

545-8016 Optiprime White Pre-Cat Pigmented Primer

Product codes: 545-8016	Viscosity 2000 cps at 77°F (25°C)
	Flash Point: -6°C (21°F)
	Density (kg/l): 1.08
	Solid (% by weight): 41%
	Solid (% by volume): 25%
	Shelf Life (months): 6

Product Description:

Optiprime is a one-component, high solids, Pre-Catalyzed Reactive Amino Coating (RAC) used as a primer. Optiprime is recommended for use as a primer for Optiset 131-82XX or E.S. Lacquer White 131-51XX. It has good filling properties and hiding characteristics.

This coating may be catalyzed to further enhance its durability. Contact your coating supplier for a recommendation.

Uses:

Interior wood applications

Environmental Data (as supplied):	VOC less exempt lb/gal: <4.80
	VOC lb/gal: <4.80
	VOC less exempt g/l:
	VOC g/l:
	VOC lb/lb Solid: <1.00
	VHAPs lb/lb Solid: <0.05

Note:

See individual compliance sheets for specific data

Application Data

Suggested Uses:	Spray
Mixing Ratio:	100 parts by volume, 3 parts by volume of 999-017 Hardener.
Suggested Uses:	8 hours
Application Viscosity:	Zahn #2 signature cup 2 – 25 seconds
Reducer:	Lacquer thinner 121-001/803-1339 or 121-8020
Retarder:	800-5328 EEP
Clean-up Solvent:	Lacquer Thinner
Recommended Wet Film:	3 to 5 mils wet
Coverage:	10 m ² /l (105pi ² /l) 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 steared paper prior to coating. Primers, if used, should be sanded prior to being coated with 280/320 grit steared paper. 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 hardener 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 steared 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 the coats. Optiprime must not be used and dried at temperatures below 18°C or relative humidity above 65%. During hardening the enamel must not be exposed to ammonia vapors. Ammonia cleaners should not be used for cleaning the finished surface. This may accelerate discoloration.

Topcoats to use over 545-8016: 131-50XX, 131-51XX, 131-82XX, 117-30XX, 117-32XX and 484-6XX

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	Flash off before entering oven
Dry to Sand:	1 - 2 hours	3 hours
Dry to Stack:	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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