

## 545-8001 Optiprime White Pre-Cat Primer

<b>Product codes:</b> 545-8001 White	<b>Viscosity:</b> Zahn #2 signature cup 58 sec at 77°F
	<b>Flash Point:</b> -4°F (-20°C)
	<b>Density (lb/gal):</b> 9.3
	<b>Solid (% by weight):</b> 48.5%
	<b>Solid (% by volume):</b> 32%
	<b>Shelf Life (months):</b> 6

### Product Description:

Optiprime is a one-component, high solids, pre-catalyzed Reactive Amino Coating (RAC) used as a primer. This product meets the German "E-1" classification for the emission of formaldehyde as tested by an accredited laboratory using North American test methods. This pigmented pre-catalyzed RAC has very low odor during the curing process.

### Uses:

Optiprime is recommended for use as a primer for Optiset® White 131-83XX. It has good filling properties and hiding characteristics.

<b>Environmental Data (as supplied):</b>	<b>VOC less exempt lb/gal:</b>	<4.80
	<b>VOC lb/gal:</b>	<4.80
	<b>VOC less exempt g/l:</b>	<575
	<b>VOC g/l:</b>	<575
	<b>VOC lb/lb Solid:</b>	<1.05
	<b>VHAPs lb/lb Solid:</b>	<0.10

### Note:

See individual compliance sheets for specific data

<b>Application Data</b>	<b>Suggested Uses:</b>	Wood Primer
	<b>Mixing Ratio:</b>	100 parts 545-8001 to 3 parts 873-0870
	<b>Suggested Uses:</b>	12 hours
	<b>Application Viscosity:</b>	Zahn #2 signature cup 20 – 25 seconds
	<b>Reducer:</b>	803-1325
	<b>Retarder:</b>	N/A
	<b>Clean-up Solvent:</b>	803-1298
	<b>Recommended Wet Film:</b>	3 – 5 mils
	<b>Coverage:</b>	545 sq. ft/gal at 1 mil dry and at 100% transfer efficiency. Coverage will vary depending on method of application or coating thickness.

### Note:

N/A

**Directions for use:**

**Surface Preparation:**

Substrate should be sanded using 120, 150 or 180 grit stearated paper prior to coating. Primers, if used, should be sanded with 280/320 grit stearated paper prior to being coated. When recoating the previous coat of Optiprime must be sanded and the next coat applied within eight hours. Optiprime cannot be used on metal, old oil or cellulose lacquers.

**General Information:**

Agitate material before use. Always mix Optiprime while adding catalyst and reducers in the recommended mixing ratios. Optiprime must be agitated thoroughly at all times to ensure product consistency.

Apply at 3 – 5 mils wet on sanded substrate. Further coats may be applied after complete drying followed by sanding with 280/320 grit stearated paper. The second and subsequent coats must be applied the same day as the previous coat is sanded.

Maximum film build of Optiprime should not exceed 2 – 3 mils dry. Maximum film build of total coating system must not exceed 4 mils dry. Contact with metal surfaces should be avoided.

Optiprime must not be polluted with oil, varnish or the like and must not be sanded with steel wool between coats.

Optiprime 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:**

	<b>Room Temperature (20°C / 68°F)</b>	<b>Forced Drying Schedule (50°C / 122°F)</b>
<b>Tack Free Time:</b>	10 – 15 minutes	Flash off before entering oven
<b>Dry to Sand:</b>	1 - 2 hours	3 hours
<b>Dry to Stack:</b>	30 minutes	60 - 90 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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