

# solvatic PVB-Primer PG15

## Protective Coatings

## Industrial Coatings

## Automotive Coatings

## Construction Coatings

## Decorative Coatings

- ▶ Article number: **PG15/0039A0DN**
- ▶ Reference colour: approx. RAL 3009, red brown
- ▶ Colour shades: RAL-colour shades, special tints on request
  
- ▶ **Medium Solid**
  
- ▶ fast drying
- ▶ universally usable
- ▶ can be welded over
- ▶ low total porous area
- ▶ test certificates available
- ▶ 2C recoatable

### Product description:

Solvatic PVB-Primer PG15 is a one component, lead and chromate free, universally usable production coating material based on polyvinylbutyral with a flashpoint above 23°C.

It is quick drying, can be welded over without any problem, low total porous area, 6.6 mm<sup>2</sup> according to test certificate no 8934040/2, no overrun of the MAK-values according to test certificate 9134039/a of the SLV-Duisburg.

The product has very good adhesion on steel, galvanised steel, aluminium and it can be recoated with 1C and 2C products.

### Applications:

It is a shopprimer (welding primer) and bonding agent for critical metal surfaces. It is used for automatical preservation plants and for mechanical engineering where quick recoating is necessary.

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**Hardener:** n.a.

**Thinner:** solvatic EP-thinner VK14-000000DN, also for cleaning the working tools

### Technical data:

Flash point: above +23°C  
 Viscosity – original packaging: 45-50 sek./4mm / 20°C (DIN 53211)  
 Viscosity – for application: 45-50 sek./4mm / 20°C (DIN 53211)  
 Density: approx. 1,09 g/ml  
 Mixture ratio: n.a.  
 Pot life: open

Dry film thickness (DFT): 15 - 30 µm  
 Gloss level: matt  
 Theoretical coverage: approx. 8.21 m<sup>2</sup>/kg at 20 µm DFT  
 Solids content at volume: approx. 18 %  
 Solids content at weight: approx. 37 %  
 Org. solvent percentage: approx. 63 %  
 VOC value: approx. 680 g/l  
 Temperature stability: max. +150°C dry heat

### Drying times:

Dust-dry: after approx. 4 hours  
 Fast to handling: after approx. 30 minutes  
 Ready for rework: after approx. 3 hours  
 Additional accelerating by heat is possible

The values indicated apply to a dry film thickness of 20 µm at +20°C and 65% relative humidity of air.

### Working temperature

+5°C to +35°C / max. 85 % rel. humidity of air

The substrate temperature must be at least 3°C above the dew point of the ambient air. The relative humidity of air should not exceed 85%.

### Surface preparation:

**Steel:** Abrasive blasting after preparation grade Sa 2 1/2 of the norm DIN EN ISO 12944, Part 4.  
 Prior to application of further coatings the primed surface has to be cleaned carefully from separating substances.

**Galvanised Steel:** Surface must be free of all kind of adhesion reducing impurities such as e.g. oil, grease, dirt particles.  
 Corrosion products of zinc have to be removed by suitable cleaning measures.  
 For more information regarding surface pre-treatment please see DIN EN ISO 12944, part 4.

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Aluminium and  
Stainless steel

All adhesion reducing deposits and impurities must be removed. In case of stainless steel the surface must be roughened by grinding or abrasive blasting, e.g. with glass beads. Only mineral abrasives are suitable.

### Subsequent coating:

Depending on requirements, novatic products on basis of polyurethane, alkyd and epoxy resin are suitable.

### Application:

Brushing/Rolling: For the application by brush or by roller a sufficient evenness and density of pores is not possible due to the low film thickness and viscosity.

High pressure  
Spraying: Processing in delivery viscosity.  
Air pressure: 3 – 4 bar  
Nozzle: 1.5 – 2mm  
Depending on workpiece and nozzle size the material can be thinned up to 25sec/4mm.

Airless-Spraying: Almost exclusively by airless application in automatic blast- and coating plants.  
Minimum pressure: 120 bar  
Nozzle: 0.24 – 0,38 mm  
The optimal adjustment of the individual plant should be evaluated together with our application technician on site.

### Repair of transport and installation damage:

Recommended surface preparation: Abrasive blasting of flaws to preparation grade Sa 2 ½ of the norm DIN EN ISO 12944 Part 4. Repair with a suitable primer coating (as mentioned in point "subsequent coating").

### Storage and identification according to hazardous substance / workplace safety regulations:

For other labelling according to valid hazardous substance regulations see the associated Material Safety Data Sheets and labels.

### Storage life:

Approx. 12 months in case of proper storage of non-opened drums at +5 °C to +25 °C. Please protect from heat and freeze.

### Safety and protection measures:

At processing please respect the field given regulations for safety and health measures BGR 500, chapter 2.29 as well as the actual EC safety directives. When liquid the contents must not be let out into waste waters.

Data and recommendations are appropriate for up to date state of product and are made for information of our buyers. This does not free the buyer of testing the products on appropriation and application of the products. We guarantee for spotless quality in the frame of our common conditions of business. Herewith all previous technical data ceases to be valid.

### For more information, please contact:

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