



# Primecoat

## High build, wet-on-wet polyester coating

### Product Overview

Primecoat is a high build, polyester coating material which allows the rapid surfacing of patterns constructed from wood, MDF, GRP etc. It can be applied wet-on-wet up to a thickness of 1.5mm in one operation without sagging or draining from vertical surfaces. The material hardens rapidly and when cured can be easily sanded to a very smooth finish which can be polished to a surface glossy enough for many applications. Where higher gloss and/ or hardness is required, it can be surfaced with Glosscoat (see separate Glosscoat data sheet).

### Application

It is designed for spray application but it can be applied by brush. Spray application will give a more uniform coating requiring much less finishing.

Gravity fed or siphon guns will require a line pressure of 40-60psi and a 1.5-2.0mm material nozzle. For pressure pot systems use a 10-20psi pot pressure and 40-60psi line pressure. It is important that the compressed air is free from impurities such as water and oil mist.

#### Application guide for pattern surfacing

1. Ensure that the plug has been accurately made and is dimensionally stable. To ensure that the Primecoat bonds to the pattern surface, thoroughly sand the surface of the plug with 40-80 grit abrasive paper. Remove surface dust and degrease with an acetone or styrene dampened cloth. Ensure that the materials and the workshop are at a minimum temperature of 15°C. A temperature of 20°C will give improved results.  
If the pattern has a wood grain surface it can be painted with Crystic<sup>®</sup> resin (e.g. 2.406PA) catalysed with 2% M50. This should be allowed to harden before abrading any 'raised' grain from the surface.
2. Mix Primecoat thoroughly before use. If application is by spray, this with pure acetone or Glosscoat Thinners and thoroughly mix until the desired consistency has been obtained. The level of pure acetone or Glosscoat Thinners can be varied to suit the particular equipment used but the addition of 25 parts by weight of pure acetone or Glosscoat Thinners to 100 parts by weight of Primecoat is a good starting point.
3. Catalyse with 2% of Butanox M50 or Catalyst M. The presence of the suggested level of pure acetone or Glosscoat Thinners will extend the pot-life to more than 30 minutes and it will be possible to spray large areas without fear of gelation in the spray equipment except in very high temperatures.

4. Apply a thin mist coat and allow 1-5 minutes for the solvents to flash off giving a matt surface on the Primecoat. The exact time will depend on temperature, ventilation and pattern material.
5. Follow with heavier wet coats, building slowly to the desired thickness. Again, allow 1-5 minutes between passes to allow for evaporation of the solvents. Do not apply successive wet coats without allowing the solvents to flash off as this will slow down the cure rate and may lead to entrapped solvent.
6. Allow the surface primer to cure until it can be sanded without excessive clogging of the abrasive paper. This time will depend on temperature and can be as little as 2 hours, although the material is still easily sandable 24 hours later.
7. If the surface of the patters is now free from wood grain marks or other surface imperfections, it can be sanded back initially with 100-180 grit abrasive paper, progressing to finer grades prior to finishing with Farecla G6 and Farecla G3 compound and the application of a release agent system from our extensive range. If after surfacing, grain marks etc. are still visible, remove them by sanding with 80 grit paper and then re-apply as in Step 3.

If you require more information, please contact our Technical Services Department.

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## Additional Information

### Storage

Primecoat should be stored in the dark in suitable closed containers. It is recommended that the storage temperature should be less than 20°C where practical, but should not exceed 30°C. Ideally, containers should be opened only immediately prior to use.

### Packaging

Primecoat is supplied in 5kg and 25kg containers.

### Health and safety

Please see the applicable Material Safety Data Sheets.



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