METALSHIELD® ETCH PRIMER
Ready For Use Universal Etch Primer

FEATURES
• READY FOR USE
• RAPID DRY AND FAST RECOAT
• IDEAL FOR PRIMING ALL Ferrous AND NON-FERROUS METALS
• SUITABLE FOR APPLICATION DIRECT TO FIBREGLASS SURFACES
• WIDE RANGE OF TOPCOAT TYPES CAN BE USED
• TOUCHUP SPRAYPAKS AVAILABLE

USES
METALSHIELD® ETCH PRIMER is a fast-cure etch primer for shop or site application over suitably prepared metal substrates, ready to overcoat in only 10 minutes under normal conditions. METALSHIELD® ETCH PRIMER is ideal where high adhesion, fast turn around and single pack convenience are required.

METALSHIELD® ETCH PRIMER can be used over appropriately prepared aluminium, zinc coated steel, stainless steel, mild steel and other non-ferrous metals. Also suitable for application direct to fibreglass surfaces. Intended for application direct to prepared metal surfaces or as a spot primer for exposed metal/fibreglass surfaces only.

SPECIFICATIONS
AS/NZS 3750.17 Type 1

RESISTANCE GUIDE
WEATHERABILITY
Will chalk on exterior exposure. Use a weatherable topcoat.

SOLVENTS
Resists splash and spillage of aliphatic and aromatic hydrocarbons

HEAT RESISTANCE
Up to 65°C dry heat

WATER
Resists rain and condensation when suitably topcoated. Not recommended for permanently damp or immersed exposure

SALTS
Unaffected by splash and spillage of most salt solutions

ALKALIS
Suitable for splash and spillage exposure to weak alkalis with suitable topcoat

ACIDS
Suitable for splash and spillage exposure to weak acids with suitable topcoat

ABRASION
Fair

TYPICAL PROPERTIES AND APPLICATION DATA
CLASSIFICATION
Ready for use universal etch primer

APPLICATION CONDITIONS
Air Temp. 10°C 45°C
Substrate Temp. 10°C 45°C
Relative Humidity 85%

COATING THICKNESS (MICRONS)
Wet film per coat (μm) 125 188
Dry film per coat (μm) 10 15

SUITSABLE SUBSTANCES
Mild steel, aluminium, galvanized steel, stainless steel and fibreglass

TOPCOATS
Single and two pack Dulux® topcoats

APPLICATION METHODS
Conventional spray and HVLP spray

DRYING CHARACTERISTICS AT 10 μm DRY FILM THICKNESS*

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>OVERCOAT</th>
</tr>
</thead>
<tbody>
<tr>
<td>25°C</td>
<td>50%</td>
<td>10 Minutes</td>
<td>30 Minutes</td>
<td>45 Minutes</td>
<td>10 Minutes</td>
</tr>
</tbody>
</table>

* These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

SPREADING RATE
8.0 square metres per litre equals 10 μm dry film thickness

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.
**METALSHIELD® ETCH PRIMER**

**TYPICAL SYSTEMS**

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

<table>
<thead>
<tr>
<th>SURFACE</th>
<th>ENVIRONMENT</th>
<th>PREPARATION GUIDE</th>
<th>SYSTEM</th>
<th>DFT (μm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>STEEL – NEW</td>
<td>Low corrosivity</td>
<td>Power tool clean AS1627.2</td>
<td>1st Coat Metalshield® Etch Primer</td>
<td>10 μm</td>
</tr>
<tr>
<td></td>
<td>(AS2312.1 Cat C1-2)</td>
<td>Abrasive blast AS1627.4</td>
<td>2nd Coat Metalshield® Etch Primer</td>
<td>50 μm</td>
</tr>
<tr>
<td>STEEL – NEW</td>
<td>Low corrosivity</td>
<td>Power tool clean AS1627.2</td>
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<td>10 μm</td>
</tr>
<tr>
<td></td>
<td>(AS2312.1 Cat C1-2)</td>
<td>Abrasive blast AS1627.4</td>
<td>2nd Coat Luxathane® HPX</td>
<td>50 μm</td>
</tr>
<tr>
<td>NON FERROUS</td>
<td>Exterior/Interior</td>
<td>Clean, degrease and abrade</td>
<td>1st Coat Metalshield® Etch Primer</td>
<td>10 μm</td>
</tr>
<tr>
<td>METALS AND</td>
<td></td>
<td>surface</td>
<td>2nd Coat Metalshield® Etch Primer</td>
<td>50 μm</td>
</tr>
<tr>
<td>FIBREGLASS</td>
<td></td>
<td></td>
<td>Metalshield® Premium Enamel</td>
<td></td>
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</tbody>
</table>

