

Technical Data Sheet

Indothane 990

Acrylic Polyurethane Zinc Phosphate Automotive Primer

Product Description

Two component Acrylic Polyurethane based anti corrosive primer containing Zinc Phosphate as corrosion inhibiting pigment. Indothane 990 is an ideal choice as primer in Automotive Refinish System and High Quality Wood Finish.

Recommended Use

It is recommended as most versatile PU primer on M.S. surface, concrete, wood, ABS plastic etc in diverse areas of Automobiles, Bus Bodies, OEM components, Electric vehicles, Sheet Metal and engineering wood etc. It has excellent adhesion to various surface and is an ideal primer where fast turnaround of equipment is desired.

Physical Data

Colour	: Grey, White
Finish	: Eggshell
Soild by Volume	: 45 ± 2%
Supply Weight (Kg/ Ltr)	: 1.25±0.05
Flash Point	: 26° C
Dry Heat Resistance	: Intermittent : 120°C, Continuous: 100°C
Shelf Life	: 12 months

Film Thickness

Recommended film thickness per coat

Dry Film Thickness	: 30-50µ in single coat
Wet Film Thickness	: 65-110µ in single coat
Therotical Coverage Rate	: 15.00 sq.mt / lit at recommended DFT of 30µ

Surface Preparation

All surfaces to be coated should be clean, absolutely dry and oil or moisture free before painting application. Oil and grease should be removed by solvent cleaning.

ABS Components: Can be applied directly after proper solvent cleaning (preferably by Isopropyl Alcohol) or sanding of ABS surface by emery paper 320/ 400 for proper adhesion. Existing system should be dry and free from loose paint, salt, grease and other contaminants prior to overcoating.

New steel: Abrasive blasting to Sa 2½ (ISO 8501-1:2007). For sheet metal, phosphating cleaning through 3 or 7 tank process are ideal surface preparation techniques. All damage of earlier coating or contamination from storage and fabrication should be thoroughly cleaned prior to final painting.

Maintenance: Remove oil and grease etc. thoroughly with suitable detergent. Remove salts and other contaminants by high pressure fresh water cleaning. Clean damaged areas thoroughly by power tool cleaning to St 3 (ISO 8501-1:2007) (minor areas) or by abrasive blasting to min. Sa 2, preferably to Sa 2½ (ISO 8501-1:2007). Improved surface preparation will improve the performance of the product.

Wood: To be sanded by power grinding or emery paper to a uniform, sharp, smooth profile corresponding to Rz minimum 50 micron. Any dirt, grease, oil, etc. to be removed before application is commenced.

Application Data

Application Method	: Spray/ Airless Spray/Brush/ Roller
Mixing Ratio	: 4 Part (Base) : 1 Part (Hardener)
Pot Life	: Two Hours at 30°C
Thinner and Cleaner	: Indokote PU Thinner (IK.1705)
Airless Nozzle Orifice	: 0.35 - 0.45mm
Nozzle Pressure	: 155 kg/cm ² or 2200 psi

Working Precautions: Material should not be allowed to remain in pipeline, hoses, gun or spray equipment. Thoroughly flush all equipment with IK.1702 thinner. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages, the work should recommence with freshly mixed units.

Maintenance: Clean all equipment immediately after use with IK.1702 thinner. It is good working practice to periodically flush out spray equipment during the course of the working day. All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.

Drying Characteristics

Surface Dry	: 20 mins
Touch Dry (to Handle)	: 60 mins
Hard Dry	: 24 Hours
Overcoating Interval	: Minimum 10 min (wet-on-wet Application compliant)

Drying and curing times are determined at 30°C under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Compatibility

Previous Coating	: Polyurethane, Epoxy
Subsequent Coating	: Polyurethanes, Acrylics

Storage

This is solvent based coating and the containers should be kept in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed.

Caution

This product is for professional use only. The paint applicators should be trained, experienced and have the capability and equipment to mix and apply the coatings correctly as instructed. Applicators should use appropriate protection equipment when using this product.

This is solvent based product and should be use under well ventilated conditions. Do not inhale spray mist. Skin contact should be avoided. In case of spillage on the skin, it should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water.

Limitation of Liability

This information is given to the best of our knowledge. Because of the multitude of formulations, production, and application conditions, all the above-mentioned statements have to be adjusted to the circumstances of the processor. Our products are often used under conditions beyond INDOKOTE's control. INDOKOTE cannot guarantee anything but the quality of the product itself. No liabilities can be derived from this fact for individual cases. This issue replaces all previous versions – Printed in India.

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