

Product Code:

545-8023

VISCOSITY: Zahn #2 signature cup 27 sec at 77°F
FLASH POINT: -4°F (-20°C)
DENSITY (lb/gal): 9.51
SOLID (% by weight): 47.1%
SOLID (% by volume): 28%
SHELF LIFE (months): 6

Product Description: Variset Primer is a one-component, high solids, pre-catalyzed Reactive Amino Coating (RAC). This product is formulated using the same chemistry as Varicure® with easy sand and great build. Variset Primer comes in a ready to use format, there is no need for reduction. This pigmented pre-catalyzed RAC has very low odor during the curing process. Variset Primer is also HAPs solvent free.

Uses: Variset Primer is recommended for use as a primer for Variset and Variset Plus. It has good filling properties and hiding characteristics.

Environmental Data (as supplied):

VOC less exempt lb/gal: <4.80
VOC lb/gal: <4.07
VOC less exempt g/l: <575
VOC g/l: <488
VOC lb/lb Solid: <0.95
VHAPs lb/lb Solid: <0.00

See individual compliance sheets for specific data

Application Data:

SUGGESTED USES: Wood Primer
MIXING RATIO: 100 parts 545-8023 to 3 parts 873-0870 (if used as a post-catalyzed primer)
POT LIFE: 8 hours
APPLICATION VISCOSITY: Zahn #2 signature cup 25-30 seconds
REDUCER: 803-1325
RETARDER: N/A
CLEAN-UP SOLVENT: 803-1298 or 800-5500
RECOMMENDED WET FILM: 3 – 5 mils
COVERAGE: 545 sq. ft. /gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

Directions for Use

Surface Preparation: Substrate should be sanded using 120, 150 or 180 grit steared paper prior to coating. Variset Primer should be sanded with 280/320 grit steared paper prior to being coated and the next coat must be applied within eight hours of sanding. Variset Primer cannot be used on metal, old oil or cellulose lacquers.

General information: Agitate material before use. Always mix Variset Primer while adding catalyst and reducers in the recommended mixing ratio. Variset Primer must be agitated thoroughly at all times to ensure product consistency. Apply at 3 – 5 mils wet sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit steared paper.

Maximum film build of Variset Primer should not exceed 2 – 3 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. Contact with metal surfaces should be avoided. Variset Primer must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats. Variset Primer must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finish surfaces. This may accelerate discoloration.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION.

Drying Times:

	Room Temperature (68°F)	Forced Drying Schedule (122°F)
Tack Free Time:	10 - 15 minutes	Flash off before entering oven
Dry to Sand:	45 - 60 minutes	20 - 30 minutes
Dry to Stack:	3 hours	60 - 90 minutes

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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