

Speedcoat MD90 HB Primer/Finish

Product Description	A one coat¹ anticorrosive alkyd primer/finish (gloss) for steel. This product is a high gloss version of Speedcoat MD60.				
Features & Use	<ul style="list-style-type: none"> • Provides a colourful, high gloss system in one coat¹ • Excellent chip resistance, corrosion and seawater resistance, verified by salt spray and humidity evaluations • Use for containers, machinery and general steel fabrications used in industrial and other aggressive environments • Designed for airless spray application 				
Approvals/Certification	Please consult Axalta Coating Systems				
Finish	Gloss				
Volume Solids	35 ± 2% (varies with colour)				
VOC Content	510 - 560 ± 20 g/litre (varies with colour)				
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage	
	Minimum	75 µm	214 µm	4.6 m ² /litre	
	Maximum	125 µm	357 µm	2.8 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 100 microns DFT		+10°C	+23°C	+35°C
	Dust Free		2 hr	1 hr	40 min
	Hard Dry		4 hr	2 hr	1½ hr
	Overcoating	Minimum ²	4 hr	2 hr	1½ hr
		Maximum	Indefinite if clean and sound		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation ² – see Product Notes					
Colours	BS, RAL and special shades to order				
Product Code	02MD90 / 17MD90				
SG	1.00 – 1.20 kg/lit (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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<p>Surface Preparation</p>	<ul style="list-style-type: none"> 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 Ideally blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns Where blast cleaning is impractical the surface should be prepared to minimum St2 (ISO 8501-1:2007), taking care to avoid 'polishing' the surface 														
<p>Mixing</p>	<p>Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.</p>														
<p>Thinner / Cleaner</p>	<p>Axalta Thinner Fast Industrial TH120 (formerly called No.4 Thinner)</p>														
<p>Application Conditions</p>	<p>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.</p>														
<p>Application Methods</p>	<table border="1"> <thead> <tr> <th>Method</th> <th>Airless Spray</th> <th>Conventional Spray</th> <th>Brush</th> <th>Roller</th> </tr> </thead> <tbody> <tr> <td></td> <td>Yes</td> <td>Yes</td> <td>Yes</td> <td>Yes</td> </tr> </tbody> </table>	Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	Yes				
Method	Airless Spray	Conventional Spray	Brush	Roller											
	Yes	Yes	Yes	Yes											
<ul style="list-style-type: none"> Airless, or air-assisted airless, spray: output fluid pressure at tip 1800-2500 psi (for airless), Tip Size 11-17 thou (0.28-0.43 mm) Conventional spray: typical atomising pressure 50-65 psi, 1.8mm tip size. Thinning of 5-10% may be required. Multiple coats may be required to achieve recommended dft Application by brush/roller is recommended only for small areas of touch up/remedial work 															
<p>Product Notes</p>	<ul style="list-style-type: none"> Incorrect application (such as excessive film thickness) can lead to immediate and long term film defects Speedspray QDH Primer may be used where extended protection is required <ol style="list-style-type: none"> Colours such as yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required, relative to only one coat of a grey or red oxide, so that yellows, bright reds and oranges may not be suitable as 'one coat' systems Minimum overcoating: can be recoated with itself, by spray only, after the minimum times shown 														
<p>Health & Safety</p>	<p>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.</p>														

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