Grey Alloy Wheel Primer

617-15070P-4536

Product Description
A silver grey coloured epoxy-polyester powder coating primer specifically designed as a basecoat for alloy wheels prior to either liquid paint or powder coating finish coats.

Key Benefits
Excellent levelling (smoothness)
Very good chemical resistance
Excellent adhesion to substrate
Excellent overcoatability and intercoat adhesion
Sandalie coating
Good out-gassing properties
Does not contain ecologically toxic materials such as zinc

Powder Properties
Chemistry - A thermosetting epoxy-polyester resin system.
Application - Corona electrostatic spray.
Coating Thickness - Depending on covering power and shade, general recommendation is 60-100 microns (μm), with a minimum thickness of 60 μm.
Gloss (ISO 2813) - 70% ± 5 on a 60 degree head
Specific Gravity - 1.65 ± 0.1 g/cm³
Theoretical Coverage - Approximately 10 m²/kg at 60 microns film thickness.
Storage & Shelf Life - When stored in a cool (<20°C), dry environment: 12 months.
Curing Schedule - 10 minutes at 180 Celsius (object temperature)

Pretreatment
To ensure maximum adhesion the substrate must be thoroughly clean and free from grease or any other contaminant. For maximum protection it is essential to pre-treat wheels before application of the powder coating. Aluminium alloys are typically treated using a chromat837_Polyester conversion coating, however non-chromate treatments are available. Discuss the performance requirements with the treatment chemical supplier.

Mechanical Tests
Unless otherwise specified, all tests were carried out under laboratory conditions on 0.8mm degreased and chromated aluminium panels. A powder coating DFT of 60-70 microns was used, followed by a second coat of Alloy Wheel High Gloss Black Polyester to 60-70 microns.

Hardness (primer) - ISO 2815 Buchholtz Indentation - >80
Flexibility (primer) - ISO 1519 Cylindrical Mandrel - Pass >5mm
Adhesion (primer) - ISO 2409 2mm Crosshatch - Pass G10
Cupping (primer) - ISO 1520 Erichsen - Pass >5mm
Impact (primer) - BS 3900: Part E7 - >25kg cm (N)
Intercoat Adhesion - Hoffman Scratch Test - >1500g
## Grey Alloy Wheel Primer

<table>
<thead>
<tr>
<th>Corrosion and Durability</th>
<th>Neutral Salt Fog: ASTM B117 (500 hours)</th>
<th>Corrosion creep &lt;2mm from scratch Adhesion – Gt0</th>
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</thead>
<tbody>
<tr>
<td></td>
<td>Boiling Water: 2 hours boiling water</td>
<td>No defects or detachments</td>
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<tr>
<td></td>
<td>Humidity: BS 3900 Part F2</td>
<td>More than 1000 hours without effect</td>
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</tbody>
</table>

| Colour Availability                     | A light silver grey, approximately RAL 7001 |

### Application Tips
- Care should be taken to ensure an adequate key for the second coat; over-curing the primer or handling the surface without gloves can compromise the inter-coat adhesion.
- Degrease and profile the aluminium alloy using a light blast or a suitable etch primer
- Apply Alloy Wheel Primer to a coating build of at least 60 microns
- Cure the primer, but do not over-bake
- Apply and cure the top coat as soon as possible after applying primer. Discuss application parameters with the spray equipment supplier; generally reducing kV and μA to as low as possible will help penetration to difficult recesses. Handle only with gloves over-coating. The second coat may be applied whilst the primer is still warm.

Should over-curing have occurred or where handling has been unavoidable, the primer may need to be slightly abraded.

### Restriction of Hazardous Substances (RoHS/RoHS2)
This product conforms to the Restriction of the Use of Certain Hazardous Substances in Electrical and Electronic Equipment Regulations (RoHS and RoHS2) Directive. It does not contain any compounds of lead, mercury, cadmium or hexavalent chromium; nor does it contain polybrominated biphenyls (PBBs) or polybrominated diphenyl ether (PBDE).

Please refer to our statement on RoHS, available at [www.hmgpowdercoatings.com](http://www.hmgpowdercoatings.com)

### Health & Safety
This product is intended for use only by professional applicators in industrial environments. Consult the relevant health and safety data sheet indicated in the box label before use.