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RUDRA PAINT



PLOT NO. 60/61, PANDOL INDUSTRIAL AREA, VED ROAD, KATARGAM,
SURAT, GUJARAT -395004

TECHNICAL DATA SHEET RP- 605

ETCH PRIMER

Product Description

A fast-drying, chromate-free etch primer designed for application over bare steel, aluminum, and galvanized surfaces. Provides superior adhesion for subsequent paint layers and inhibits corrosion.

Recommended Uses

- Bare mild steel, galvanized steel, stainless steel, and aluminium.
- Automotive, industrial, and general metal finishing.
- Not intended for direct-to-plastic or flexible substrates.

Surface Preparation

- Substrate must be clean, dry, and free from oil, grease, and rust.
- Abrade metal using P280–P320 grit abrasive.
- Remove dust and degrease with a solvent cleaner.

Mixing / Thinning

- Mix ratio: Base For Hardener 1 (2 K system) 4/1 Ratio .
- Thinning (if required): Use up to 10% recommended reducer.
- Pot life: Not applicable

Application Guidelines

- Application method : Spray only.
- Gun setup : 1.2–1.4 mm fluid tip, 2.0–2.5 bar pressure.
- Coats : 1–2 light coats.
- Wet Film Thickness (WFT) : 20–30 μm per coat.
- Dry Film Thickness (DFT) : 8–15 μm .
- Flash time between coats : 3–5 minutes.

Drying Times (at 23 °C, 50% RH)

- Touch dry : 10–15 min
- Handle dry : 20–30 min
- Sandable : 60 min
- Overcoat window : 15–30 min (apply primer/topcoat directly)
- Full cure : 24 hrs

Over coating

- Suitable for most 1K and 2K primers, fillers, and topcoats.
- Must be over coated within 24 hours. If exceeded, lightly abrade before recoating.

Physical Properties

- Colour : Yellow / Green (depending on variant)
- Finish : Matt
- Density : $\sim 1.0 \text{ g/cm}^3$
- Viscosity : $\sim 2000 \text{ cP}$ at 20 °C
- Volume solids : 15–20%
- VOC content : Approx. 600–650 g/L
- Flash point : $-18 \text{ }^\circ\text{C}$
- Coverage (theoretical): $\sim 8\text{--}10 \text{ m}^2/\text{L}$ at 10 μm DFT

Performance Data

- Excellent adhesion to ferrous and non-ferrous metals.
- Provides a corrosion-resistant basecoat.
- Heat resistance: up to 120 °C dry.

Storage & Shelf Life

- Store in a cool, dry, well-ventilated area.
- Keep container tightly closed.
- Protect from heat and ignition sources.
- Shelf life: 24 months (unopened container at 5–25 °C).

Health & Safety

- Highly flammable liquid and vapour.
 - Causes skin and eye irritation.
 - Use in well-ventilated areas only.
 - Wear suitable PPE: gloves, goggles, respirator, protective clothing.
- Refer to Safety Data Sheet (SDS) for full information.

Disclaimer

This information is based on current knowledge and is intended as a guide. Users must confirm suitability for their specific application. The manufacturer accepts no liability for improper use



Mfg by **RUDRA ENTERPRISE**

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