PRIME-GUARD™ 29357

ANTICORROSIVE PRIMER / SURFACER

TWO COMPONENT POLYURETHANE

PRODUCT FEATURES

- High quality anticorrosive polyurethane primer
- Fast dry primer for efficient job completion
- Very good sanding and curing times
- High build capabilities
- Very good application characteristics. Easy to apply with any traditional painting equipment
- Easy to sand primer
- Long pot life
- Excellent intercoat adhesion with subsequent coatings
- No induction time
- For superior perfomance overcoat with Glass Shield polyurethanes

glass® shield

Suggested Use

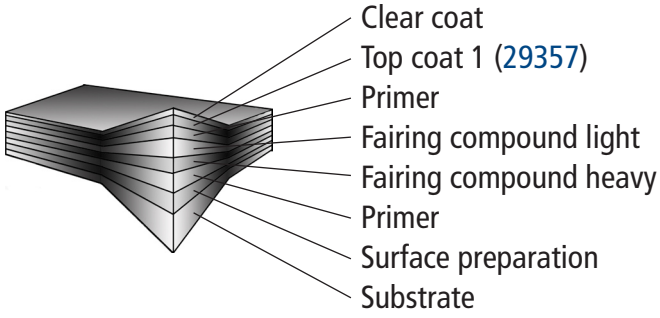
- Transport and / or automotive industry
- Steel structures or equipments of any type

Technical Data

Coating type	Polyurethane
Colour	Gray
Packaging	3.78 L (1 US Gal.)
Mixing Ratio	4 : 1 per volume
Gloss (ASTM D523)	Flat
Flashpoint (ASTM D93)	26° C (79° F)
Induction time	None
Thinner	UC 500S - Regular
Pot life	6 hours at 20° C (68° F)
Shelf life	2 years
Density (ASTM D 1475)	1.25 kg / L +/- 0.05
Weight	10.46 +/- 0.4 lbs / US gal.

Volatile organic compound (VOC)	5.4 lbs / US gal. (520 g/L)
Temperature resistance	100° C (212° F) in continuous service
Solids (ASTM D1644)	
By weight	55.8 +/- 2%
By volume	38.32 +/- 2%
Theoretical spreading rate	12.6 sq.m /l at 25 microns dry
	512 sq.ft. / US gal at 1 mil
Recommended film thickness	25 - 50 microns dry (1.0 - 2.0 dry mils)
Application methods	Conventional air spray, airless, HVLP

Typical Sequence (First class finish)



In doubt? Contact technical services at 1-800-361-6652 for proper guidance in preparing substrate

Surface Preparation

The surface preparation recommended for PRIME-GUARD™ 29357 is to include removal of all oil, grease, dirt, dust, mill scale, rust, paint, oxide, corrosion product and other foreign matters. This can be accomplished with hydroblasting, grit sweeping and with a variety of mechanical descaling tools. The minimum standard for steel is Steel Structures Painting Council Standard SSPC-SP-2 or SSPC-SP-3. For superior protection, overcoat with Glass Shield's polyurethanes.

Mixing and Thinning

PRIME-GUARD™ 29357 is a two component product supplied in 5 US gallons or 1 US gallon containers which contain the proper ratio of ingredients. The entire content of each container must be mixed together (If smaller amounts are needed mix 4 parts by volume of 29357 (Part A) with 1 part by volume of GS 275-63C (Part B)).

Mix the Part A portion first to obtain a smooth, homogeneous product. Add one (1) part by volume of catalyst Part B (GS 275-63C) while mixing. Mix only what is needed for use at that time. Pot life is 6 hours at 20ºC.

For air spray application dilute as needed, up to 25% by volume with GS UC 500S. Add while mixing and stir until homogeneous.

Warning: Excessive solvent addition can adversely affect the performance of the coating.

CATALYST	THINNER	VISCOSITY	POT LIFE
			
4 : 1	Up to 25 %	22 to 60 sec.	6 hrs

Application Conditions

Industry standards are for the substrate temperatures to be above 10º C of the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate.

Special application techniques may be required above or below normal application conditions.

Condition	Material	Surface	Ambient	Humidity
Normal	60 - 85º F (16 - 29º C)	60 - 85º F (16 - 29º C)	60 - 90º F (16 - 32º C)	0 - 65%
Minimum	50º F (10º C)	50º F (10º C)	50º F (10º C)	0%
Maximum	90º F (32º C)	100º F (35.5º C)	100º F (35.5º C)	85%

Application

All spray equipment and fluid lines must be clean and free of moisture or solvent. Do not apply to damp surfaces or under high humidity conditions since condensation or fog could settle on the coating before it has cured.

Minimum temperature for application: 10º C (50º F). Temperatures over 30ºC or high humidity conditions may shorten the drying times or pot life.

PRESSURE	DRY THICKNESS	INTERCOAT
		
40 to 65 lbs / 10 lbs at the gun Conventional HET or JTI	2.0 to 3.0 mils 1 to 3 coats	15 to 30 minutes

Airless & Air Spray

Manufacturer	Graco
Pump	30 : 1
Fluid hose	3/8" x 100' max
Tip size	309 / 411 / 513/ or equivalent
PSI	2400 PSI min.

Manufacturer	Devilbiss	SATA
Spray gun	HET	K3 RP
Fluid tip	1.1 ff	1.1
Air cap	#410 / 414	
Fluid line	3/8"	3/8"
Pressure pot	15 - 25 psi	40 psi
Atomizing air	50 - 60 psi	36 psi

Curing Schedule

Ventilate the substrate for 2 hours after application. Curing times are based on a 2.0-3.0 mil (50-75 micron) dry film thickness. Higher film thickness, insufficient ventilation or cooler temperatures will require longer cure times and could result in solvent entrapment and premature failure of the film. Maximum recoat time is 72 hours without special surface preparation. Consult technical services for recommendations and test results. If the maximum recoat time has been exceeded, the surface must be sanded or prepared with a brush off blast SSPC-SP-7 prior to the application of additional coats. PRIME-GUARD™ 29357 applied below 40ºF (4ºC) may temporarily soften for several hours, after temperatures rise to 60ºF (16ºC). This is a normal condition and will not influence performance.

Catalyst	275-63C
Dry to touch	30 minutes
Sandable	1 hour
To recoat	1 hour
Hard	8 hours
Full cure	7 days

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www.glass-shield.com 1-800-361-6652