

Modified Vinyl Primer/Finish for Galvanising

(previously *Stokes Modified Vinyl*)

Product Description	A one coat* vinyl anticorrosive primer/finish for galvanising.			
Features & Use	<ul style="list-style-type: none"> • Where a one coat*, sheen primer/finish is required • Can be applied to degreased new galvanising without the need for an etch primer • Use for gates, fences, street furniture and structural steelwork • Contains zinc phosphate anticorrosive pigmentation • Resistant to weak acids and alkalis • Highly moisture resistant • Available in a wide colour range 			
Approvals/ Certification	Please consult Axalta Coating Systems			
Finish	Sheen			
Volume Solids	35 ± 6% (varies considerably with colour)			
VOC Content	545 ± 54 g/litre (varies considerably with colour)			
Film Thickness Range And Coverage		Dry Film Thickness	Wet Film Thickness	Theoretical Coverage
	Typical	50 µm	143 µm	7.0 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 50 microns DFT	+10°C	+23°C	+35°C
	Dust Free	2 hr	1 hr	30 min
	Hard Dry	30 hr	24 hr	12 hr
	Overcoating	Minimum	6 hr	3 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			
Colours	Black (IP197), White (IP173), Moss Green (IP174), MIO Silver (IP195), MIO Black (IP196), RAL7033 Grey (MV930) and tinted range (MV)			
Product Code	20MVP, 20MVT and 20HBV			
SG	1.33 ± 0.27 kg/lit (varies considerably 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 Galvanising: thoroughly degrease and lightly abrade any very shiny areas Steelwork: Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns maximum 				
<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 General Industrial TH004 (formerly called No.7 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>	<p>Method</p>	<p>Airless Spray</p>	<p>Conventional Spray</p>	<p>Brush</p>	<p>Roller</p>
	<ul style="list-style-type: none"> Airless Spray: Output fluid pressure at tip 2000 psi, Tip Size 13-17 thou (0.33-0.43 mm), some thinning may be required Conventional spray – not recommended, as considerable thinning would be required for suitable atomisation and build would be greatly reduced Application by brush – supplied ready for use 	<p>Yes</p>	<p>No</p>	<p>Yes</p>	<p>No</p>
<p>Product Notes</p>	<ul style="list-style-type: none"> 2 coats at 50µm per coat are recommended for bare steel (i.e. non-galvanised), for galvanised surfaces with a degree of roughness, and where extended protection is required When applied to bare steel (i.e. non-galvanised): in common with most single pack primers and primer/finishes, this product is not recommended for extended exterior exposure, or exposure in aggressive or coastal locations, or for immersion. Epoxy primers are preferred for these conditions, please consult Axalta Coating Systems for advice Do not use for temperatures above 60°C *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 				
<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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