



TECHNICAL BULLETIN

PRODUCT NAME : MDF DOOR PRIMER

PRODUCT CODE : 550-1600

DESCRIPTION : 100% ACRYLIC PRIMER FOR INTERIOR MDF AND HARDWOOD SUBSTRATE, PROVIDING EXCELLENT COVERAGE AND HIDING. THIS PRIMER CAN BE RECOATED WITH ANY TYPE OF FINISHING SYSTEMS AVAILABLE FROM A WB PIGMENTED TOP COAT TO A SOLVENTBORNED SYSTEM (PRECAT/POST CAT/VARNISH) EVEN A URETHANE 2K.

COLOR : White

SOLID CONTENT BY VOLUME : $48 \pm 1 \%$

SOLID CONTENT BY WEIGHT : $66 \pm 1 \%$

VISCOSITY : 35-38 sec. Z#2 @ 25°C

V.O.C. : 30 g/L

SPECIFIC GRAVITY (kg/l) : $1.52 \pm 2\%$ at 25°C

REDUCTION : Mix well with a mixing device and add 2-5% of water.

SHELF LIFE : 6 months recommended if unopened and stored between 15 deg. C and 25 deg. C. Always rotate stock and keep above 5 deg. C.

FILM THICKNESS : Film build must not exceed 4 dry mils



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COVERAGE : Coverage is 19-20 m²/l at 1 mil for 100% transfer efficiency. Coverage will vary depending on method of application and coating thickness.

SURFACE PREPARATION : Surface must be sanded, free of dirt and contamination.

VISCOSITY AND FILM THICKNESS

VISCOSITY (Zahn #2)

WET FILM

CONVENTIONAL SPRAY :

25-28 sec

3-4 mils

AIRLESS SPRAY :

25-28 sec

3-4 mils

HVLP:

25-28 sec

3-4 mils

DRY TIME : Allow 45-60 minutes dry at a minimum temperature of 18°C and below 65% relative humidity before sanding. Dry times are greatly affected by film build, porosity of substrate, air movement, heat and humidity. Individual tests should be conducted to determine drying times on specific equipment.

CLEAN-UP :
-Clean with water when material is in liquid state.
-Clean with an 80:20 blend of water and Butyl Cellosolve (013-0500) when material is semi-dried.
-Clean with 015-0500 to remove dried lacquer.

DIRECTIONS FOR USE : Mix material before use. Add water to reduce, if required, and mix thoroughly. Apply a maximum wet film thickness of 4 mils. Sanded surfaces must be recoated within 8 hours of the sanding preparation.



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ADDITIONAL INFORMATION: Product must be agitated thoroughly at all times to ensure product consistency. Contact with metallic surfaces must be avoided. Keep from freezing.

All dilution, if necessary, MUST be done with AkzoNobel solvents.

CLASSIFICATION U.N. : Not regulated

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