

## Speedspray QDH Primer

Product Description	A fast drying, high build, modified-alkyd zinc phosphate primer, for in-shop spray application to steelwork.				
Features & Use	<ul style="list-style-type: none"><li>Excellent drying and enamel hold-out, which makes it an ideal base for top coating with Hi-Dur AD100 Finish</li><li>Good adhesion and corrosion resistance</li><li>Use as a primer for metal fabrications, agricultural equipment, machine tools and most other surfaces where fast drying properties are required</li></ul>				
Approvals/ Certification	Please consult Axalta Coating Systems				
Finish	Matt				
Volume Solids	45 ± 2% (varies with colour)				
VOC Content	475 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	75 µm	167 µm	6.0 m²/litre	
	Maximum	150 µm	333 µm	3.0 m²/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 75 microns DFT		+10°C	+23°C	+35°C
	Dust Free		45 min	25 min	15 min
	Hard Dry		2 hr	1 hr	45 min
	Overcoating	Minimum	3 hr	2 hr	1 hr
		Maximum	Indefinite if 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	Light Grey (IP010), Red Oxide (IP011), Buff (IP013), Black (IP014), White (IP015) and shades to order				
Product Code	04SQP				
SG	1.41 kg/ltr (varies with colour)				
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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<b>Surface Preparation</b>	<ul style="list-style-type: none"> <li>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</li> <li><b>Steel:</b> blast clean ideally to Sa2½ (ISO 8501-1:2007), minimum of Sa2, surface profile 50-75 microns</li> <li><b>Non-ferrous surfaces:</b> consult Axalta Coating Systems for advice on appropriate adhesion primer</li> </ul>				
<b>Mixing</b>	Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.				
<b>Thinner / Cleaner</b>	Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)				
<b>Application Conditions</b>	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 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.				
<b>Application Methods</b>	<b>Method</b>	<b>Airless Spray</b>	<b>Conventional Spray</b>	<b>Brush</b>	<b>Roller</b>
		Yes	Yes	Yes	Yes
	<ul style="list-style-type: none"> <li>Airless/Air-assisted Airless Spray: output fluid pressure at tip 2000-2500 psi, tip size 11-17 thou (0.28-0.43 mm)</li> <li>Conventional spray: 50-60psi and 1.4-1.8mm diameter nozzle</li> <li>Thin the coating for spray if required (up to 5-10% typical) but hold-up properties will be reduced</li> <li>Application by brush/roller will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work. For brush application please consult Axalta Coating Systems</li> </ul>				
<b>Product Notes</b>	<ul style="list-style-type: none"> <li>Apply two coats of primer in more severe environments or where a topcoat is not to be used</li> <li>In common with most alkyd primers, this product is not recommended for extended exterior exposure, exposure in aggressive or coastal locations, or for immersion. Epoxy primers are preferred for these conditions, please consult Axalta Coating Systems for specification advice</li> </ul>				
<b>Health &amp; Safety</b>	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 Axalta Coating Systems.				

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