



# TECHNICAL DATA SHEET

## STOKES SINGLE PACK ETCH PRIMERS (CHROMATE FREE)

Reference	Revision No	Revision Date	Printed	Page 1 of 2
IPETCF	2	15 October 2009	20 March 2012	

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<b>Properties and Uses</b>	<p>PROPERTIES</p> <p>Etch primers protect ferrous metal surfaces and enhance the adhesion of subsequent coats of paint by forming a light phosphate coating on the metal. These primers will considerably improve the adhesion of most paint systems to aluminium and other light alloys. Protection against corrosion for interior environments is good, but when exposing etch primers outside it is recommended that a more substantial coating is applied over the etch primer at the earliest opportunity (preferably within 2 - 3 weeks).</p> <p>USES</p> <p>Etch primers can be used as temporary rust preventative coatings on both ferrous and non-ferrous metal substrates which are finished but await final assembly. These primers are suitable for use with most finishing systems i.e. air drying or stoving points. However for best results thin films of primer give better performance than thick coats. Ideally a dry film thickness of 0.5 thou (approx 13 microns) should be spray applied as a full 'wet' coat.</p>
<b>Technical Data</b>	<p>TYPE.</p> <p>One pack phosphate etching composition.</p> <p>DRYING TIME.</p> <p>About 30 minutes to BS3900 part C2, but maximum adhesion only develops after 24 hours. A further paint coat may be applied after a few minutes and the films will dry or cure together. Handleable in 10 minutes. Slightly superior corrosion resistance is obtained if the etch primer is stoved for 10 minutes at 120°C.</p> <p>THEORETICAL SPREADING CAPACITY.</p> <p>Etch Primer should be applied in very thin coats. Approx. 10 - 13 sq. metres per litre to achieve a dry film thickness of 0.5 thou (approx 13 microns).</p> <p>FLASH POINT.</p> <p>Below 21°C. HIGHLY FLAMMABLE LIQUID.</p> <p>NON VOLATILE CONTENT</p> <p>These figures will vary upon the pigmentation used but are normally within the following ranges:</p> <p>By volume 12 - 16%. By weight 19 - 30%.</p> <p>VOC</p> <p>Etch Primers from this range are typically between 680 -720 g/lit.</p> <p>THINNERS AND CLEANING SOLVENT.</p> <p>Stokes Cellulose Thinners Ref. TH001.</p> <p>HEAT RESISTANCE.</p> <p>Up to 150°C.</p> <p>LEAD CONTENT.</p> <p>Below 0.25% on the Dry Film.</p> <p>COLOUR RANGE.</p> <p>Light Grey - IP136 Black - IP220 Other colours available by special arrangement.</p>
<b>Stock Container Sizes</b>	5 and 20 litre containers.

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<b>Processes</b>	<p>STIR PRIMER WELL BEFORE USE.</p> <p>PREPARATION. The surface to be painted must be clean, dry and entirely free from grease, dust, dirt, rust and peeling or loose material or any other form of contamination. See Stokes Technical Data Sheet Systems for Metal. NOTE : The etch primer has no filling properties and will not conceal any imperfections in metal surfaces.</p> <p>FINISHING. Most types of paint can be applied over Stokes Etch Primer including air drying, stoving enamels, cellulose etc.</p>
<b>Application</b>	<p>BRUSH. Only ONE coat of this primer must be applied. Etch Primer may be applied as supplied when it is necessary to cover sharp edges etc. For large flat surfaces an addition of Stokes Thinners Ref. TH001 may be made to obtain the very thin coat that is required.</p> <p>ROLLER. Only ONE coat of this primer must be applied. Etch Primer may be applied as supplied when it is necessary to cover sharp edges etc. For large flat surfaces an addition of Stokes Thinners Ref. TH001 may be made to obtain the very thin coat that is required.</p> <p>DIPPING. Only ONE coat of this primer must be applied. Etch Primer may be applied as supplied when it is necessary to cover sharp edges etc. Thin as necessary with Stokes Cellulose Thinners Ref TH001 to suit the article being painted.</p> <p>CONVENTIONAL SPRAY. Only ONE coat of this primer must be applied. Etch Primer may be applied as supplied when it is necessary to cover sharp edges etc. Thin as necessary with Stokes Cellulose Thinners Ref. TH001 to obtain the very thin coat that is required.</p> <p>AIRLESS SPRAY. Only ONE coat of this primer must be applied. Etch Primer may be applied as supplied when it is necessary to cover sharp edges etc. Thin as necessary with Stokes Thinners Ref. TH001 to obtain the very thin coat that is required.</p> <p>ELECTROSTATIC SPRAY. Only ONE coat of this primer must be applied. Etch Primer may be applied as supplied when it is necessary to cover sharp edges etc. Thin as necessary with Stokes Thinners Ref. TH001 to obtain the very thin coat that is required. For low resistance use Stokes Thinners Ref. TH009. NOTE : For further advice refer to Stokes Technical Service Dept.</p>
<b>Storage</b>	<p>Use within 6 months of delivery. Keep in original containers until required for use. Partly used containers should be re-sealed securely and stored according to the recommended manner. (see section 7 of Stokes Material Safety Data Sheet Ref. IPETCF)</p>
<b>Health and Safety</b>	<p>THIS MATERIAL IS HIGHLY FLAMMABLE. REFER TO STOKES MATERIAL SAFETY DATA SHEET REF. IP136 OR IP220 FOR FULL DETAILS OF FIRST AID, FIRE FIGHTING, ACCIDENTAL RELEASE, HANDLING, EXPOSURE CONTROLS / PERSONAL PROTECTION AND DISPOSAL.</p>
<b>Disclaimer</b>	<p>The above information is for guidance only. It is given in good faith but without warranty. Users should first carry out their own trials to ascertain the suitability of the product for their intended purpose.</p> <p>This Data Sheet supercedes all previous Data Sheets supplied to you relating to this product. It contains important information which must be communicated to the user. The user must satisfy himself of the suitability of the product for the intended application and surface, as surface and application conditions are beyond the control of R.J.Stokes &amp; Co Ltd. The user must also satisfy himself of the suitability of the product in circumstances other than those set out in this data sheet. The user should also maintain appropriate control procedures. Should further information be required, please contact our Technical Department.</p> <p>R.J.Stokes &amp; Co. Ltd. employ a policy of continuous development and the technical data could be revised as a result of experience or new information becoming available.</p>