

## 522-3000 OmniBuild® Pro Primer

<b>Product codes:</b>	522-3000	<b>Viscosity</b>	72-78 KU Stormer at 25°C
		<b>Flash Point:</b>	45°F (7°C)
		<b>Density (kg/l):</b>	1.28
		<b>Solid (% by weight):</b>	62.96%
		<b>Solid (% by volume):</b>	43.76%
		<b>Shelf Life (months):</b>	12

### Product Description:

OmniBuild Pro Primer is a true 24 hour pot life conversion varnish primer for interior woodwork and MDF. It's high-solids formulation provides superior build, sag resistance and hide. OmniBuild Pro Primer is easy to apply, sands easily and quickly and has a quick stack time making it very production-friendly. For optimum results use 117-24XX Chemlife 24 or 117-25XX Chemlife 24 Plus Topcoat.

### Uses:

OmniBuild Pro Primer is designed for interior woodwork on solid wood and MDF.

<b>Environmental Data (as supplied):</b>	<b>VOC less exempt lb/gal:</b>	<3.65
	<b>VOC lb/gal:</b>	<3.65
	<b>VOC less exempt g/l:</b>	
	<b>VOC g/l:</b>	
	<b>VOC lb/lb Solid:</b>	<0.55
	<b>VHAPs lb/lb Solid:</b>	<0.15

### Note:

See individual compliance sheets for specific data

<b>Application Data</b>	<b>Suggested Uses:</b>	Wood Primer
	<b>Mixing Ratio:</b>	873-1251 @ 15% for 24 hour pot life 999-017 @ 10% for 8 hour pot life 999-031A @ 10% for 8 hour pot life 873-2400 @ 7% for 8 hour pot life
	<b>Suggested Uses:</b>	See Mixing Ratio
	<b>Application Viscosity:</b>	Zahn #2 signature cup 25 – 40 seconds
	<b>Reducer:</b>	803-1325 or 121-8020 (121-802) 10 - 15% as needed
	<b>Retarder:</b>	N/A
	<b>Clean-up Solvent:</b>	800-5500 (100-121)
	<b>Recommended Wet Film:</b>	4.5 to 5.5 mills Max
	<b>Coverage:</b>	17 m <sup>2</sup> /l (701.87 sq.ft./gal) at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

### Note:

Recommended reduction ratio of 803-1325 or 121-8020 by volume is as follows:  
5% for Airless Assisted application

10% for conventional cup gun application

Directions for use:

Surface Preparation:

Substrate should be sanded using 120, 150 or 180 grit stearted paper. OmniBuild Pro cannot be used on metal, old oil or cellulose lacquers. For optimum results use 117-24XX Chemlife 24 or 117-25XX Chemlife 24 Plus Topcoat.

General Information:

Mix OmniBuild Pro Primer thoroughly, then catalyze and reduce material as recommended. OmniBuild Pro Primer must be well mixed while adding catalyst and reducers and must be agitated at all times to ensure product consistency. OmniBuild Pro Primer is applied in one or two coats and can be used as a primer for most wood and wood products meant for indoor use. A thorough sanding using 240/320 grit stearted paper between coats is essential for adhesion. The second and subsequent coats must be applied the same day as the previous coat is sanded. Care should be taken to avoid sanding through the primer coat. With profiled edges, care must be taken with sanding of primer to avoid sanding through sharp edges. Complex profiles or profiles with sharp corners may cause difficulties in obtaining an effective primer coat of even thickness. In these cases, profile design must be discussed with your technical representative. Contact with metal surfaces should be avoided once the OmniBuild Pro Primer has been catalyzed. To ensure proper uniformity, the material should be agitated at all times. Please refer to the specific topcoat PIS for recommended dry film thickness for the topcoat. Total recommended dry film build of OmniBuild Pro Primer and Chemlife 24 Plus system is not to exceed 8 mils dry: OmniBuild Pro Primer with any other recommended post-catalyzed topcoat system is not to exceed 7 mils dry. Designed for solid wood and MDF. For all other substrates including combination substrates, please contact your Chemcraft representative for additional information. OmniBuild Pro Primer must not be polluted with oil, varnish or the like and must not be sanded with steel wool between the coats. OmniBuild Pro Primer must not be used and dried at temperatures below 64°F or relative humidity above 65%. During the curing process, the coating must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finish surfaces. This may accelerate discoloration.

THE CUSTOMER IS RESPONSIBLE FOR FOLLOWING THE RECOMMENDED APPLICATION PROCEDURES. FAILURE TO ADHERE TO THE RECOMMENDATIONS GIVEN IN THIS DATA SHEET WILL LIKELY RESULT IN UNSATISFACTORY FILM APPEARANCE OR FILM FAILURE. THE COMPLETE COATING SYSTEM SHOULD BE CHECKED FOR REQUIRED PROPERTIES PRIOR TO THE START-UP OF PRODUCTION

Drying Times:

	Room Temperature (20°C / 68°F)	Forced Drying Schedule (50°C / 122°F)
Tack Free Time:	10 - 15 minutes	5 - 10 minutes
Dry to Sand:	20 - 30 minutes	2 - 3 hours
Dry to Stack:	15 - 20 minutes	45 - 60 minutes

Note:

N/A

Dry times are greatly affected by film build, porosity of substrate, air movement as well as heat and humidity. Temperatures are based on actual board temperature. This may vary depending on length of time for boards to reach these temperatures. Minimum curing temperatures of 64°F/18°C must be maintained throughout the curing cycle to achieve the film integrity as stated in product features.

These products are designed for industrial use only. AkzoNobel views safety as a top priority. Please refer to Material Safety Data Sheet for information on the safe use of this product.

Values shown are calculated estimates and should not be construed as product specifications. We cannot anticipate all conditions under which this information and our products or the products of other manufacturers in combination with our products may be used. We accept no responsibility for results obtained by the application of this information or the safety and suitability of each such product or product combination for their own purposes. Unless otherwise agreed in writing, we sell the products without warranty, and users assume all responsibility and liability for loss or damage arising from the use of our products whether used alone or a combination with other products. Use of unapproved or reclaimed solvent blends may reduce film properties and is not recommended.

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