


Technical Data Sheet

Product Name	
Full Product Name	109 Enamel Primer
Type of Product	1K Enamel Primer
Description	Concept 109 ENAMEL PRIMER is an industrial enamel primer with excellent hold out and adhesion properties. It is suitable as a primer for Concept's Enamel Product range.

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
109 Enamel Primer	42.1	61.0	1.241	10.35	483.6	4.04
804 Enamel Thinner	0.0	0.0	0.802	6.69	802.0	6.69










Properties	
<ul style="list-style-type: none"> • Excellent hold-out • Excellent adhesion • Easy to sand 	

Substrates	
<ul style="list-style-type: none"> • Mild steel surfaces • Sound existing enamel and acrylic lacquer surfaces 	

Substrate Preparation	
 All Substrates	<p>All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept Light Rust & Metal Converter.</p>



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Product Preparation

	Reducer	Up to 50% (v/v) of Concept Enamel Thinner, if required.			
	Pot life @ 25°C (77°F)	N/A			
	Spray viscosity @ 25°C (77°F)	BSB 4 Cup	14-16 s	Ford 4 Cup	12-14 s
	Spray equipment	Gun type	Fluid tip	Spray pressure	Spray Distance
		Gravity feed	1.8-2.0 mm 0.071-0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
		Suction feed	1.8-2.0 mm 0.071-0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
		HVLP	1.5-1.8 mm 0.059-0.071"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch
	Number of coats	2-3	Apply one coat followed by one or two even full coats. Avoid heavy wet coats.		
	DFT Recommended	40-50 µm Higher film build can be achieved by reducing the thinner level 1.6-2.0 mils			
	Flash off time @ 25°C (77°F)	5 min between coats			
	Drying	Air Dry @ 25°C (77°F)	2-3 hours		
	Sanding	Wet sand with P600-P800 before applying finish coat or Dry sand with P240 followed by P400-P500 using an orbital sander			

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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Remarks	
	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.

Equipment Cleaning
Use recommended Concept Paints cleaner

Dry Film Properties	After 7 days drying, <u>when compared to similar technology products.</u>
Adhesion	Excellent
Hold-out	Excellent
Durability	Excellent

Product Data	
Colour	Grey
Theoretical Coverage	Approx. 7.0 m ² /L (205 ft ² /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature away from sunlight.

Product Packaging			
Product Code 1	Product Code 2	Product Name	Package Size
A03C/INEP	1096200	109 Enamel Primer	1L, 4L
A08C/ENA	8049200	804 Enamel Thinner	1L, 4L, 20L, 60L

Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

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This Technical Data Sheet supersedes all previous issues.

Concept Paints
26-30 Charles Street
St Marys NSW 2760
Sydney, Australia

ph. +61 (2) 9673 2555
fax. +61 (2) 9623 1918
info@conceptpaints.com.au
www.conceptpaints.com.au