TECHNICAL DATA SHEET

SETAPRIMER 255

CONVERSION VARNISH PRIMER

DESCRIPTION

SETAPRIMER 255 is a high-volume solid, two component, solvent borne primer for interior woodwork. This fast-drying primer has excellent sandability and good build. It has extremely good coverage and provides good hold-out of the top coat. Typical applications include kitchen cabinets, vanities, chairs, office as well as other interior wood applications. Available in HAPS free version.

PRODUCT DATA

Color	N/A	**VOC less exempts**	365.82 g/L	3.05 lb/gal
Solids % by Vol	50% ± 2%	**VOC regulatory**	445.66 g/L	3.72 lb/gal
Solids %by Wt	61% ± 2%	**Photochemical reactive**	No	
Density	1.24	**Flash Point (PM/CC)**	N/A	
Viscosity 23°C/73°F #4 Ford	N/A	**Shelf life**	6 months (at 15-25°C/59-77°F)	
Gloss(On Black glass @60°)	Flat	**Theo-coverage @1 mil dry**	830-840 Sq.Ft/gal	16-17 m^2/L

PREPARATION/APPLICATION

Working Temp >18°C/65°F surface, coating and air

Catalyzation 10 % by volume using C A72 Catalyst- 10 parts SETAPRIMER 255 to 1 part C A72 catalyst

Pot life 24 hours (23°C/74°F)

Reducer Reduce 15-35% by volume with DX 180 THINNER (Medium), DX 195 THINNER (slow).
To help reduce trapped air, blushing or orange peel, use Retarder LR236 at a maximum of 5%.by volume

Film thickness Min 4 mil wet –Max 5 mil wet.

Suggested Topcoat SETAFLEX 540.WHITE, DIAMOS 420 WHITE

Application

- Apply 1 coat of catalyzed primer at 4.0 - 5.0 mils wet. Allow to dry for sanding. A second coat of Surfacer may be applied after sanding if needed for additional filling. Sand again before topcoating.
- Sand with 320-grit paper and remove all sanding dust. If a wet look is desired, sand final primer coat with 500-600 grit paper. Topcoat within 8 hours of sanding.
- Topcoat with recommended Topcoat
- Do not exceed 7.0 mils DFT for the total system.

Surface Preparation Wood surface must be clean, dry, free of grease and oil and finish sanded with 180 grit sandpaper to ensure optimum adhesion and coating performance properties. Moisture content of the wood should be between 6%-8%.

Use Directions For interior use only. Catalyze, adjust viscosity and stir thoroughly before application to avoid variations application. Dry time can be directly impacted by many factors, including film thickness. Users are urged to test the system under shop conditions.

App equip. Conventional & HVLP Siphon Feed, Pressure Pot Systems and Airless/Air Assist Equipment.

Tinting Can be tinted up to 5% maximum with universal colorants 844.

Cleanup Clean tools/equipment immediately after use with T750 LORCHEM cleaner gun or a quality lacquer thinner or acetone. Always follow manufacturer's safety recommendations when using any solvent.

Standards This product meets KCMA and CKCA test requirements when used under recommended LORCHEM Topcoat.

DRYING TIMES

Method	Drying temperature.	Drying Time (@ 50%RH and thickness @ 4 mil WET)			
Air Drying	23°C/74°F	**Dust free time**	4-6 minutes	**Dry to sand**	2 hours
		Dry to touch	20-30 minutes	**Dry to recoat**	2 hours
		Dry to Handle	2 hours	**Dry to stack**	12 hours
Force dry	45to 60°C/110-140°F	Minutes			

Note: Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Minimum curing temperatures of 23°C/74°F must be maintained throughout curing cycle to achieve the film integrity as stated in product features.

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APPLICATION RECOMMENDATIONS

APPLICATION EQUIPMENT SETTINGS

Method of Application	Air Pressure (PSI)	Fluid Pressure (PSI)	TIP size (mm / inch)	Application Viscosity (#FORD 4)	Thickness Film (Mils)
Conventional spray	40-50	08-12	1.8-2/0,070-0,078	18-21	3-5
Airless Spray	10-18	300-600	0,28-0,33/0,011-0,012	18-21	3-5
HVPL	35-45	8-12	1.19-1,39/0,047-0,055	18-21	3-5

Note: All measurements and application equipment settings are based on application at a temperature of 23°C/74°F. Viscosity will vary depending on the temperature of the liquid. The above-mentioned application equipment recommendations are guidelines only. The noted settings are starting point recommendations and that adjustment to the settings and equipment may be needed to obtain the desired results. Please refer to your specific equipment manufacturer's recommendations for equipment set-up.

SPECIFICATIONS

- For interior use only.
- Must be stirred before and during using.
- Must be catalyzed with C A72 catalyst at a level of 10% by volume. Over catalyzing or using incorrect catalyst may result in blooming, cracking and poor adhesion.
- C A72 is an acid. To prevent acid corrosion and pitting, do not catalysed in an unlined metal container and all equipment should made of stainless steel.
- This product should be thoroughly sanded within 4 hours of being applied. If the primer is not topcoated the same day, it should be resanded immediately before topcoating to insure optimum intercoat adhesion.
- Store at room temperature (under 25°C/ 80° F) after catalyzation. Higher temperatures will reduce the storage life.
- Can be used under recommended LORCHEM Topcoat. Please contact your LORCHEM representative for system recommendations.
- Total film thickness of systems must not exceed 7.0 mils dry film because heavier films may show cracking tendencies.
- To maintain HAPS compliance, only recommended solvents may be added.

CAUTIONS

TESTING

Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

THESE PRODUCT ARE DESIGNED FOR INDUSTRIAL SHOP APPLICATION AND PROFESSIONAL USE ONLY

Thoroughly review Safety Data Sheet (SDS) for safety information and cautions prior to using this product. Please direct any questions or comments to your local representative.

PDS

Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling ,preparation and application which are not known or under our control, LORCHEM cannot make any warranties related to the product or the performance of the product. Moreover, we underline the fact that in industrial applications, a tolerance of 5% in the overall results is considered normal and is not caused by the quality of the product.

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