Technical Data Sheet

PROTOPOL F50

Reaction Primer
Lead and chromate free

Product Description

One-pack chemically curing primer with very good adhesion to smooth and badly pretreated surfaces. Thermal resistance up to 80 °C dry heat.

Areas of Application

Production-line painting in machine, metal and vehicle construction. Especially suitable as primer for cold-drawn and aluminium profiles.

Application

Conventional and airless spraying.

Airless nozzles (approximate settings)
narrow = 213 / medium = 413 / wide = 613

Do not apply at temperatures below + 5 °C. Surface temperature must be at least 3 °C above dew point to prevent moisture condensation during application.
Steel parts temporarily exposed to weathering should be coated with a dry film thickness of at least 40 µm.

Can be recoated with PROTOPOL F50 after 30 minutes at 20 °C, with one-pack top coats after 1 - 2 hours at 20 °C. Two-pack top coats for indoor use should first be discussed with our Technical Department.

Addition of Thinner

Conventional spraying	30 - 40 wt.-%	V1
Airless spraying	15 - 30 wt.-%	V1

Special Note

Our data are based on a dry film thickness of approx. 30 µm for primers and approx. 40 µm for top coats, standard climate 23/50 DIN 50014.

The information contained in this technical data sheet is based on general technical standards and is meant for specialists. Any changes in the recommended operating procedures or specified environmental conditions may influence the results significantly. Our guarantee covers only the quality of the material delivered. We do not accept any responsibility for the application. In case of doubt, we recommend contacting our Technical Service. Our products are under constant development. Therefore please note date of issue of our technical data sheet and ask for latest edition.

Safety Measures

PROTOPOL F50 contains solvents and is combustible, therefore protect from heat and keep away from naked flames. Sufficient air circulation must be provided. Do not inhale vapours. All regulations regarding work hygiene and operational measures must be observed.

Technical Data

Binder	Polyvinylbutyral
Pigmentation	Zinc phosphate
Finish	Matt
Colour	black approx. RAL 4009 oxide red approx. RAL 7037 light grey approx. RAL 6011 reseda green white Other colours on request.
Substrate	Cold-drawn profiles, steel, aluminium (chromatized for exterior use). The surface must be dry, free of grease and dust.
Thinner	V1 (The use of other thinners may lead to defects and loss of quality).
Packaging	5 and 20 kg disposable containers
Storage	6 months in original, unopened containers stored at a temperature of 20 °C.
Waste disposal	Residues are considered as special refuse and must be treated as such, VeVa-code 08 01 11.

Components	1
Drying (23 °C)	Dust free approx. 5 min. Dry to touch approx. 30 min. Transportable approx. 2 - 3 hours Drying times depend on film-thickness, substrate and air temperatures.
Stoving possible	Up to 30 minutes at 80 °C There may be a slight yellowing of pure white top coats during stoving.

Solids content	by weight: approx. 42 % by volume: approx. 26 % } white
Density (20 °C)	approx. 1,07 kg/l
Theoretical consumption	approx. 120 g/m² at 30 µm

	PROTOPOL F50	**V1**
Flash point	15 °C	25 °C
Danger class RID/ADR	3 III	3 III
VOC content	63,64 %	100 %

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