Description

Two-pack fast drying anti-corrosive primer for pre-treatment for Aluminium and Galvanized Steel surfaces. Designed to be used over abrasive sanded steel, GI and Aluminium to provide optimal corrosion protection and adhesion to the subsequently applied coatings.

Suitable Substrates

Steel
Galvanized Steel (GI)
Aluminum
Polyester Filler and Putty

1 Ultima Etch Primer
1 Ultima Etch Primer Activator

Spray-gun setup:
Gravity fed | 1.4 - 1.6 mm

Application Pressure:
1.7 - 2.2 Bar | 28- psi | At spray-gun air inlet
HVLP max 0.6-0.7 bar (8-10 psi) at the air cap

1 coat

8-14 µm / coat

Dry to re-coat

20°C(70°F)	30°C(86°F)	40°C(100°F)
25 mins -2 hours	20 min – 2 hrs	15 – 90 mins

Re – coating
With Ultima PU Primer

Ultima Etch Primer	4 years
Ultima Etch Primer Activator	4 years

Use suitable respiratory protection

Nippon Paint Automotive Refinishes recommends the use of fresh air supply respirator.

For detailed information read entire TDS

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Suitable Substrates

Steel
Galvanized Steel (GI)
Aluminum
Polyester Filler and Putty

Surface preparation



- Prior to any work, remove dirt and degrease the surface using nax Silicone Off degreaser.
- Always use clean quality rags or wiping towels for wipe on and wipe off.
- Apply sufficient degreaser to keep the surface wet.
- Wipe degreaser off before it can evaporate.



Iron & Steel: abrasive blasted with SA 2.5 - 3.0 or sanded with	P120 - P220	dry
Galvanized steel sanded with	P120 - P220	dry
Aluminum abraded with red scuff pad or sanded with	P220 – P320	dry
Sound OEM electro (ED) coated parts abraded with	P320	dry
Fiber reinforced laminates (FRP) abraded with	P220 - P320	dry
nax polyester bodyfillers and putties; finished with	P120 - P220	dry
Removal of existing finish with	P120	dry
Feather edge before polyester/putty and finish, sanding for complete panel priming	P220	dry
Feather edge and final step prior to primer/surfacer application for spot repairs	P320	dry



- Prior to Ultima Etch Primer application, degrease the surface using nax Silicone Off degreaser.
- Always use clean quality rags or wiping towels for wipe on and wipe off.
- Apply sufficient degreaser to keep the surface wet.
- Wipe degreaser off before it can evaporate.

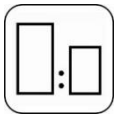
Notes: *Respect 100 grit maximum jump in dry sanding steps.*
Prior to primer application surface must be dry and free of any dirt, oil, grease and other foreign matters.

Mixing



Product Mix

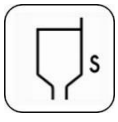
Stir well, after each added component.



1	Ultima Etch Primer
1	Ultima Etch Primer Activator

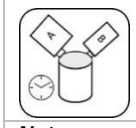
Notes: *Stir well*

Viscosity (DIN 4 Cup)



	30°C(86°F)
Spraying	16-20 Sec.

Pot Life



30°C(86°F)
5 Hrs.

Notes: *Passed potlife primer loses its etching property.*

Spray gun set-up / application pressure



Spray-gun type	Nozzle size	Application pressure
Gravity (HVLP, LVLP)	1.4-1.6 mm	Max 0.6-0.7 bar at the air cap (1.7-2.2 at inlet)

Application



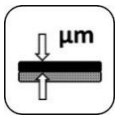
Number of coats
1 full coat to cover bare metal

Re-coating time



20°C(70°F)	30°C(86°F)	40°C(100°F)
25 min – 2 hrs.	20 min – 2 hrs	15 – 90 mins

Film thickness



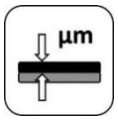
Using the recommended application technique 8-14 µm

Re-coating



With Ultima PU Primer
With all nax Primer Surfacers

Coverage



By using the recommended application, the theoretical material coverage is:
11 ± 01 m²/liter RTS mixture

Notes: *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure and application circumstances.*

Equipment cleaning

Solvent borne gun cleaners

Shelf life



Ultima Etch Primer	4 years
Ultima Etch Primer Activator	4 years

Minimum storage temperature: 5°C (41°F) Maximum storage temperature: 35°C (95°F)

Notes: *Product shelf-life is determined when products are stored unopened at 20°C (70°F).Avoid extreme temperature fluctuation.*

--- Local organization address with phone number ---	
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