

PR30B Etch Primer

TECHNICAL DATA SHEET

Product Description

PR30B is a two pack chromated etch primer, suitable for use as a pretreatment primer coat. PR30B promotes excellent adhesion between epoxy and polyurethane primers and a variety of light alloys and steel.

- Alternative pretreatment to chemical conversion coatings
- Good corrosion resistance
- Phenolic modified for excellent water resistance
- Used to reactivate aged anodized or chromated surfaces

Components



Mix Ratio (by volume)

- | | |
|------------------------------|----------|
| • PR30B (Base) | 1 part |
| • TH34B (Acid Catalyst) | 1 part |
| • T105 (Thinner) anti chill | 0.1 part |
| OR | |
| • T112 (Thinner) general use | 0.1 part |

Specifications



PR30B is qualified to:

- BS2X32A+B
- MSRR 9064

Product Compatibility

PR30B is compatible with the following primer specifications:

- BS2X33A+B
- Def Stan 80-206
- Def Stan 80-207

Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.

Surface Preparation and Pretreatment



Ensure the surface is clean, dry and intact using a high performance solvent cleaner - DeSoto® CN20 or Desoclean™ 45 solvent cleaner are recommended.

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Instructions for Use



Ensure all mixing and measuring containers to be used are clean. Stir the base component thoroughly to fully incorporate any slight settlement. Mix base with acid catalyst then add thinner as required. When mixed PR30B is ready for use once induction period has been observed.

Note: All products and components should be placed in ambient conditions of 15-30°C (59-86°F) for at least 24 hours prior to mixing and application.



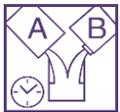
Induction Time:

15-30 minutes



Viscosity: (23°C/73°F)

Apply as mixed



Pot Life:

4 hours @ 15-35°C (59-95°F)

Application Guidelines

Recommended Application Conditions:

Temperature	15 - 35°C (59 - 95°F)
Relative Humidity	30 - 85%

Application:

Apply a light wet closed film to achieve a dry film thickness of 4 - 8 µm. The applied coating should be an iridescent yellow / golden colour.



Note: Over application / excessive film build of product will result in a dark brown discolouration of the dry film.



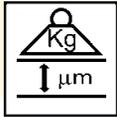
Theoretical Coverage: (ready for use)

11 m² /Lt @ 6 µm dry film thickness
440 ft/US gal @ 0.24 mil dry film thickness

Recommended Dry Film Thickness:

4 - 8 µm
0.16 - 0.32 mil

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Dry Film Density:

1.6 g/cm³
13 lbs./US gal

Dry Film Weight:

10 g/m² @ 6 µm dry film thickness
0.002 lbs/ft² @ 0.24 mil dry film thickness

Note: These application guidelines represent PPG's best advice for usage in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.

Equipment:

PR30B is compatible with most types of current spray equipment, but is NOT suitable for application with electrostatic spray equipment.



Equipment Type	Tip Size	Pressure
Airmix	9 to 11 thou	44 to 73 psi (3 to 5 bar)
HVLP Air Spray	1.2 to 1.6 mm	
Conventional Air Spray	1.2 to 2.2 mm	
Airless	9 to 11 thou	1450 to 1885 psi (100 to 130 bar)
Air-assisted Electrostatic	Not Recommended	
Low Pressure Electrostatic	Not Recommended	

Equipment Cleaning:

Clean spray equipment before use and as soon as possible after use. DeSoto® CN20, CN44 or Desoclean™ 45 solvent cleaners are recommended.

Physical Properties



Colour:

Yellow



Gloss:

≤ 20 units with a 60° gloss meter

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DRYING TIMES @ 23°C (73°F) 75% R.H.	
Dry to Touch	20 minutes
Dry to Handle	45 minutes
Dry to Overcoat	1 to 24 hours
Dry to Mask	2 hours
Full Cure	7 days

Note: Drying times listed above are dependent upon film thickness applied, air flow conditions and application technique.

Force Drying:

PR30B should not be force dried at temperatures above 60°C (140°F) unless already overcoated with another product.



VOC: (ASTM)

Mixed ready for use	770 g/Lt
PR30B Base Component	710 g/Lt
TH34B Acid Catalyst	810 g/Lt
T105 Thinner	940 g/Lt
T112 Thinner	800 g/Lt



Flash Point:

PR30B Base Component	-4°C (25°F)
TH34B Acid Catalyst	-4°C (25°F)
T105 Thinner	40°C (104°F)
T112 Thinner	-5°C (23°F)

Shelf Life:

PR30B Base Component	24 months in original unopened container
TH34B Acid Catalyst	24 months in original unopened container
T105 & T112 Thinners	10 years in original unopened container

Note: Shelf life may vary due to OEM specification requirements. Refer to container label for specific shelf life information.

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

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Storage Recommendations



Inspect the condition of the container to ensure compliance. The material should be stored at temperatures between 5°C to 35°C (41°F to 95°F) to ensure shelf life.

Note: When procuring to a qualified material specification, follow those storage instructions.



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Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call the local PPG office at the numbers listed below:

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