

VP404 Etching Primer

TECHNICAL DATA SHEET

DESCRIPTION

VP404 is an acid etch pre-treatment primer and metal conditioner. It is formulated for excellent adhesion when used on various types of substrates including properly prepared steel and aluminum. VP404 is compliant with all applicable air regulations including Rule 1151 in the SCAQMD. VP404 is lead and chromate free.

COMPONENTS

- VP404 Base component
- VP406 Converter

MIXING RATIO

Mix one (1) part VP404 base with one (1) part VP406 converter.

POT LIFE at 77° F

8 hours

CLEAN UP

Use **NORTHSTAR** Lacquer thinner or zero VOC solvents. (Check local regulations)

PHYSICAL DATA

Volume solids as mixed	10%
VOC as mixed	6.0
Color	Grayish green
Dry mills per coat	0.5 maximum

DRY / FLASH TIMES

Air Dry at 77° F

Flash time to topcoat	30 minutes
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Force Dry

Flash before force dry	15 minutes flash
Force dry time	20 minutes at 140° F

GUN SETUPS

Conventional

Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.3 mm – 1.5 mm

AIR PRESSURES

Conventional at Gun

Gravity Feed	30 – 40 psi
Siphon Feed	35 – 45 psi
HVLP at cap	8 – 10 psi

SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) or Final Wipe (S20) to clean substrate free of grease, dirt, and foreign contaminants.

CAUTION: Do not apply body filler, polyester spot putty, polyester primer, or epoxy primer over applied primer.

APPLICATION

- Apply 1 medium wet coat over substrate (0.5 mils maximum)
- Avoid excess film build which may cause adhesion failure
- Clean gun immediately after spraying is completed
- Coating must be dry to a flat finish. Do not apply Topcoat over wet VP404.
- Sand after 8 hours before applying Primer and or Sealer.

SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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