

# Interior Primer 330 WB

## Primers

High performance Epoxy Primer for Steel and Aluminium Interiors



### PRODUCT DESCRIPTION

Interior Primer 330 WB is a two component, high performance waterborne epoxy for dry areas. An extremely low solvent content helps yards meet all current and proposed VOC legislation. Low odour and fast drying, Interior Primer 330 WB reduces the impact on other trades helping to reduce project duration.

### PRODUCT INFORMATION

Colour	YIC330-Buff, YIC334-White
Finish	Matt
Specific Gravity	1.4
Volume Solids	47%
Mix Ratio	9:1 by volume (as supplied).
Converter/Curing Agent	YIC331
Typical Shelf Life	6 mths
VOC (As Supplied)	90 g/lit
VOC (EU Solvent)	65 g/kg EU Solvent Emissions Directive (Council Directive 1999/13/EC)
Unit Size	Part A: 5lt, 20lt. Part B: 1lt, 3.7lt

### DRYING/OVERCOATING INFORMATION

	Drying			
	10°C (50°F)	15°C (59°F)	23°C (73°F)	35°C (95°F)
Touch Dry	45 mins	40 mins	30 mins	25 mins
Hard Dry	16 hrs	12 hrs	7 hrs	2.5 hrs
Pot Life	1 hrs	2 hrs	2 hrs	2 hrs

**Note:** Relative humidity should be below 80% otherwise drying times will be severely extended. Relative humidity should be over 20% otherwise films may not coalesce satisfactorily. The air temperature must be kept between 10°C/50°F and 35°C/95°F during application to achieve films suitable for purpose. Pot life is shorter at lower temperatures.

Overcoated By	Overcoating							
	Substrate Temperature							
	10°C (50°F)		15°C (59°F)		23°C (73°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max	Min	Max
Interior Finish 600 WB	8 hrs	6 mths	5 hrs	6 mths	4.5 hrs	6 mths	4 hrs	6 mths
Interior Floor 340	2 wks	6 mths	2 wks	6 mths	2 wks	6 mths	2 wks	6 mths
Interior Floor 350	2 wks	6 mths	2 wks	6 mths	2 wks	6 mths	2 wks	6 mths
Interior Floor 360	2 wks	6 mths	2 wks	6 mths	2 wks	6 mths	*	*
Interior Floor 370	2 wks	6 mths	2 wks	6 mths	2 wks	6 mths	*	*
Interior Primer 330 WB	8 hrs	6 mths	5 hrs	6 mths	4.5 hrs	6 mths	4 hrs	6 mths

**Note:** \* Interior Floor 360/370 must not be applied at ambient or substrate temperature above 30°C (86°F). Overcoating times at 30°C are 2 weeks (min) and 6 months (max).

### APPLICATION AND USE

<b>Preparation</b>	<p><b>STEEL</b> Degrease the surface with 600 Wipedown Solvent or Thinner 910. Gritblast to Sa 2½ - near white metal surface. If gritblasting is not possible, grind the metal surface with 24-36 grit abrasive discs to a uniform, clean, bright metal surface with a 50-75 microns anchor pattern. Use angle grinder on small areas.</p> <p><b>STEEL with a Shop Primer</b> Degrease the surface with 600 Wipedown Solvent or Thinner 910. Ensure that the surface is clean from contaminants e.g. rust, dust, oil, grease and dirt. Note: shop primer should have been applied on to a substrate where standard profile requirements have been achieved.</p> <p><b>ALUMINIUM</b> For dry areas: degrease the surface with 600 Wipedown Solvent or Thinner 910.</p> <p><b>STAINLESS STEEL</b> Degrease the surface with 600 Wipedown Solvent or Thinner 910. Light gritblast to produce a profile of 50 microns.</p>
<b>Method</b>	<p>Remove blast/grinding/sanding residues with a clean air line &amp; sweep with a clean brush, or vacuum clean for best results. A power agitator should be used to mix both the individual components and the mixed paint thoroughly prior to use. Add curing agent to the base and mix well. Airflow between 0.1m/sec and 1m/sec should be maintained during curing.</p>
<b>Hints</b>	<p><b>Thinner</b> Clean potable water.</p> <p><b>Thinning</b> Thin 0-10% depending on application method.</p>

Please refer to your local representative or visit [www.yachtpaint.com](http://www.yachtpaint.com) for further information.

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**Cleaner** Clean potable water then a suitable solvent as required.

**Airless Spray** Thin 0-5%. Tip size: 1540-1750 (1540 recommended) Pressure: >300 bar/ >4351psi

**Brush** Thinning is not usually required.

**Roller** Thinning is not usually required.

**Other** For air-assisted airless spray application: Thin 5-10%. Tip size: 1540-1950 (1740 recommended). Fluid pressure: 240 bar/3480 psi. Atomising pressure: 2 bar/29 psi

#### Some Important Points

With Interior Primer 330 WB, no increase in viscosity is observed after mixing, even after long periods. If the pot life is exceeded the film formed on curing will not give the specified level of performance. Substrate temperature should be minimum 10°C/50°F. Substrate temperature should be 3°C/5°F above dew point to prevent condensation. Good airflow is essential around the areas being painted. (Minimum air speed 0.1m/s, maximum airspeed 1m/s). Optimal air speed 0.3-0.5m/s. Although Interior Primer 330 WB is a waterborne product, it still contains epoxy and amine components therefore appropriate P.P.E must be worn during application. The product is suitable for areas that will remain completely dry and areas that will experience intermittent wet/high humidity conditions (maximum 24 hours). Repeated exposure to these conditions is allowable if the area has been allowed to completely dry for a minimum of 24 hours. Waterborne products should not be applied when the relative humidity is greater than 80% and/or the ambient temperature is below 10°C/50°F. Application under these conditions will compromise coating performance. Ambient temperature should be minimum 10°C/50°F and maximum 35°C/95°F. Product temperature should be minimum 10°C/50°F and maximum 35°C/95°F. Substrate temperature should be minimum 10°C/50°F and maximum 35°C/95°F.

#### Compatibility/Substrates

Suitably prepared steel, aluminium and Interior Primer 330 WB.

#### Number of Coats

1 (dry areas), 2 (wet areas)

#### Coverage

(Theoretical) - 4.2 m<sup>2</sup>/lt

#### Recommended DFT per coat

125 microns dry

#### Recommended WFT per coat

266 microns wet

#### Application Methods

Airless Spray, Brush, Roller, Air Assisted Airless

### TRANSPORTATION, STORAGE AND SAFETY INFORMATION

#### Storage

##### STORAGE:

Exposure to air and extremes of temperature should be avoided. For the full shelf life of this product to be realized ensure that between use the container is firmly closed and the temperature is between 10°C/50°F and 25°C/77°F. Keep out of direct sunlight.

Protect from freezing at all times during storage. Mixed paint should not be stored under any circumstances.

##### TRANSPORTATION:

Interior Primer 330 WB should be kept in securely closed containers during transport and storage.

#### Safety

##### GENERAL:

Read the label safety section for Health and Safety Information, also available from our Technical Help Line.

##### DISPOSAL:

Do not discard tins or pour paint into water courses, use the facilities provided. It is best to allow paints to harden before disposal.

Remainders of Interior Primer 330 WB cannot be disposed of through the municipal waste route or dumped without permit. Disposal of remainders must be arranged for in consultation with the authorities.

#### IMPORTANT NOTES

*The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further written enquiries as to the suitability of the product for the intended purpose does so at their own risk and we can accept no responsibility for the performance of the product or for any loss or damage (other than death or personal injury resulting from negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.*