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## PRODUCT NAME

**Synergy® One Pack Etch Primer**  
 TECHNICAL DATASHEET

Issue date 12/06/2002

Formula number 3100 Series

## PRODUCT DESCRIPTION

### PACKAGING

1, 2.5, 5 litre tins, 25 and 200 litre drums.

### PRODUCT FUNCTION

Synergy® 1 PACK ETCH PRIMERS are anti-corrosive, quick drying, metal etching primers offering excellent adhesion onto non-ferrous metals. Whereas most non-ferrous metal primers are sprayed, Synergy® 1 PACK ETCH PRIMERS have the advantage of being suitable for either brush or spray application, they can be overcoated with most topcoat and intermediate priming/build systems.

## TECHNICAL INFORMATION

<b>Solids</b>	Approximately 30% dependent on colour
<b>Flashpoint</b>	Below 22°C
<b>Specific Gravity</b>	0.80 to 0.90 approximately dependent on colour
<b>Viscosity</b>	60 seconds B4 Ford Cup
<b>Temp Resistance</b>	180°C
<b>Storage</b>	12 months in original sealed containers
<b>Flash off period</b>	5 minutes

## APPLICATION AND USAGE DATA

<b>Touch dry</b>	5-10 minutes
<b>Firm dry</b>	30 minutes
<b>Hard dry</b>	1 hour
<b>Thinners</b>	thinmulti
<b>Overcoating</b>	24 hours
<b>Eqp. cleaning</b>	GUNCLEANER 302
<b>Film thickness</b>	20 microns WFT gives approximately 7-12 microns DFT
<b>Coverage</b>	15 square metres per litre (theoretical)
<b>VOC</b>	716g/l

## COLOUR RANGE

Grey/Black/White. Clear is available in batch sizes only (500litres).

## SPECIAL PROPERTIES

- Outstanding adherence to difficult metal substrates.
- Mild rust neutralization/conversion.
- Good anti-corrosion barrier (First coat of a system).

**Technical Data Sheets are also available on our website at [www.hmgcoatings.co.uk](http://www.hmgcoatings.co.uk)**

ALL MATERIALS SHOULD BE STIRRED AND CHECKED FOR COLOUR AND SHEEN BEFORE USE. NO CLAIMS FOR DISCREPANCY OF COLOUR OR GLOSS CAN BE ACCEPTED AFTER USE. INFORMATION CONTAINED ON THIS DATA SHEET IS TO THE BEST OF OUR KNOWLEDGE TRUE AND ACCURATE AND IS GIVEN IN GOOD FAITH, BUT WITHOUT WARRANTY, SINCE THE APPLICATION, USE AND PROCESSING OF THE PRODUCT IS BEYOND OUR CONTROL.



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## PREPARATION

Surfaces must be thoroughly clean, dry, free from millscale, rust, oil, grease or other contaminants. Degrease using Synergy® L.T. Degreasing Solvent. Best results will be obtained by abrading the substrate - preferably shot blasting.

## HOW TO USE

- |  |   |  |   |
|--|---|--|---|
| <input checked="" type="checkbox"/> Airless            | <input checked="" type="checkbox"/> Brush   | <input type="checkbox"/> Electrostatic     | <input checked="" type="checkbox"/> HVLP      |
| <input checked="" type="checkbox"/> Conventional spray | <input checked="" type="checkbox"/> Dipping | <input checked="" type="checkbox"/> Roller | <input type="checkbox"/> See application data |

## APPLICATION

Synergy® 1 PACK ETCH PRIMERS can be used on most bare metals after thorough cleaning and degreasing. They are applied by brush or airless spray, without the addition of thinners, or by conventional/HVLP spray with up to 20% HMG Etch Thinners.

## HEALTH AND SAFETY

- Refer to health and safety data sheet and tin label prior to use.
- The product contains zinc chromate and can cause cancer as a result of ingestion or inhalation.

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