EMEAI Valspar bv
Zuiveringweg 89
8243 PE Lelystad
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www.valsparindustrialmix.com

PB330 Fast Drying Anti-Corrosion Primer "Tintable" PB330 / UK

Product Information

Product Description:
PB330 is a tintable 1K Fast Drying Anti-Corrosion Primer with good corrosion protection & adhesion properties.
Add 20% Color toner to 80% Binder (PB330) according to our CRS (Color Retrieval System) to create any color.
This fast-drying 1K Primer forms a protective film with good adhesion for light industrial market, agriculture machinery and equipment, machine tools, caterpillars, building equipment etc…

Preparation:
For more detailed information go-to Technical Information (TI), Substrate and Pre-treatment on Color Retrieval System (CRS) or website www.valsparindustrialmix.com/emea/en/.

Substrates:	Steel, cast iron, galvanized steel, aluminum and glass fiber reinforced composites.
Plastic:	FP600 Plastic Primer (adhesion test recommended).
Other:	E-coat, solvent resistant surfaces, original and cured coatings, cleaned/sanded.
Steel:	Recommended abrasive blast to SA 2½. Dry sanding P80 – P180.
Aluminum:	P120 – P240.
Galvanized steel:	Sweep blasting recommended.
Paint finishes:	P240 – P320.
Note:	Please, regularly check and change abrasive paper as required.
Cleaning:	Surface must be dry and free from any contamination, e.g. oil, grease & release agents. Use AD690 Degreaser Solvent Based.

Material Description: PB330 Fast Drying Anti-Corrosion Primer "Tintable"		
Application Method	Minimum DFT µm	Maximum DFT µm
Spraying equipment (including airless/airmix)	50µm	80µm

*Higher thicknesses require extended drying times

Recoating

Topcoat:	Industrial:	TB300, TB332, TB330 and TB350 Synthetic Topcoat
	Other:	PU Topcoats
	More detailed information go-to:	Technical Data Sheet.

Physical properties:

Chemical base	Alkyd resin
Density (kg/l)	1,3
Volume solids (%)	43.1%
Weight Solids (%)	63.8%
Flash point	26.0°C
Pot life (+20°C)	Approx. 24 hours (as 1K product)
Shelf life	Min. 24 month under normal storage conditions and unopened tins
Coverage (m²)	Approx. 8,2m² 40µm (DFT)
Gloss	Semi-gloss 40GU/60°
Color	Binder Transparent
Temperature Stability	Dry Heat up to 120°C
VOC (g/l)	Max. 580g/l see CRS (VOC: 2004/42/IIB(d)420g/l)
Processing temperature	+10°C till max. +40°C, max. Humidity 85%

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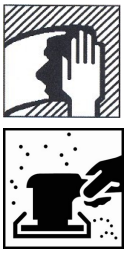
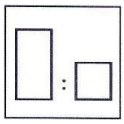
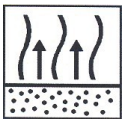
Application Data

	**Preparation/ Cleaning:**	**All surfaces must be properly shot blast or sanded and cleaned** Abrasive blast to EN ISO 12944, part 4 (SA 2½) with a uniform blast profile. Dry sanding Steel: P80 – P180 Aluminum: P120 – P240 galv. Steel: Sweep-blasting recommended Paint finishes: P240 – P320 Cleaning: AD690 Degreaser Solvent Based Surface must be dry and free from any contamination, e.g. oil, grease	
	**Handling:**	**Color preparation:** 1. Stir binder until homogeneous 2. Add Color Toners 3. Mix mechanically (paint shaker/ mechanical stirrer)	**Before use/spraying:** 1. Mix mechanically (paint shaker/ mechanical stirrer) 2. Add Activator and/or Reducer 3. Stir this mixture well with a mixing stick or a (pneumatic) stirrer
	**Mixing ratio with Color Toner, and Synthetic dryer:** (By volume)	PB330 **Anti-Corrosion Primer Binder** CT Range of VIM Color Toners AA300 Synthetic Dryer	79.5 parts 20 parts 0.5 parts
	For mixing machine users:	For mixing formula's see VIM CRS	(By weight)
	**Mix ratio with Reducer 4:1**	PB330 Anti-Corrosion Primer RS330 Reducer NC or RS300 Synthetic Reducer	100 parts 20 - 30 parts
	**Mix stick:**	Use the Mixing stick **M2 4:1** (74-202 = 3:1/4:1) or **M6 Universal cm-stick** (74-206 standard) / **M7** (74-207 large)	
	**Viscosity:** 15 – 28 sec. (DIN4/20°C)		
	**Gravity or Suction Feed:** Nozzle set Spray gun "High pressure" Spray gun "Reduce pressure" HVLP (Air cap pressure) Airless/Airmix Pressure Pot	 1.3 – 1.6 mm 3.0 – 4.5 bar (42 – 65 psi) 1.6 – 2.0 bar (23 – 30 psi) 0.7 bar (10 psi) maximum 0.009 – 0.011 1.0 – 1.3 mm	
	**Application:** **Film Thickness:**	1 closed coat Followed by 1 full coat (recommended 40 – 80µm)	
	**Between coats at 20°C:** **Before baking at 20°C:**	5 minutes 5 minutes	
	**Clean up:** (Check the local regulations!)	RS300 Synthetic Reducer, RS330 Reducer NC, RS60x Universal Reducer or Gun cleaner (solvent)	

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	**Air–dry at 20°C:**	**Dust Free:** 15 – 20 minutes **Dry to assembly:** 40 – 60 minutes **Dry:** 24 hours
	Force–dry:	20 - 30 minutes / 60°C object temperature
	**IR–dry:**	8 – 12 minutes (The panel must not exceed 90°C)
	**Use suitable respiratory protection (air fed respirator strongly recommended).**	
	**Recoating time:**	1 Layer Primer Application – Flash-off PB330 sprayed up to 40µm can be recoated with recommended Topcoat after 60 minutes at 20°C. 2 Layer Primer Application – Flash-off Layer thickness up to 60 – 80µm can be recoated with recommended Topcoat after 4 - 5 hours at 20°C. More save is the recoating after 16 - 20 hours. This Primer can be recoated within 48 hours – after that time, sanding is required.
	Topcoat:	TB300/332/330/350 Synthetic Topcoat PU Topcoats (See Technical Data Sheet)
	**Precautions:** During application all health and safety measures referring to the use and handling of coating materials are to be observed, e. g. existing regulations issued by the trade associations in the Chemical Industry. For Health and Safety information please refer the Material Safety Datasheet (MSDS). Information also available on our webpage: www.valsparindustrialmix.com/emea/en/	
	Note: The products listed are intended only for the professional user and for professional use. All recommendations given in writing on the use of our products to customers or users are not binding and do not give reasons for secondary obligations resulting from the bill of sale. Every care is taken to ensure that the technical information provided is accurate and up to date according to the present state of knowledge in science and our experience. These recommendations do not, however, exempt the customer from autonomously checking whether our products are suitable for the intend purpose. The durability of the coating system largely depends on the thorough preparation of the surface. Furthermore our uniform terms of delivery and payment are applicable.	
	With the publication of this Technical Data Sheet all previous versions regarding this product are no longer valid.	