by light blast cleaning. It is important to follow application of L3503 with a paint system appropriate to the painting of aluminium.				
	Galvanised Steel				
	If the surface has not been subjected to hot phosphating before delivery to site, degrease and remove any white zinc corrosion products by hand abrasion cleaning.				
APPLICATION	Mixing	Material is supplied in two containers as a unit. Always mix in the proportions supplied. Once mixed, IL3503/IL3504 must be used within the working pot life specified. (1) Agitate IL3503 Base (Part A) with a power agitator. (2) Combine Base (Part A) and Curing Agent (Part B) and mix thoroughly.			

Mix Ratio	1 part of IL3503: 1 part IL3504 by volume			
Working Pot Life	10 ⁰ C 14 hours	15 ⁰ C 12 hours	25 ⁰ C 10 hours	40 ⁰ C 8 hours
Airless Spray	Not recommended			
Air Spray (Pressure Pot)	Suitable	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E	
Air Spray (Conventional)	Recommended	Use suitable proprietary equipment.		
Brush	Suitable	Care should be taken to avoid over application		
Roller	Not recommended			
Thinner	Not recommended			
Cleaner	Carrs Q thinners			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with Carrs Q thinners. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.			
Clean Up	Clean all equipment immediately after use with Carrs Q thinners. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays. All surplus materials and empty containers should be disposed of, in accordance with appropriate regional regulations/legislation.			

**PRODUCT
CHARACTERISTICS**

A complex reaction between the phosphoric acid and polyvinyl butyral occurs in this system and due to the low solids the product appears to have an exceptionally long pot life and can be liquid for a period of days. Do not exceed the working pot life times stated otherwise correct surface treatment will not be achieved.

Care must be taken to ensure surface to be treated is fully degreased otherwise good adhesion of IL3503, and subsequent topcoats, will not be achieved.

No attempt should be made to obliterate the surface, final appearance should be a pale yellow wash.

Dew or rain on this product while uncured may cause surface blush or browning and may impair its cure and adhesion of subsequent coats

Do not apply when relative humidity exceeds 90% or when condensation is likely to occur.

Excessive film thickness may lead to splitting of the film when overcoated with high build systems.

When applying IL3503 in confined spaces, ensure adequate ventilation.

Exposure to unacceptably low temperatures and/or high humidities during, or immediately after, application may result in incomplete cure and surface contamination that could jeopardise subsequent intercoat adhesion.

Over-application of coating systems, containing strong solvents, can dissolve up IL3503 causing adhesion loss when these coatings cure.

**SYSTEMS
COMPATIBILITY**

IL3503 has been designed for application as a primer for application to nonferrous metals and galvanised steel surfaces.

Always ensure sufficient dry film thickness of any subsequent topcoat systems has been applied in order to adequately protect substrate. Contact Carrs Coatings Ltd for further information on suitable

topcoat systems.

**SAFETY
PRECAUTIONS**

This product is intended for use only by professional applicators in industrial situation in accordance with the advice given on this sheet, the Safety Data Sheet, and the container(s), and should not be used without reference to the Safety Data Sheet (SDS) which Carrs Coatings Ltd has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted, which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult Carrs Coatings Ltd for further advice.

PACK SIZE	10 litre unit	IL3503 Base	5 litres in a 5 litre container
		IL3504 Curing Agent	5 litres in a 5 litre container

For availability of other pack sizes contact Carrs Coatings Ltd

SHIPPING WEIGHT	U.N. Shipping No. 1263
	10 litre unit
	6.1 kg (13.4 lb) IL3503 Base (Part A)
	4.2 kg (9.2 lb) IL3504 Curing Agent (Part B)

STORAGE	Shelf Life	12 months minimum at 25 ⁰ C (77 ⁰ F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.
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