



**TECHNICAL DATA SHEET**

**AMBER STOVING PRIMER**

<b>PRODUCT DESCRIPTION</b>	A high quality, alkyd-melamine formaldehyde based industrial stoving primer. It gives a tough and flexible film with excellent adhesion and corrosion resistance to metal surfaces
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<b>RECOMMENDED USES</b>	Primer for metal surfaces, for use on equipments, vehicle repaint and domestic appliances. It is to be overcoated with Amber Stoving Enamel for better performances.
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**TECHNICAL DATA**

<b>COLOUR, DRY FILM</b>	White and Off white
<b>FINISH, DRY FILM</b>	Smooth / Matt
<b>VOLUME SOLIDS (ASTM D2697)</b>	54 ± 2%
<b>SPECIFIC GRAVITY</b>	1.40 ± 0.05
<b>THEORETICAL SPREADING</b>	13.5 – 10.8 M2 /LTR
<b>RECOMMENDED DFT (DRY FILM)</b>	40 – 50 Microns/Coat
<b>RECOMMENDED WFT (WET FILM)</b>	75 – 95 Microns/Coat
<b>FLASH POINT</b>	32°C
<b>FLEXIBILITY</b>	Good

**DRYING TIME**

Stoving schedule may affect the drying time as well as dry film properties.	
<b>STOVING SCHEDULE</b>	120°C for 30 minutes (OR) 130°C for 20 minutes (OR) 150°C for 15 minutes
<b>FLASH OFF</b>	10 – 15 minutes



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### ADVANTAGES

<b>AMBER STOVING PRIMER</b>	Dry film is tough and flexible, with excellent adhesion and corrosion resistance to metal surfaces.
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### APPLICATION INSTRUCTION

<b>SURFACE PREPARATION</b>	<p><u>New Steel:</u> All surfaces to be coated should be clean, dry and free from any contamination. Oil and grease should be removed by solvent cleaning as per SSPC-SP1. Abrasive blast cleaning to Sa 2.5 or mechanical cleaning using hand/power tool to minimum of St 2 standard should be done.</p> <p><u>Repair/Maintenance:</u> Existing paints system should be dry and free from salt and other contaminants. Corroded and/or damaged areas should be blast cleaned to Sa 2 or power tool cleaned to St 3.</p>
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### APPLICATION DATA

<b>APPLICATION METHOD</b>	Conventional spray
<b>CLEANING/THINNING</b>	Amber Stoving Thinner
<b>THINNER (VOLUME)</b>	5 – 10%
<b>CONV. SPRAY REQUIREMENTS</b>	Atomizing Pressure : 50 psi
<b>AIRLESS SPRAY REQUIREMENTS</b>	Not applicable
<b>NOZZLE SIZE</b>	Not applicable
<b>MIXING RATIO (BY VOLUME)</b>	Not applicable
<b>POT LIFE @ 30°C (100 ml)</b>	Not applicable

### SYSTEM

<b>RECOMMENDED SYSTEM</b>	No. of Coats x DFT (Microns)	
	Amber Stoving Primer	1 x 40
	Amber Stoving Enamel	1 x 40
To be applied on prepared surface.		



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### ADDITIONAL DATA

<b>SHELF LIFE @ 30°C</b>	6 months, in original sealed container, with proper storage conditions.
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### HEALTH & SAFETY

<b>SAFETY PRECAUTIONS</b>	<p>As a general rule, avoid skin and eye contact by wearing overalls, gloves, goggles, and airmask etc. Spillage on skin should immediately be removed by thorough washing with water and soap or suitable cleaner. Eye should be flushed with fresh water. Avoid inhalation of vapours and paint mist by wearing suitable airmask. In the event of ingestion and eye contact, seek medical attention immediately. Painting must be carried out in well-ventilated area. This as industrial product, contains flammable materials and should be kept away from the sparks and open flames, smoking in the area should not be permitted. Local safety regulations should be followed.</p>
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### STORAGE & HANDLING

<b>STORAGE</b>	<p>Store the paint in proper storage conditions as per the local regulations. Keep the paint container in sealed condition under shed, away from direct sunlight and extreme temperatures. Do not stock paint material near to any ignition sources. Do not put back the half or unused material back in original container, containing the supplied paint, to avoid contamination. Handle with care. Stir well before use.</p>
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