**NOTES:** If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity.

**SURFACE PREPARATION**

**Steel:** Round off all rough welds, sharp edges and remove weld spatter. Remove grease, oil and other contaminants in accordance with AS1627.1. Degrease with Gamlen CA 1 (a free-rinsing, alkaline detergent) according to the manufacturer’s written instructions and all safety warnings. Abrasive blast clean to a minimum of AS1627.4 Class 2.5 with a blast profile of 40 – 70 microns. Remove all dust brushing or vacuum.

**Steel where abrasive blast cleaning is not viable:** Rust, mill scale, oxide deposits and old paint films on metal surfaces must be removed by power tool cleaning according to AS1627.2 Class 2. Coating performance is proportional to the degree of surface preparation.

**Non-ferrous metals:** Round off all sharp edges. Remove grease, oil and other contaminants in accordance with AS1627.1. Whip blast with fine non-metallic media such as plastic, glass or garnet to provide a key. Remove all dust with compressed air. Alternatively, degrease and abrade the surface with a non-metallic abrasive pad wetted with Gamlen CA 1 (a free-rinsing, alkaline detergent) and water. Rinse thoroughly with fresh potable water.

**APPLICATION**

**BRUSH/Roller**

Recommended only for spot patching on rivets, seams, etc.

Thinning not required but up to 50ml/litre with Metalshield® Etch Primer Thinner (965-H0011) may be used to aid atomisation. Apply in multiple wet coats overlapping each pass 50%.

Typical Set-up

- Graco AirPro: 1.4mm (239542)
- Pressure at Triton 308: 70-100 kPa (10-15 p.s.i.)
- Pressure at Gun: 380-410 kPa (55-60 p.s.i.)
- HVL: 1.4 Fluid Tip

**AIRLESS SPRAY**

Not recommended

Refer to the details located on the back of the Touchup Spraypak aerosol can. Note – a slight colour variation may occur compared to the standard product due to film build, application methods and technique.

This is an industrial product designed for use by experienced Protective Coatings applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® Consultant for advice prior to painting.

Do not apply in conditions outside the parameters stated in this document without the written consent of Dulux® Australia. Do not apply at temperatures below 5°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Do not apply over scale bearing steel. Abrasive blast cleaned surfaces must be primed within 4 hours. Excessive film thickness should be avoided as this may result in delamination.

**CLEAN UP**

Clean all equipment with Metalshield® Etch Primer Thinner (965-H0011) immediately after use.

**OVERCOATING**

Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200 -1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating.

**SAFETY PRECAUTIONS**

Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au

**PACKAGING, TRANSPORT AND STORAGE**

<table>
<thead>
<tr>
<th>DESCRIPTION</th>
<th>VALUE</th>
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<tbody>
<tr>
<td><strong>PACKAGING</strong></td>
<td>Available in 1, 4 and 15 litre cans</td>
</tr>
<tr>
<td><strong>TRANSPORTATION WEIGHT</strong></td>
<td>0.88 kg/litre</td>
</tr>
<tr>
<td><strong>DANGEROUS GOODS</strong></td>
<td>Class 3 UN 1283 Aerosols Class 2 UN 1950</td>
</tr>
</tbody>
</table>

Any advice, recommendation, information, assistance or service provided by Dulux Australia in relation to goods manufactured by it or their use and application is given in good faith and is believed to be Dulux to be appropriate and reliable. However, any advice, recommendation, information, assistance or service provided by Dulux is provided without liability or responsibility PROVIDED THAT the foregoing shall not exclude, limit, restrict or modify the right entitlements and remedies conferred upon any person or the liabilities imposed upon Dulux by any condition or warranty implied by Commonwealth, State or Territory Act or ordinance void or prohibiting such exclusion limitation or modification. Products can be expected to perform as indicated in this sheet so long as applications and application procedures are as recommended. Specific advice should be sought from Dulux for application in highly corrosive areas and for large projects to ensure proper performance.