

# BG Coatings **Datasheet**



## **SINGLE PACK ENAMEL PRIMER**

**PRODUCT CODE: SPEP - SERIES**

**TECHNICAL DATA SHEET NO: SPEP-1**

**DATE: OCTOBER 2020**

THIS SUPERSEDES ALL PREVIOUS PUBLICATIONS

<b>PRODUCT DESCRIPTION</b>	A premium quality single component modified alkyd, zinc phosphate primer.	
<b>INTENDED USES</b>	It is an ideal shop or field primer which is designed for corrosion protection of a variety of substrates, such as required in the following segments of the industry: <ul style="list-style-type: none"><li>• Structural steel.</li><li>• Agricultural equipment.</li><li>• Mining equipment.</li><li>• Heavy machinery and plant equipment.</li><li>• Metal and farm implements.</li></ul>	
<b>FEATURES &amp; BENEFITS</b>	<ul style="list-style-type: none"><li>• Good Corrosion resistance.</li><li>• Suitable for applications where a primer with quick drying properties and turnaround is required.</li><li>• Early recoating is possible.</li><li>• Exhibit filling properties and is sand able. Suitable as a Primer Surfacer to prepare surfaces with imperfections to obtain smooth coating systems.</li><li>• May be top coated with Alkyd and 2K Polyurethane Finishes.</li></ul>	
<b>PRODUCT INFORMATION</b>	Appearance	Matt.
	Colour	Grey, Red Oxide.
	Generic type	Modified Alkyd.
	Volume Solids	38%
	S G	1,280 – 1.360 kg/lt.
	Flash point	4°C
	Calculated Max VOC	486 g/ℓ
<b>APPLICATION DETAILS</b>	Mixing	Mix well with a power agitator until completely homogeneous. Remix thoroughly before application.
	Method	<u>Airless Spray:</u> Recommended tip size: 0.017" - 0.019" Nozzle Pressure (minimum): 165 bar (2400 p.s.i.) Thinning is not normally required for application. 5 - 10% BG Coatings <b>Single Pack Enamel Thinner</b> may be added to ease application. <u>Conventional Spray (Pressure Pot):</u> Recommended nozzle orifice: 1.4 - 1.8 mm. Pot Pressure: 70 - 100 kPa (10 - 15 p.s.i.) Gun Pressure: 380 - 410 kPa (55 - 60 p.s.i.) 5 - 10% BG Coatings <b>Single Pack Enamel Thinner</b> may be added to ease application. <u>Brush:</u> Recommended for touch up purposes. <u>Roller:</u> Not recommended.

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Thinning  
Cleaning  
Substrate

SPES - BG Coatings **Single Pack Enamel Thinner.**  
SPES - BG Coatings **Single Pack Enamel Thinner.**  
Suitably prepared steel, galvanizing, and zinc-aluminium.

Application  
Environment

Surface Temperature	Ambient Temperature	Relative Humidity
Min: 10 °C	Min: 10 °C	Min: 10%
Max: 40 °C	Max: 40 °C	Max: 85 %
Or minimum 3 °C above dew point.		

Drying time  
@ 25°C and 50% R.H.

Touch dry	To Handle
15 - 30 minutes	30 - 45 minutes

To Recoat:	Min.	Max.
With Itself	4 hours	Indefinite
With Q.D. Enamel	4 hours	Indefinite
With 2K PU	6 hours	Indefinite

Full cure: 7 Days.

## TYPICAL SPECIFICATIONS

Type	Thickness $\mu$		
	Dry film	Wet film	Dry film
<b>Standard:</b>			
<b>BG Single Pack Enamel Primer</b>	45 - 50 $\mu$ m	118 - 132 $\mu$ m	-
Q.D. Enamel or 2K Polyurethane Finishing	-	-	40 - 50 $\mu$ m
<b>As Primer Surfacer - (Hi - Fill):</b>			
<b>BG Single Pack Enamel Primer</b>	90 - 100 $\mu$ m	118 - 132 $\mu$ m x 2 •	-
Q.D. Enamel or 2K Polyurethane Finishing	-	-	40 - 50 $\mu$ m
• Apply sufficient coats to obtain desired surface finish.			
To control correct film thickness, it is recommended to measure the wet film thickness continuously during application using a wet film thickness measurement comb.			

## COVERAGE

Film thickness and spreading rate	Thickness		Theoretical spreading rate ( $m^2/\ell$ )
	Dry film - $\mu$ m	Wet film - $\mu$ m	
Minimum.	45	118	8.4
Maximum.	50	132	7.6
Typical.	48	125	7.9

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## **SINGLE PACK ENAMEL PRIMER**

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### **PERFORMANCE PROPERTIES**

Temperature resistance:	Up to 120°C dry heat.
Gloss retention:	Fair
Abrasion resistance:	Moderate.
Solvent resistance:	Moderate.
Chemical resistance:	Acids - Not recommended where fumes, splash or spillage might occur. Alkalis - Not recommended where fumes, splash or spillage might occur.
Flexibility:	Good.

### **SURFACE PREPERATION**

The surface to be coated should be clean, dry and free from contamination.

Degrease surfaces with a suitable alkaline detergent.

Surface preparation and coating should normally be commenced only after all welding, degreasing, removal of sharp edges, weld spatter and treatment of welds is complete.

#### HOT ROLLED STEEL:

Optimum performance is achieved by dry abrasive blast cleaning to Sa 2½ or higher (ISO 8501-1) with a blast medium suitable to achieve a sharp and angular surface profile of 50 - 75 µm.

Abrasive blast cleaned surfaces must be primed within 4 hours.

#### NEW COLD ROLLED STEEL:

Degrease thoroughly.

#### GALVANIZING:

Degrease and abrade surfaces with 3M Scotchbrite® pad. Ensure that water sheets off, without breaking whilst rinsing.

#### ZINC-ALUMINIUM:

Degrease and abrade surfaces with 3M Scotchbrite® pad. Ensure that water sheets off, without breaking whilst rinsing.

#### For Hi-Fill Primer Surfacer applications:

If sanding is required, use 220 - 240 grit wet & dry sand paper to prepare before top coating. Allow to completely dry before application of top coats.

### **SAFETY PRE-CAUTIONS**

For complete safety and handling information please refer to the appropriate Safety Data Sheets prior to using the product.

#### Storage:

Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.

#### Handling:

As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 must be worn while handling. Always wash hands before smoking, eating, drinking or using the toilet.

#### During application:

Use with good ventilation and avoid inhalation of spray mists and fumes. When spraying, wear combined organic vapour/particulate respirator. Users must always comply with their respective State Spray Painting Regulations at all times.

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#### Flammability:

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO2 or dry chemical powder. On burning will emit toxic fumes.

#### Annex:

Always use appropriate dust masks whilst sanding this product.

### **STORAGE AND PACKING**

Shelf Life: 12 months at 25°C - from date of manufacture. Subject to inspection thereafter.

Store in dry conditions out of direct sunlight away from source of heat or ignition. Store at temperature between 5 and 35°C

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### **PACK SIZE**

#### Single pack:

Available in 4 lt. and 20 lt. cans.

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### **DISCLAIMER:**

The recommendations contained herein are given in all good faith and are meant to guide the specifier or the user. They are based on results gained from our tests and experiences and are believed to be reliable. No guarantee is implied by the recommendations contained herein since conditions of use, method of application and cleanliness of the substrate prior to painting are beyond our control.

**N.B.** Technology may change with time necessitating changes to this Technical Data Sheet (TDS). It is the responsibility of the user to ensure that the latest TDS is being used.

### **MANUFACTURED BY BG COATINGS**

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