

DESCRIPTION

Sun/Charge Primers are a fast drying chain stopped alkyd primer for general industrial use on steel either as a shop coat or as the primer for Sun/Charge Electrostatic Enamel Finishes. Sun/Charge primers are formulated specifically for electrostatic application by a Ransburg #2 hand gun. Sun/Charge primers need to be tested by the end user if top coating with other than Sunburst Coatings finishes.

ADVANTAGES

- VOC 3.33 lb/gal (400 g/l)
- Polarity adjusted for application with a Ransburg #2 Gun
- Viscosity adjusted for application with a Ransburg #2 Gun
- Fast air drying
- Excellent corrosion resistance
- Excellent adhesion to metal, both cold and hot rolled steel
- Free of lead and chromate hazards
- Application by various spray methods
- Recoat/Topcoat window up to 1 year

SURFACE PREPARATION

Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties.

New Galvanized Steel: Do not use Sun/Charge.

Aged Galvanized Steel: Do not use Sun/Charge.

Non-Ferrous Metals: Do not use Sun/Charge

Steel or Iron: Remove rust, mill scale, and oxidation using power tool or brush blasting.

Testing: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.

Product Limitations:

- Package stability is 12 months. Indoor storage at 50-90°F is recommended.
- Do not spray at air temperatures below 50°F.
- Heavier film thickness will give slower dry time and higher sheen. Follow recommended film thickness for optimum performance.

APPLICATION

MIXING:

Stir well before use.
Do not thin or add other solvents.
Primers contain inert pigments which can settle.

APPLICATION TEMPERATURE:

Substrate temperature between 55 to 100° F
Product temperature between 75 to 90° F

APPLICATION EQUIPMENT

Electrostatic Spray:

Ransburg #2 hand gun
Reduction: none

Conventional Spray:

Binks #7 gun with 36 x 36SD air cap
Reduction: none

Note: Use oil & water extractor in air line per manufactures instructions. Drain daily or more often as needed especially in area or period of high humidity.

Airless Spray:

Pressure: 1800-2300 psi
Tip: 0.13
Reduction: none

HVLP: (Mach I)

Air Pressure: 70-90 psi
Fluid Pressure: 3-10 psi
Fluid nozzle: #94 (.055")
Reduction: none

Thinning: Do Not Thin

CLEAN-UP

Clean with Lacquer Thinner or Xylene. Follow manufacturer's safety recommendations when using any solvent.

CHARACTERISTICS

GLOSS: matte flat

COLORS: Red Oxide (48R), Gray (48F2)

SOLIDS BY WEIGHT: 55 ± 2% (may vary by color)

SOLIDS BY VOLUME: 39 ± 2% (may vary by color)

VISCOSITY

30-35 seconds using a EZ Zahn #2 viscosity cup

RECOMMENDED FILM THICKNESS

Mils wet: 2.4 – 3.6

Applications, greater than 6 mils, paint will run

Mils dry: 1.0 – 1.5

RECOMMENDED SPREADING RATE: (no application loss)

@ 1 mil dft: 576 sq ft/gal

DRYING SCHEDULE: 1.0 mils dft, 77°F, 50% RH:

To touch: 30 minutes

To handle: 60 minutes

Tack free: 30 minutes

To recoat: overnight

NOTE: Good air movement and humidity control are necessary for proper drying of alkyd coatings. Coating millage and substrate temperature effect the above drying schedule. Please contact your salesman if you are unsure how environmental conditions may affect your results.

FLASH POINT: 00° F

WEIGHT PER GALLON:

9.81 lbs/gal +/-, varies by color

PACKAGE LIFE:

1 year, unopened

PERFORMANCE TESTS

Salt Spray Test

ASTM B117: 250 hours

VOC

COATING VOC: 3.33 #/gal or 400 g/l

This is an “artificial” VOC computation that the EPA and AQMD use to regulate paints and coatings that contain either water or exempt solvents. The *COATING VOC* is sometimes called the *Regulatory VOC*, and this is the VOC that air quality districts use to determine whether or not the paint is in compliance with the limits set by a rule.

MATERIAL VOC: 3.33 #/gal or 400 g/l

This is the *actual or real amount of VOC that a gallon of paint contains*. Always use the MATERIAL VOC to calculate actual VOC emissions.

STORAGE

FLAMMABLE LIQUID

Use All Appropriate Cautions for Storage and Handling.

WINTER:

Store inside a building, preferably with heat to maintain a climate of no less than 50° F. If stored outside, protect with blanket material and store under canopy if possible.

SUMMER:

PROTECT FROM EXTREME HEAT:

Store inside a building or under canopy to prevent direct sunlight exposure. Extreme heat will increase flammability.

MIXING:

Stir well before use.

Primers contain inert pigments which can settle.

CAUTIONS

Do not apply product to exposed steel if threat of rain is imminent.

Thoroughly review product label for safety and cautions prior to using this product. A Safety Data Sheet is available from our web site or your local Sunburst Coatings Distributor. Please direct any questions or comments to your local Sunburst Coatings Distributor.

Note: The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable.

Note: Sunburst Coatings believes the technical data presented in this bulletin is currently accurate: however, no guarantee of accuracy, comprehensiveness, or performance is given or implied. Improvements in coatings technology may cause future technical data to vary from what is in this bulletin. For complete, up-to-date information visit our web site or contact your local Sunburst Coatings Distributor.

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