

PRODUCT DATA SHEET

PT-545 ZINC-MOLYBDATE PRIMER PT-545 PRIMER SERIES

DESCRIPTION

PT-545 is a low VOC, chromate free, zinc-molybdate air dry primer intended for use as a corrosion inhibiting primer on metal surfaces. It is particularly useful in the marine industry. It can also be used as an undercoat for enamels and is also suitable as an after-blast or after pickling primer for plating.

COLORS

This coating can be provided in Yellow.

COATING PROPERTIES & CHARACTERISTICS

Reducer	Acetone
Recommended Dry Film Thickness	0.6 – 0.9 mil
Spray Viscosity	14 seconds, max #4 Ford
Coatings VOC	324 grams per liter
Specification	TT-P-645B

SHELF LIFE

Shelf life is only applicable for materials stored in unopened and undamaged original factory filled containers. 1 year when stored between 50°-85° Fahrenheit.

SURFACE PREPARATION INSTRUCTIONS

ALL SURFACES: Remove all dirt, grease, oil, salt and chemical contaminants by washing the surface with PTC-2002 or GTS-2000 0 VOC Cleaners/Degreasers or other suitable detergent cleaner/ degreaser. Then rinse thoroughly with water. If you wish to use solvents PTI recommends IPA, Acetone or MEK. Rinse thoroughly with fresh water and allow to fully dry. Remove all remaining dust and debris by lightly wiping the surface with a tack rag or cheese cloth. All surfaces must be dry at time of application.

STEEL: Hand tool (SSPC-SP-2) or power tool (SSPC-SP-3) clean to remove all loose rust, mill scale, and deteriorated previous coatings. Abrasive blasting to a minimum Commercial Grade (SSPC-SP-6, NACE 3) with a 1–2 mil (25–50µ) surface profile is recommended for optimal performance. Abrasive blast cleaned steel requires two coats of primer. Scuff the surface with scotch bright pads.

- For additional protection apply PTI's Acid Etch Primer prior to the PT-545 Primer.

MIXING INSTRUCTIONS

Mix the paint on a shaker for 5 – 10 minutes for optimal results.

The product is formulated so that thinning is **not** normally required.

1. If you are thinning this primer, do not thin more than 1 part primer to 1 part acetone.
2. Thinning with 4 parts primer to 1part acetone.

PRODUCT DATA SHEET

APPLICATION

This product can be applied using a brush, conventional spray equipment or HVLP spray system. Please consult with a PTI representative for specific equipment recommendations and settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix both paint and reducer thoroughly and filter/strain before spray application.
NOTE: It is not recommended to strain flat/matte coatings.
3. HVLP Spray Pressure: 7-10psi
4. Always air-blow and tack wipe the surfaces to be painted. Aircraft should be grounded to prevent static.
5. Best application results: apply 2 coats: 1 fog/tack coat & 1 full coat from 0.6 – 0.9 mil thickness.
6. Recommended Dry Film Thickness is 0.6-0.9 mils.

NOTE: Application of PTI products requires the use of all OSHA approved safety equipment, including proper ventilation. Additionally, PTI products require the recommended temperature/humidity conditions and film thickness ranges for optimal performance. The material, hangar, and aircraft skin temperatures should be no lower than 75° F / 25° C before, during and after application.

DRYING & CURING SCHEDULE

Dry times are based on the dry film thickness between 0.6 - 0.9 mils (25-50 microns).

Air Dry:

Allow applied coating to dry for at least 6 hours before apply a top coat. Primer dries dust free in 6 hours and dries hard in 8 hours.

EQUIPMENT CLEANUP

Use clean Acetone. Do not allow material to dry or cure inside any equipment.

HEALTH, SAFETY, & STORAGE REQUIREMENTS

Refer to each individual material SDS (Safety Data Sheet) for specific requirements on the health, safety, storage and handling requirements. Follow all local, state, and national regulations during surface preparation, material application and cleanup.

PRODUCT INFORMATION & DISCLAIMER

Product Data Sheets are periodically updated to reflect new information. It is important to use the latest and most recent revision for the product being used. The foregoing information is accurate to the best of our knowledge. However, due to differences in customer handling, use and method of application which are not known and are beyond our control, Products Techniques, Inc. makes no warranties as to the end result.