



Technical Data

PRODUCT DESCRIPTION

A high performance, high solids, two component urethane primer system formulated to provide excellent gloss holdout, adhesion and chip resistance when applied over steel, aluminum or fiberglass materials. VOC compliant.

INTENDED USES

Designed as a primer for Original Equipment Manufacturers and for over-the-road equipment and transportation vehicles such as tanker trucks, trailers and agricultural equipment. NOT INTENDED FOR IMMERSION SERVICE.

PHYSICAL PROPERTIES

Color (Part A)	White PG-1236, Off White PG-0239, Buff Yellow PG-3235, Gray PG-0255, Red Oxide PG-5238, Black PG-9237
Cure (Part B)	PG-0231
Finish/Sheen	25 - 35 @ 60°
Resin Type	Urethane
Reduction Solvents	Butyl Acetate or Toluol
Clean-up Solvents	Butyl Acetate or Ketones
Solids By Weight	72%
Solids by Volume	53%
Theoretical Coverage**	850 ft ² /gal @ 1 mil
Dry Film Thickness / Coat	1 - 2 mils (25 - 50 microns) above surface profile
Wet Film to Achieve DFT	3 - 4 mils (75 - 100 microns) Apply in 2 medium build coats.
Coverage at DFT**	425 - 850 ft ² /gal @ 1 - 2 mils DFT
VOC's	3.5 lbs./gal. (420 grams/liter)
Induction Time	None required
Mixing Ratio (by volume)	6 parts resin to 1 part cure. Product packaged in pre-measured kits.
Thinning	May be necessary for conventional air spray.
Pot Life	At 77°F (21°C) - 12 hours (approximate)
Drying Time* (hours) [ASTM D 1640]	<u>At 77°F (21°C)</u> Tack Free - 15 to 30 minutes Recoat Time - Min. - 15 to 30 minutes Recoat Time - Max. - 72 hours

* Dry times vary with surface temperature, air movement, humidity and film thickness. Stratum can be force dried to desired hardness at 160°F. After 72 hours or force drying, Stratum will need to be thoroughly scuff sanded to insure inter coat adhesion.

** Coverage rates are estimates based on the product volume solids and make no allowance for material loss during application. Actual spread rates may vary dependent on applicator experience, surface porosity and texture.

RECOMMENDED SYSTEMS

Stratum Urethane Primer/Pinnacle 330HS
Stratum Urethane Primer/Pinnacle 460

SURFACE PREPARATION

The service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits, that would interfere with new coating adhesion. Surfaces must be properly prepared prior to application of this product.

Ferrous Metal and Previously Painted Metal Surfaces:

Power or hand washing is recommended to remove contamination prior to sandblasting. If oil or grease is present, use of a cleaner/degreaser is required. All cleaning residue must be completely rinsed from the surface. Allow to dry. For new steel and removal of old coating on previously coated steel, abrasive blast according to SSPC-SP-6 commercial blast. Use proper abrasive to achieve an average of 1.5 to 2 mil profile. Blasted surfaces should be primed before flash rusting occurs. Treat rust free, cold rolled steel with a metal cleaning and etching solution.

APPLICATION

Part A and part B are packaged in pre-measured kits. The mixing ratio is 6 parts A to 1 part B. Thoroughly mix Part B into Part A using an explosion-proof power drill and Jiffler mixer to disperse pigments. The material must be applied within the estimated pot life. For optimum application, air and surface temperatures should be from 50° to 90°F (10° to 32°C) and at least 5° F (3° C) above the dew point. Above 122°F (50°C), sagging may occur.

Conventional Spray:

For conventional air spray, some reduction may be necessary. Thin with Butyl Acetate or Toluol. Pressures are dependent on the type of gun and fluid nozzle. Typical pressures will be in the 45 - 60lb range for proper atomization.

Airless Spray:

Flush airless lines with Butle Acetate or Ketones. Equipment must be clean prior to start. Apply a wet coat in even, parallel passes with 50 % overlap to avoid bare areas and pinholes. If required, cross spray at right angles. No reduction is necessary. Adjust pressures accordingly for best atomization and transfer efficiencies.

<i>Tip Orifice</i>	<i>Atomizing Pressure</i>	<i>Mat'l Hose ID</i>	<i>Manifold Filter</i>
0.011" to 0.017"	2500-3000 psi	1/4"	60 mesh

PERFORMANCE CRITERIA

Gravel-o-meter:

Method: ASTM D-3170
Substrate: B-1000 panels
System: Stratum, one coat at 1.0 - 1.3 mils DFT
Requirements: 4A Excellent (SAE J400)

Salt Spray:

Method: ASTM B-117
Substrate: B-1000 panels
System: Stratum, one coat at 1.0 - 1.3 mils DFT
Requirements: 500 hours - less than 1 mm creep

Fluid Immersion:

Method: ASTM D-870
Substrate: B-1000 panels
System: Stratum, one coat at 1.0 - 1.3 mils DFT
Requirements: #2 Diesel 500 hours - no corrosion or blistering
1OW30 Oil 500 hours - no corrosion or blistering
Water 500 hours - no corrosion or blistering

PACKAGING

<i>1 gallon kit</i>	<i>5 gallon kit</i>
Part A - 1 Gallon (3/4 filled)	Part A - 5 Gallon (3 gallons filled)
Part B - 1 Pint (full filled)	Part B - 1/2 gallon (full filled)

SAFETY PRECAUTIONS

When blended, contains aliphatic polyisocyanate, hexamethylene diisocyanate and butyl acetate. Avoid contact with skin. Vapor and spray mist harmful. Use proper respiratory protection including positive air supplied respirators. Refer to the MSDS sheet for specific information.

LIMITED WARRANTY

The technical data and suggestions for use contained in this document are true and correct to the best of our knowledge at the date of issuance. The statements of this document do not constitute a warranty, expressed or implied, as to the performance of these products. Since Diamond Vogel Paints does not control the application of its products, or the condition of the surfaces to which they are applied, Diamond Vogel Paint's liability will under no circumstances exceed replacement of the product. **All technical information is subject to change without notice.**

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