

GP STOVEPRIME 304

SPECIAL POLYMER BASED PRIMER

Description

Special polymer modified with melamine amino resin based thermosetting primer.

Recommended Use

This is a stoving primer. It is an ideal protective stoving primer for application on M.S. metal surface for OEM industries allowing faster handling of coated articles.

Physical Data

COLOUR	:	Red & Grey
FINISH	:	Matt
SOLIDS BY VOLUME	:	35 ± 3% (Depends on shade)
THEORETICAL SPREADING RATE	:	1 l .66 sq.mt /ltr at recommended DFT of 30 μ
FLASH POINT	:	Above 25°C
DRYING CHARACTERISTICS	:	Baking Schedule: 140°C /30 Minutes.
SHELF LIFE	:	6 months

Surface Preparation

The surface of steel should be free from rust, dust, oil, grease, and other foreign contaminants. The surface should be prepared by following seven tanks pretreatment. It is preferable to have Zinc Phosphating. Iron Phosphated surface is also acceptable under certain conditions

Application Data

APPLICATION	:	By Conventional Spray / Electrostatic Spray
THINNER	:	TSA thinner
COMPATIBILITY	:	Compatible with Epoxy, PU, TSA and Chlorinated Rubber Finish paints

Application Method

Stir the paint thoroughly. Add TSA Thinner into the paint. Strain the paint through Nylon filter cloth of 200 mesh size. All equipments used for above should be properly clean.

Application: By Conventional Spray / By Electrostatic Spray

For Conventional Spray application:

Thinner: TSA Thinner

Addition: 25 - 30%

Nozzle Orifice: 1.2 - 1.5 mm

Nozzle Pressure: 45 - 55 p.s.i.

For Electrostatic Spray application

Thinner: TSA Thinner

Addition: 25 - 30 % max

Nozzle Orifice: 1.1 - 1.3 mm

Resistivity: 300 - 700 KOhms



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ISO 14001

Additional Information

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following section of Grand Polycoats' latest Data manual:

- Guide to Product Data Sheet
- Surface Preparation Details
- Paint Application Details
- MSDS

Notes

1. Do not apply paint when temperature falls below 10°C or rises above 50°C and when Relative Humidity is above 85%. Do not apply during rain, fog or mist. Surface temperature must always be minimum of 3°C above Dew point.
2. Contact Grand Polycoats' representative for further assistance.
3. Shelf life indicated is minimum for this Product in sealed condition and it is subject to re-inspection thereafter. Individual component is required to be stored in cool, dry and covered condition, away from heat and ignition.

Health & Safety

This is a solvent based paint and care should be taken to avoid inhalation of spray mist or vapour as well as contact between the wet paint and exposed skin or eyes.

Limitation of Liability

To the best of our knowledge, the technical data in our literature are true and accurate at the date of issuance but are subject to change without prior notice. We guarantee our product to conform to the specifications contained herein. We make no other warranty or guarantee of any kind, express or implied, including merchantability and fitness for particular purpose. Liability, if any, is limited to replacement of the product or refund of the purchased price. Labour or cost of labour and other consequential damages are hereby excluded.



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Grand Polycoats Co.Pvt.Ltd. 204, Siddharth Complex, R.C. Dutt Road, Vadodara - 390007, (Gujarat) India.

Tel.: +91-265-3064200 / 3064201 Fax: +91-265-2337022

E-mail: marketing@grandpolycoats.com Website: www.grandpolycoats.com

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