

## ViterLac 305 Vinyl Acrylic Primer/Finish

<b>Product Description</b>	<b>A one coat* vinyl acrylic anticorrosive primer/finish</b> for steelwork and galvanising.				
<b>Features &amp; Use</b>	<ul style="list-style-type: none"> <li>• Where a one coat*, semi-gloss primer/finish is required</li> <li>• Can be applied to degreased new galvanising without the need for an etch primer</li> <li>• Use for gates, fences, street furniture and structural steelwork</li> <li>• Resistant to weak acids and alkalis</li> <li>• Highly moisture resistant</li> <li>• Available in a wide colour range</li> </ul>				
<b>Approvals/ Certification</b>	Please consult Axalta Coating Systems				
<b>Finish</b>	Semi-gloss				
<b>Volume Solids</b>	30 ± 2% (varies with colour)				
<b>VOC Content</b>	603 ± 20 g/litre (varies considerably with colour)				
<b>Film Thickness Range And Coverage</b>		<b>Dry Film Thickness</b>	<b>Wet Film Thickness</b>	<b>Theoretical Coverage</b>	
	<b>Minimum</b>	75 µm	250 µm	4.0 m <sup>2</sup> /litre	
	<b>Maximum</b>	100 µm	333 µm	3.0 m <sup>2</sup> /litre	
Practical coverage depends on the application method, painting conditions and the shape and roughness of the surface to be coated					
<b>Drying Times</b>	Applied to 75 microns DFT		<b>+10°C</b>	<b>+23°C</b>	<b>+35°C</b>
	<b>Dust Free</b>		45 min	15 min	10 min
	<b>Hard Dry</b>		6 hr	3 hr	2 hr
	<b>Overcoating</b>	Minimum	12 hr	6 hr	3 hr
		Maximum	Indefinite if clean and sound		
Drying and recoating times are related to the film thickness, temperature, the relative humidity of the air and ventilation					
<b>Colours</b>	BS and RAL shades by in-can tinting				
<b>Product Code</b>	<b>6305</b>				
<b>SG</b>	1.11 kg/lit (varies with colour)				
<b>Storage Conditions</b>	Store in dry, cool conditions and protect from frost				
<b>Shelf Life</b>	Minimum 12 months if stored as above in unopened containers				
<b>Flash Point</b>	23-60°C				

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<p><b>Surface Preparation</b></p>	<ul style="list-style-type: none"> <li>All surfaces to be coated should be dry and cleaned as necessary to remove all oil, grease, salts, weld flux or other contamination. Where necessary, remove weld spatter and grind smooth all sharp edges and weld seams</li> <li><b>Steelwork:</b> Blast clean to Sa2½ (ISO 8501-1:2007), surface profile 50-75 microns</li> <li><b>Galvanising:</b> thoroughly degrease and lightly abrade any very shiny areas</li> </ul>														
<p><b>Mixing</b></p>	<p>Must be mixed thoroughly by using a mechanical agitator before use. Agitate periodically to ensure paint remains homogeneous.</p>														
<p><b>Thinner</b></p>	<p>1006 Thinner</p>		<p><b>Equipment Cleaner</b> 1006 Thinner</p>												
<p><b>Application Conditions</b></p>	<p>Only apply in conditions of good ventilation which must be maintained during drying and curing. Do not apply when rain, mist, sleet or snow are imminent. During application and drying time of the paint coating, the surface should be dry, the Relative Humidity should not exceed 85% and the steel temperature should remain at least 3°C above the dew point. Paint temperature should ideally be at a minimum of 15°C.</p>														
<p><b>Application Methods</b></p>	<table border="1"> <thead> <tr> <th data-bbox="419 902 675 981">Method</th> <th data-bbox="675 902 922 981">Airless Spray</th> <th data-bbox="922 902 1169 981">Conventional Spray</th> <th data-bbox="1169 902 1337 981">Brush</th> <th data-bbox="1337 902 1493 981">Roller</th> </tr> </thead> <tbody> <tr> <td data-bbox="419 981 675 1037"></td> <td data-bbox="675 981 922 1037">Yes</td> <td data-bbox="922 981 1169 1037">Yes</td> <td data-bbox="1169 981 1337 1037">Yes</td> <td data-bbox="1337 981 1493 1037">No</td> </tr> </tbody> </table>					Method	Airless Spray	Conventional Spray	Brush	Roller		Yes	Yes	Yes	No
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<ul style="list-style-type: none"> <li>Airless Spray: Output fluid pressure at tip 2000 psi, Tip Size 17-21 thou (0.43-0.53 mm)</li> <li>Thinning will reduce the film build</li> <li>Application by brush will result in a reduced film thickness and is recommended only for small areas of touch up/remedial work</li> </ul>															
<p><b>Product Notes</b></p>	<ul style="list-style-type: none"> <li>Overcoat with itself only</li> <li><b>When applied to bare (non-galvanised) steel:</b> in common with most single pack primers and primer/finishes, this product is not recommended for extended exterior exposure, or exposure in aggressive or coastal locations, or for immersion. Epoxy primers are preferred for these conditions, please consult Axalta Coating Systems for advice</li> <li>*Colours such as yellows, reds and oranges have lower opacity, especially when produced using lead-free pigments. Two or three coats of these shades may be required, relative to only one coat of a grey or red oxide, so that yellows, bright reds and oranges may not be suitable as one coat systems</li> </ul>														
<p><b>Health &amp; Safety</b></p>	<p>Containers are provided with safety labels which should be observed. Further information about hazardous influences and protection are detailed in individual Product Safety Data Sheets. A Safety Data Sheet for this product is available on request from Axalta Coating Systems.</p>														

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