



## SOLACOAT WB PRIMER (Metal)

### Description

WB Primer is a novel water based primer based on acrylic resin and a zinc phosphate complex that has exceptional adhesion to both ferrous and nonferrous metals with good anti-corrosive properties on steel. WB Primer may be top-coated with both water based and solvent based coatings.

### Features

- Fast drying
- Lead and zinc chromate free
- Excellent for use as a shop primer in prefabrication work
- An excellent primer on steel, aluminum and good on zinc coated metals
- Good gloss holdout
- Can be top-coated with conventional water based and solvent based coatings
- Low VOC emissions.

### Areas of Application

Suitable for new and old metal roofs and walls, general shop work and production line work, tanks, pipes, cranes, agricultural parts, earthmoving equipment, structural steel and production line priming. Normally over coated with conventional air-drying, spraying finishes such as Insul Insulation.

### Typical Specifications

Surface	Preparation	System	Dry Film Thickness
Structural Steel	Abrasive blast clean to AS1627.4 Class 2	First Coat: WB Primer Top Coat: As mentioned above	40-50µm 30-50µm
Mild Steel	Remove rust, clean and degrease.	First Coat: WB Primer Top Coat: As mentioned above	40-50µm 30-50µm
Galvanised and zinc coated steel and aluminum	Clean and degrease. Smooth and polished aluminum may need abrading with a nylon pad.	First Coat: WB Primer Top Coat: As mentioned above	40-50µm 30-50µm

**Please Note:** WB Primer applied at 40-50µm should be allowed to dry a minimum of 2 hours for top-coating with conventional water based coatings and 4 hours before applying solvent based topcoats.

### Surface Preparation

#### Steel

Excellent performances will be achieved by abrasive blast cleaning to AS1627.47 Class 2 or equivalent. However, good results can be achieved in mild exposure conditions on power or hand tool cleaned surfaces to AS1627.2 or AS1627.7 or equivalent. Prime with WB Primer to 40 -50 microns dry film thickness.



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### Mild Steel

Remove light surface rust with a rust converter according to manufacturers instructions or clean and degrease with a Wax and Grease Remover. Prime with WB Primer to 40 - 50 microns.

### Galvanised and Zinc Coated Steel, Aluminium and most non-ferrous metals.

Clean with Wax and Grease Remover. Allow to dry. Smooth polished aluminium may need to be lightly abraded with a nylon pad. Apply WB Primer at 40 - 50 microns dry film thickness.

### Mixing Instructions

Stir thoroughly until uniform consistency.

### Application

Do not apply WB Primer below 6oC substrate temperature or above 85% relative humidity.

### Brush or Roller

Thinning not required, taking care not to over brush or over roll the coating.

### Airless Spray

Thin approx. 5 - 10% with clean water. Tip orifice 0.013" to 0.015". Apply at 14 to 17 Mpa atomising pressure. Apply two medium double-header coats to a dry film thickness of 40 - 50microns.

### Conventional Spray

Thin approx. 15%. Apply at air atomising pressure of 350 to 400kPa. Apply two medium double-header coats to a dry film thickness of 40 - 50microns.

### Thinner

Water

### Cleaner

Initially water to remove the bulk of the material then use a final rise of methylated spirits or lacquer thinners. Alternatively use warm soapy water.

### Approximate Coverage

Practical at 40micron dft	Brush or roller	9.0m <sup>2</sup> /L
	Airless spray	9.3m <sup>2</sup> /L
	Conventional spray	8.0m <sup>2</sup> /L



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### Properties

<b>Colour:</b>	White, which may be tinted with earth oxide colours to pastel shades.
<b>Gloss:</b>	Low
<b>Drying time:</b>	Approximate air drying times at 25oC and 40 microns dry film thickness
<b>Dust free:</b>	10 - 15minutes
<b>Touch free:</b>	20 - 30 minutes
<b>Hard dry:</b>	2 hours
<b>Recoating Time:</b>	2 hours for water based products 4 hours for solvent based products. These times are quoted for 25°C, 50% relative humidity and reasonable air movement. Cold damp conditions with little or no air movement will increase the recoat times.
<b>Solids:</b>	By weight approximately 51% By volume approximately 40%
<b>Weight per Litre:</b>	Approximately 1.23kg.
<b>Shelf life:</b>	18 months when stored in original, unopened contained and store in cool, dry conditions above freezing and out of direct sunlight.
<b>Flash Point:</b>	Non-flammable.
<b>Durability:</b>	Good when top-coated.
<b>Resistance Properties:</b>	
<b>Abrasion:</b>	
<b>Heat:</b>	Good
<b>Solvent:</b>	Up to 1200C
<b>Oil and Petrol:</b>	Moderate.
<b>Chemical:</b>	Moderate. Limited.

### VOC Emissions

WB Primer has a Volatile Organic Content (VOC) of less than 120 grams per litre.

### Precautions

When applying in a confined space, use suitable respiratory protection. In common with other solutions WB Primer should not be allowed to remain on the skin and normal hygiene standards should be observed when using this product.