

P/N:

N/A

DESIGNATION

N/A

Prepared by: Marta Guerrero Ramos

Date: 28-04-2010

Aproved by:

Date: 09-06-2010

DESCRIPTION:

PREPARATION AND APPLICATION OF PRIMER P05 (IFMA 195, IFMA 389, IFMA 310)

Verify compliance with the ambient conditions in the storage room and paint mixing. And verify that the shelf life of material hasn't expired.

**Temperature: 10°C-30°C**  
**Relative humidity: 40%-70%**

The door of the paint preparation box should be closed. Check that the cooling and ventilation systems of the paint box are working.

Proportions by **VOLUME**

Agitate mixture, during 2min to 5min. Allow the mixture to settle for a minimum 30minutes.

		By volume
Base resin:	7835 NV	1
Catalyst :	7835 NV	1

Before open the base container agitate vigorously.

It s an obligation wear latex gloves and mask during the preparation of the

Stir the paint to remove the solid sediment that might be formed

Add thinner **7928** to get the right viscosity with Afnor Cup nº 4:

temperatura	15°C	20°C	25°C	30°C
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"Pot life" of mixture is 8 hours maximum, after mixture.

Clean the cover and the seating area to close.

The time of mixing and the lifetime should be reported on all pots.

The mixture must be rejected when their "Pot life" has expired.

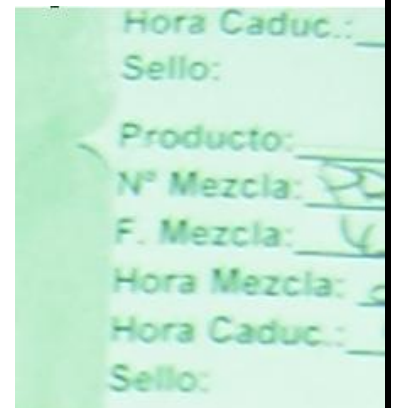


Fill out all data required in Mixing Register:

- a) Mixing number
- b) Paint Type
- c) Batch number
- d) Batch expiry date
- e) Mix ratio
- f) Date / time of mixing
- g) Pot life expiry time
- h) Relative humidity
- i) Temperature
- j) Maturing time of paint
- k) Viscosity
- l) Operator number or operator name

Each pot of mixed material shall be identified with:

- a) Product
- b) Mixing number
- c) Date of mixing
- d) Time of mixing
- e) Pot life expiry time
- f) Seal



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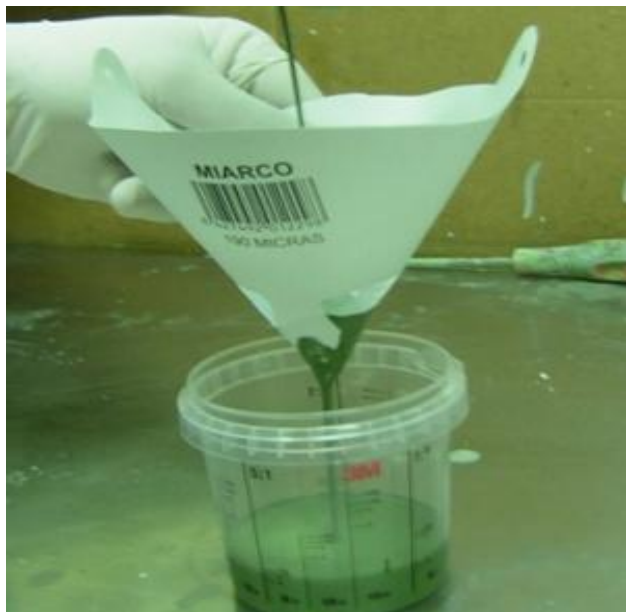
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DESCRIPTION:

PREPARATION AND APPLICATION OF PRIMER P05 (IFMA 195, IFMA 389, IFMA 310)

Before application, it is highly advised to  
**filter the mixing.**



Fill out all data required in Application Register:

- a) Mixing number
- b) Date / Time of application start
- c) Product
- d) Touch-up
- e) Paint type
- f) Relative Humidity
- g) Temperature
- h) End time of application
- i) Time of application start drying
- j) End time of application drying
- k) Drying temperature
- l) Operators (painter) sign
- m) Verification of thickness and paint adhesion
- n) inspectors

Apply the mixture in one coat, i.e. 2 crossed films (1 vertical pass, 1 horizontal pass)

Thickness of dry film is about 12 to 20microns for one coat.

Aplication is done with nozzle diameter between 1.4mm and 1.6mm, air pressure: 1,5 to 2bars.

**Driying conditions:**

Dust dry at ambient temperature :

15 min

Fast to handling and drying time between coats at ambient temperature:

1hour

Dry at 60°C 5°C

30min

**Curing:**

Temperature holding time:

30minute (+ 5minutes, - 0)

Curing at 60°C 5°C

2h30min ( - 10°C )

Each month three specimens must be prepared acording G6-SP-008 to be subject to the followwing tests:

- a) Visual inspection
- b) Measure thickness
- c) Dry adhesive test