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ViterBond ET777 PVB/Epoxy Primer

Product Description	**A two pack epoxy/pvb primer and bonding coat** for steel and non-ferrous metals.
Features & Use	• A pre-treatment and bonding primer for use on aluminium, copper, brass, cadmium, zinc, galvanising, nickel and carbon steel • Suitable as an adhesion coat to abraded stainless steel • As an alternative to T-wash type mordant solution for adhesion to fresh galvanised steel • Combines the adhesive power of PVB resin together with the resistance properties of epoxy resin • Overcoatable with most generic groups
Approvals/ Certification	Please consult Spencer Coatings
Finish	Matt
Volume Solids	30 ± 2%
VOC Content	588 ± 20 g/litre

Film Thickness Range And Coverage

	Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
Typical	15 µm	50 µm	20.0 m^2/litre
Maximum	20 µm	66 µm	15.0 m^2/litre

Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated

Drying Times

Applied to **15 microns** DFT		+10°C	+23°C	+35°C
Dust Free		6 min	4 min	2 min
Hard Dry		15 min	10 min	5 min
Overcoating	Min with ViterClad 50 or PV	4 hr	3 hr	2 hr
	Min with ViterShield	36 hr	24 hr	16 hr
	Maximum	Indefinite when the surface is clean and sound		

Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation

Colours	Grey (approx. RAL 7032) For a range of colours see ViterClad Bonding Coat
Mix Ratio/ Product Code	Base **3338 RJN** 3 parts by volume Hardener **4050 059** 1 part by volume
Pot Life	12 hours at 23°C
SG	1.22-1.25 kg/lt mixed
Storage Conditions	Store in dry, cool conditions and protect from frost
Shelf Life	Minimum 12 months if stored as above in unopened containers
Flash Point	23-60°C

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Surface Preparation	• **Carbon Steel** (non-blasted): thoroughly degrease and prepare to St2 (ISO 8501-1:2007) taking care to avoid 'polishing' the surface • **Galvanised Steel**: thoroughly degrease using a propriety biodegradable degreaser, rinse with clean fresh water and allow to dry before coating. It is essential to remove all flux, zinc salts and high profile zinc spatter. Very smooth or glossy areas should be lightly abraded to provide a 'key' • **Aluminium, Copper, Brass, Cadmium and Nickel**: thoroughly degrease using a propriety biodegradable degreaser to remove all verdigris, salts and other contaminants. Wash with clean fresh water and allow to dry. Very smooth or glossy areas should be lightly abraded to provide a 'key' • **Stainless Steel**: thoroughly degrease and abrade • All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams
Mixing	Mix only in the proportions stated, mixing each component individually then together using a mechanical agitator. Agitate periodically during use to ensure product remains homogeneous.
Thinner	1031 Thinner **Equipment Cleaner** 1031 Thinner
Application Conditions	Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3ºC above the dew point. Only apply this product when the above conditions can be maintained throughout the critical application and drying/curing process. Paint temperature should ideally be at a minimum of 15ºC.
Application Methods	**Method** / **Airless Spray**: Yes / **Conventional Spray**: Yes / **Brush**: Yes / **Roller**: Yes • Airless Spray: Output fluid pressure at tip 1500-2500 psi, Tip Size: 11-15 thou (0.28-0.38mm) • Refer to Spencer '**Epoxy Application and Curing Notes**'
Product Notes	• Do not exceed the maximum stated dry film thickness • Do not apply more than 125 microns DFT of any topcoat in a single coat directly over ViterBond ET777 • For application under cold or hot conditions the addition of up to 5% of 1031 Thinners may be necessary
Health & Safety	Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Spencer Coatings.