

CRLPR10 – Industrial Waterborne Paint

CRLPR10 Industrial Waterborne Paint is a water-based one component acrylic coating that provides good corrosion protection and rapid dry. This coating is well suited for primer applications on metal surfaces and plastic substrates.

TYPICAL USES:

- Primer for Metal & Plastic substrates

BENEFITS:

- Low VOC – 0.79 lbs/gal
- RoHS / WEEE Compliant
- Rapid Dry (~20 minutes)

Cured Film Properties:

Testing conducted on CRLPR10 at 1.5 mils DFT (Dry Film Thickness) over 20 gauge Bonderite 1000® test panels, cured 30 minutes at 180°F and air dried 14 days.

TEST	METHOD	PARAMETERS	RESULT
Impact:	ASTM D2794	Direct	30 in. lbs.
Flexibility:	ASTM D1737	¼" mandrel	No cracking
Hardness	ASTM 3363	Pencil	HB - F

SURFACE PREPARATION AND PRIMING: The most important steps in a successful coating process are cleaning, pretreatment and priming. The following is a brief outline of some basics for unpainted substrates. It is not intended to be all-inclusive. For more information on your particular application contact our Technical Management Team.

Cleaning the substrate: All surfaces to be coated, must be free of dirt, grease, oil, oxidation, mill scale, and all other contaminants. The surface must be thoroughly dry before painting. Air quality regulations have limited the allowable emissions from cleaning operations.

FOR INDUSTRIAL USE ONLY
NOT FOR RESIDENTIAL USE

TYPE: Acrylic Emulsion.

COMPONENTS: One.

COLOR: White

GLOSS: FLAT (0 – 4 GU @ 60°)

COVERAGE: At 1.0 mil DFT, 65% transfer efficiency (TE)

Paint, 0.79 lbs/gal: 332 ft²/gal.

Calculation: 1604 ft²/gal x % volume solids x TE ÷ DFT

VOC:

95 grams/liter = ~0.79 lbs/gal excluding exempt

34 grams/liter = ~0.28 lbs/gal including exempt

VOLUME SOLIDS:

3H60-1..... 32%

FLASH POINT: > 212 °F TCC

SHELF LIFE: 6 months from date of manufacture in factory sealed container.

APPLICATION: See surface preparation and priming section. This material is designed to be applied at high viscosity. Brushing or rolling are not recommended.

VISCOSITY: 20 – 50 seconds BYK Zahn Cup #3 @ 78°F

RECOMMENDED DFT: 1.0 – 2.0 mils

CURE:	Air Dry	Force Dry *
Tack Free	15 mins.	Flash off 10-20 mins.
Dry to handle	1 hr.	
Dry to sand	2 hrs.	Bake cycle:
Recoat	2 hrs.	20 min. @ 140 F
(At 1.5 mils dry film thickness, 78° F, 50% RH)		

* Some Air quality regulations require a maximum temp. of

TROUBLE SHOOTING:

PROBLEM	CAUSE	REMEDY
Blisters, pin holes or solvent pop	In air line: Water contamination. Entrapped air. Entrapped solvent	Eliminate water – Check air lines. Use fresh catalyst. Use urethane grade thinners. Increase atomization, decrease film build.
Craters	Contaminated ambient air, e.g., silicone mist, dust.	Locate and eliminate source of contamination.
Fish-eyes	Substrate contamination.	Clean and prepare substrate.
Not drying	Alcohol in reducer. Wrong catalyst ratio.	Double check mix ratio.
Poor adhesion	Improper surface preparation.	See surface preparation section.
Gloss variation	Variation in application, cure schedule, catalyst ratio, humidity.	Consistent gloss depends upon consistent process.

APPLICATION EQUIPMENT: Most air quality regulations require the paint application transfer efficiency to be 65% or better. This generally means using electrostatic or high volume low pressure (HVLP) spray guns. Otherwise, conventional pressure feed, airless or air assisted airless spray equipment can be used. Air supply lines need water and oil traps.

EQUIPMENT CLEAN-UP: Water clean up should be done as soon as possible keeping in mind the pot life of the mixed paint. Avoid leaving catalyzed paint in the lines. Air quality regulations have limited the allowable emissions from cleaning operations.

PRODUCT LIMITATIONS:

- Catalyst reacts with water. Air supply should be dry. Containers should be kept tightly closed. Use urethane grade thinners only.
- Alcohols and glycols interfere with curing chemistry and should be avoided. They can be found in some lacquer thinners and certain synthetic reducers.
- Optimum film properties are dependent upon proper mixing of paint and catalyst.

SAFETY: Refer to the product's Safety Data Sheet (SDS) for complete safety information. Contains organic solvents. Use with adequate ventilation. Do not breathe vapors or spray mists. If component TLVs are exceeded, a NIOSH approved air supplied respirator is advised. See SDS for TLV information. Contents are FLAMMABLE. Keep from heat, sparks or open flame. Allergic reactions are possible. Avoid use by persons with respiratory problems. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

FIRST AID:

Eye contact: flush immediately with plenty of water for at least 15 min. and get medical attention. Skin contact: wash thoroughly with soap and water for 5 minutes. If swallowed: do not induce vomiting and get medical attention immediately.

IMPORTANT: Warranty and Disclaimer — The performance characteristics of these products vary according to product application, operating conditions, materials applied to or with and use. Since these factors can affect results, we strongly recommend that you make your own test to determine to your satisfaction whether the product is of acceptable quality, has not been affected by storage or transport and is suitable for your particular purpose under your own operation conditions prior to using any product in full scale production. Seller warrants the products to be free from defects in materials and workmanship. SUCH WARRANTY IS EXCLUSIVE AND IS IN LIEU OF ANY OTHER WARRANTY, EXPRESSED OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OF FITNESS FOR A PARTICULAR PURPOSE. No representative of ours has authority to waive or change this provision, which applies to all sales of these products.