

PRODUCT DATA SHEET

PT-402 ACID ETCHING PRIMER PTI PRIMER SERIES

DESCRIPTION

PT-402 Acid Etching Primer is a polyvinyl butyral zinc chromate formulation that may be used to prime all plain or plated metallic surfaces. Priming surfaces with PT-402 Acid Etching Primer **prior to priming with epoxy primer MIL-PRF-23377** or by itself will ensure maximum adhesion and protection of all bake or air-dry finish coats (including lacquer finish coats). The finely ground emulsions of zinc chromate pigments, resins and phosphoric acid hardeners are virtually non-settling. Once applied, the Acid Etching Primer requires no sanding and has a pot life of 8 hours. Extreme humidity can affect the bonding of the coating.

SPECIFICATIONS

- DOD-P-15328D
- MIL-C-8514C

COLORS

This coating can be provided Yellow and Green.

COATING PROPERTIES & CHARACTERISTICS

Mix Ratio, by volume	4 part Base to 1 part Catalyst by volume
Reducer	PTI-1045 reduce, 1 part paint to 2 – 3 parts reducer
Recommended Dry Film Thickness	0.2 mil
Admixed Viscosity	14 seconds, max #4 Ford
Admixed Weight per Gallon	11.5 lbs.
Theoretical Coverage	1600 sq. ft. ² /gal.
Pot Life	8 hours
Coatings VOC	Below 340 g/L

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

- Scuff the surface with scotch bright pads.
- Dust off the surface with an air hose and wand.
- Wipe of the substrate with IPA or Acetone to remove grime and oils
- Remove all remaining dust and debris by lightly wiping the substrate with a tack or “cheese” cloth

MIXING INSTRUCTIONS

Shake component A in a paint shaker for 5 – 10 minutes for optimal results.
Admix by volume:

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1. Stir or shake both component "A" and "B" well before mixing
2. Add 4 parts of Component "A" to 1 part of Component "B" by volume and stir thoroughly. Stir each well before mixing.
3. Reduce with PT-1045. Dilution ratio is 1 part admixed primer to 2 – 3 parts PT-1045.
4. Mix only an amount that can be used in one day.

APPLICATION

This product can be applied using conventional air spray equipment, 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 base and catalyst thoroughly and filter/strain before spray application.
3. HVLP Spray Pressure: 7-10psi. Conventional spray equipment 15-30psi
4. Always air-blow and tack wipe the surfaces to be painted. Aircraft should be grounded to prevent static.
5. Best application results: apply 1 fog/tack coat at 0.2 mil thickness.
6. Recommended Dry Film Thickness is 0.2 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 of 0.2 mils (25-50 microns).

Air Dry:

Allow applied coating to dry for at least 15 minutes before painting over it.

EQUIPMENT CLEANUP

Use clean PTI-1045 Reducer. 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.