



TIE-COAT PRIMER

Revised 27.5.09

Application Information

Tie-Coat Primer is a very tough and sandable, non-moisture sensitive single-component polyurethane primer. It contains hybrid polymeric resins which have excellent adhesion characteristics to most painted surfaces, especially POR 15, because we have matched and blended the resin components of both coatings to make them fully compatible. Tie-Coat Primer is highly resistant to penetrating topcoats such as enamels, lacquers, and two-component finishes ("penetrating topcoats" refers to topcoats with especially aggressive solvent bases which can penetrate and ruin a partially cured base coat). But it must be 100% cured

Tie-Coat Primer is not a reactive coating (as is POR 15, which reacts to moisture), but its revolutionary adhesion promoters make it an ideal interlocking prime coat between POR 15 and various topcoats. It sands to a perfectly smooth finish.

It may be use over cured POR 15 coating, up to six months (for better adhesion we recommend that it be applied sooner) with no special preparation other than cleaning the surface.

DIRECTIONS FOR USE

Surface Preparation:

- Surface to be coated should be free of grease, oil, foreign substances. Use a wax and grease remover before painting. Marine Clean is ideal for this.
- Avoid the use of Solvent based preps.
- The best method for over coating POR-15 Rust Preventive Paint with Tie-coat Primer is to first clean the surface with Marine Clean and then apply a **THIN** coat of Tie-coat. Allow at least 24hrs and then top coating can be done at any stage after this curing time. thicker coats will need longer.....

N.B. Tiecoat should not be exposed to rain, dew, etc.

Paint Surfaces:

- Clean with Marine Clean and sand with 240 grit and then overcoat with Tie-Coat Primer.

Thinning:

- Thinning is not usually required if it is brushed on. Tie-Coat may be thinned for spraying 5%-10% with POR 15 Solvent. (10 parts primer to 1 part Solvent) Do not thin any more than this or adhesion may be affected.

Application:

- Stir Tie-Coat thoroughly before using; do not shake as this will create air bubbles.
- Apply by brush or spraying.
- Apply in **THIN** coats.
- Subsequent coats if required may be applied at 12 hour intervals. Not normally required.
- DO NOT SAND BETWEEN COATS OF PRIMER. Sand only after final coat of primer has fully dried (at least 24 hours).

Pressure:

- Spray at approximately 250 Kpa (35lbs).

Topcoating:

- Allow a minimum of 24 hours before applying any topcoat over Tie-Coat Primer. **Failure to allow enough dry time before applying topcoats may result in spidering or crinkling of the finish**
- **NOTE:** in temperatures below 18°C curing times can lengthen considerably (Tie-Coat is Solvent curing not moisture curing). Allow extra days for curing in a low temperature environment. Tie-Coat will stop curing in temperatures below 12°C.

Storage & Handling:

- Store in a tightly closed container and protect from moisture and foreign materials. Ideal storage temperature is 10 - 27°C (50-81°F).

SUMMARY:

1. Stir, do not shake, Tie Coat Primer before using.
2. Apply **THIN** coats. Do not sand between coats. Sand only after final coat has dried thoroughly - watch drying times — see note above.
3. As with all solvent-based coatings, use an organic vapour particulate respirator, NIOSH/MSHA approved, when spraying or brushing. In closed areas, use an air supplied respirator when spraying.

CHARACTERISTICS

Boiling Point:	177-196°C (350-385°F)
Viscosity:	Range @ 77°F: 250-500 CPS
Vapor Density:	Heavier than air
Specific Gravity (water=1):	1.32
Reactivity in water:	None
% Volatile by volume:	21%
Odour:	Light aromatic
Colour:	Bluish-Grey
Evaporation rate (Ether=1):	Solvent 4.5
Volatile organics:	2.33 lbs/gal (270gr/ltr)
Flash Point:	67°C
Solubility in water:	negligible
Carcinogens (or potential):	none
Stability:	stable under normal conditions
Conditions to avoid:	Sparks, open flame
Materials to avoid:	oxidising agents
Current TLV:	ACGIH: 100 ppm TWA
Ceiling Value OSHA PEL:	500

The information set out in this flier is, so far as can be ascertained, true and accurate, but all recommendations or suggestions are made without guarantee.

Since the conditions of use of the Products sold by Permanent Painted Coatings Pty Ltd (Australia) ("PPC Pty Ltd") are beyond the control of PPC Ltd / and or PPC Pty Ltd ("the company"), the Company to the full extent allowed by law, disclaim any liability with respect to damage, injury or death consequent upon the use of the Products or consequent upon the use of the information contained herein.

The Company warrant that the Products supplied hereunder shall conform to the description or specification stated in this flier. The Company make no warranties that Products supplied are made to certain industry specifications. To the full extent allowed by law, the liability of the Company with respect to any breach of the aforesaid warranty shall be limited, at the option of the Company, to payment of the cost of replacing the Products or of acquiring equivalent products and in no case shall the Company be liable for consequential loss or damage. In no case will the Company be liable to defend or pay any award of damages assessed against the buyer in any suit or cause of action alleging that the use of the Products supplied hereunder infringe any patent. The Company hereby expressly disclaim any written or unwritten, express or implied representation, warranty or condition against infringement of any patent with

PERMANENT PAINTED COATINGS LTD

Unit 1 / 4 Prosperity Parade;
WARRIEWOOD NSW 2102

Phone free: 1-800 643 229

Telephone: 02 9999 0122

Fax: 02 9999 0394

Website: www.por15.com.au

Email: sales@ppcco.com.au



Permanent Painted Coatings

respect