

CF Metal Primer 156

- 1. Introduction** ALEXSEAL® CF Metal Primer 156 is a chromate free, high solid epoxy-based primer designed for priming metal surfaces where excellent corrosion protection and chemical resistance is required.
- 2. Range of application** ALEXSEAL® CF Metal Primer 156 is designed to prime and seal old and new, properly prepared, metal surfaces prior to the application of ALEXSEAL® Topcoats or ALEXSEAL® Finish Primer 442. This product is ideal for masts, parts and thin gauge metal where minimal fairing is required. It may be topcoated or primed depending on the application requirements. CF Metal Primer 156 may be used above and below the waterline.
- 3. Color** Colors of mixture: Ivory (White-Yellow blend)
- 4. Coverage** Coverage for ALEXSEAL® CF Metal Primer 156 when applying 1 - 2 coats or passes in the same application period.
Volume Solids catalyzed without reduction: 50%.
Theoretical: 22 m² / l (876 sq. ft. per gallon) at recommended dry film thickness of 25 microns (1 mil).
Practical:
Conventional Air Spray Equipment: 7.3 m² / l (300 sq. ft. per gallon) at recommended dry film thickness of 25 microns (1 mil).
HVLP Air Spray Equipment: 8.5 m² / l (350 sq. ft. per gallon) at recommended dry film thickness of 25 microns (1 mil).
Brush / Roller: 18 m² / l (750 sq. ft. per gallon) at recommended dry film thickness of 25 microns (1 mil)
Airless Spray Equipment: 10 m² / l (400 sq. ft. per gallon) at recommended dry film thickness of 25 microns (1 mil).
- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust, grease, oil and other contamination.
ALEXSEAL® CF Metal Primer 156 may be applied directly to the properly cleaned and prepared Aluminium or Steel substrate to achieve optimum adhesion and performance:
Steel should be sanded or blasted to white metal (SSPC-SP5-85).
Aluminium should be sanded with 80-180 grit or blasted depending on thickness of primer surfacer used over CF Metal Primer 156. 180-220 grit can be used when over coating CF Metal Primer 156 directly with Alexseal® Topcoat 501. Bright clean aluminium should always be achieved before application. The use of Alumiprep® or Alumiprep® and Alodine® treatment may be used as an option to clean and treat the aluminium. Please contact your Alexseal® Representative to discuss additional chemical treatment options.
- 6. Trade names**
- | | | |
|---------------|-------|---|
| Base Material | P1566 | ALEXSEAL® CF Metal Primer 156, Yellow |
| Converter | C1567 | ALEXSEAL® CF Metal Primer 156 Converter |
| Reducer | R4042 | ALEXSEAL® Epoxy Primer Reducer |
- 7. Mixing ratio**
- | | | |
|-------------------|-------|---|
| 2 parts by volume | P1566 | ALEXSEAL® CF Metal Primer 156 Base |
| 1 part by volume | C1567 | ALEXSEAL® CF Metal Primer 156 Converter |
| 1 part by volume | R4042 | ALEXSEAL® Epoxy Primer Reducer |
- Allow a 15 minute induction period after mixing base and converter, add reducer and remix.
Example: 2 : 1 : 1 = 33% reduction for spray application

Professional Use Only

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The information contained in this data sheet is based on our level of research and development. Revisal by the user with regard to the intended aim is necessary due to the diverse processing and application possibilities. revision July 2008

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Technical Data Sheet:

153-44 / P1566

8. Application

Viscosity (Zahn #2)	approx. 15 sec
Fluid Nozzle Size Pressure Pot	1.0 to 1.2 mm (0.040 to 0.046) - Conventional & HVLP
Fluid Nozzle Size Siphon Cup	1.6mm (0.070) - Conventional & HVLP
Atomizing Pressure	3.0 to 5.0 bar (42 to 70 PSI) - Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 15 PSI) - Conventional & HVLP
Airless Equipment	Tip 0.22mm – (0.009) to 0.012 – (0.3 mm) – 50-65° fan
Airless Equipment	Pressure 2 to 4 bar (30 to 56 PSI)

Spray

Apply 1 to 2 coats to a wet film thickness (WFT) of 40-50 microns (1.5-2.0 mil). This will achieve a dry film thickness (DFT) of 25 microns (1 mil). Minimum recommended film is 25 microns (1 mil) DFT. Maximum recommended film thickness during a spray application is 2 coats totaling 40-50 microns (1.5-2.0 mil) WFT, or 25 microns (1 mil) DFT.

9. Pot life and Drying

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Dry Time
Pot Life - approx.	12 hrs	12 hrs	12 hrs	12 hrs	N/A
Dust Free	90 min	60 min	45 min	30 min	N/A
Tape Dry	30 hrs	24 hrs	18 hrs	14 hrs	N/A
Fully Cured	10 days	8 days	7 days	6 days	N/A
Recoat with another coat of ALEXSEAL® CF Metal Primer 156	3 hrs minimum	2 hrs minimum	1 hr minimum	1 hr minimum	24 hrs maximum
Overcoat with another product including 442, and 501. Sanding is required after max time.	5 hrs minimum	4 hrs minimum	3 hrs minimum	3 hrs minimum	24 hrs maximum

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity of reducer, and film thickness will effect actual times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F).

10. Packaging

P1566	ALEXSEAL® CF Metal Primer 156, Yellow	1 QT & 1 Gal
C1567	ALEXSEAL® CF Metal Primer 156, Converter	1 PT & 1/2 Gal
R4042	ALEXSEAL® Epoxy Primer Reducer	1 QT & 1 Gal