

CF Metal Primer 156

Technical Data Sheet: 153-44
P1566

- 1. Introduction** ALEXSEAL® CF Metal Primer 156 is a chromate free, high solid epoxy-based primer designed for priming metal surfaces where corrosion protection and chemical resistance is required.
- 2. Range of application** ALEXSEAL® CF Metal Primer 156 is designed to prime and seal new and old, properly prepared, metal surfaces prior to the application of ALEXSEAL® Topcoats or ALEXSEAL® Finish Primer 442. This product is ideal for masts, parts and thin gauge metal where minimal fairing is required. It may be top coated or primed depending on the application requirements. CF Metal Primer 156 may be used above and below the waterline.

- 3. Color**
- Colors of mixture: Ivory
Base material: Ivory
Converter: Clear

- 4. Coverage**
- Volume Solids catalyzed without reduction: 60%.
Coverage for ALEXSEAL® CF Metal Primer 156 when applying 1 - 2 coats or passes in the same application period.
Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	Rec. DFT in µm (mils)
Theoretical/ Brush and Roller	22	83.3	876	25 (1)
Practical				
Conventional Air Spray Equipment	7.3	27.6	297	25 (1)
HVLP Air Spray Equipment	8.5	32	346	25 (1)
Airless Spray Equipment	10	37.8	407	25 (1)

- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust, grease, oil and other contamination.
- ALEXSEAL® CF Metal Primer 156 may be applied directly to the properly cleaned and prepared Aluminium or Steel substrate to achieve optimum adhesion and performance:
- Aluminium** should be sanded with 80 - 180 grit or blasted depending on thickness of primer surfacer – or topcoat used over CF Metal Primer 156. 180 - 220 grit can be used to sand the metal when over coating CF Metal Primer 156 directly with Alexseal® Topcoat 501. Bright clean aluminium should always be achieved before application. The use of either Alumiprep® by itself or Alumiprep® and Alodine® treatment is recommended to clean and treat the aluminium to enhance corrosion resistance.

Please contact your Alexseal® Representative to discuss additional chemical treatment options.

- 6. Trade names**
- | | | |
|---------------|-------|---|
| Base Material | P1566 | ALEXSEAL® CF Metal Primer 156 Ivory |
| Converter | C1567 | ALEXSEAL® CF Metal Primer 156 Converter |
| Reducer | R4042 | ALEXSEAL® Epoxy Primer Reducer |
- 7. Mixing ratio**
- | | | |
|--------------------|-------|---|
| 2 parts by volume | P1566 | ALEXSEAL® CF Metal Primer 156 Base |
| 1 part by volume | C1567 | ALEXSEAL® CF Metal Primer 156 Converter |
| 10 – 20% by volume | R4042 | ALEXSEAL® Epoxy Primer Reducer |

Allow a 15 minute induction period after mixing base and converter, add reducer and remix.

Example: 2 : 1 : 3/10 = 10% reduction for spray application

The amount of reducer varies on the application conditions.

Professional Use Only

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8. Application

Viscosity	Zahn #2: ≈ 15 sec, DIN 4 cup 4mm: ≈ 12 - 16 sec
Nozzle Size Gravity Gun	1.0 to 1.4 mm (0.040 to 0.055) - Conventional & HVLP
Nozzle Size Siphon Cup	1.4 to 1.6 mm (0.061 to 0.070) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	1.0 to 1.2 mm (0.040 to 0.046) - Conventional & HVLP
Atomizing Pressure	2.0 to 4.0 bar (30 to 60 PSI) - Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 15 PSI) - Conventional & HVLP

Application by Spraying

Apply 1 coat to a wet film thickness (WFT) of 40-50 microns (1.5-2 mil). This will achieve a dry film thickness (DFT) of 20-25 microns (1 mil). Minimum recommended film is 25 microns (1 mil) DFT. Maximum recommended film thickness during a spray application is 2 coats totaling 50-60 microns (2-3 mils) WFT, or 25-30 microns (1 mil) DFT.

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life - approx.	12 hrs	12 hrs	12 hrs	12 hrs	N/A
Dust Free	90 min	60 min	45 min	30 min	N/A
Tape Dry	30 hrs	24 hrs	18 hrs	14 hrs	N/A
Fully Cured	10 days	8 days	7 days	6 days	N/A
Overcoat with another product including 302, 357, 442 and 501. Sanding is required after max time.	5 hrs minimum	4 hrs minimum	3 hrs minimum	3 hrs minimum	72 hrs maximum

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will effect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.

10. Packaging

P1566	ALEXSEAL® CF Metal Primer 156, Yellow	1 QT & 1 Gal
C1567	ALEXSEAL® CF Metal Primer 156, Converter	1 PT & 1/2 Gal
R4042	ALEXSEAL® Epoxy Primer Reducer	1 QT & 1 Gal

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