

Suede Primer 701

Technical Data Sheet: 450-20
P7492 / P7473 / P7478

- 1. Introduction** ALEXSEAL® Suede Primer 701 is a two component epoxy primer. Together with ALEXSEAL® Suede Coating 702 it provides excellent adhesion properties over many substrates including polyamide and thermosetting plastics as well as a variety of metals.
- 2. Range of application** Due to the fast drying characteristics of ALEXSEAL® Suede Primer 701 it is ideal for over coating with ALEXSEAL® Suede Coating 702 without sanding. This quick drying application process reduces the time needed to prime and paint parts for a variety of applications on yachts.

- 3. Color**
- Colors of mixture: White / Light Gray / Anthracite
 Base material: White / Light Gray / Anthracite
 Converter: Clear

Due to the character of ALEXSEAL® Suede Coating 702 the color of the primer should be similar to the color of the topcoat (use light primer under light topcoat). See the ALEXSEAL® Suede Coating 702 color card or price list for the recommended color of ALEXSEAL® Suede Primer 701.

- 4. Coverage**
- Volume Solids catalyzed without reduction: whites 42 %, colors 38 %.
 Coverage for ALEXSEAL® Suede Primer 701 in one application period.
Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	Rec. DFT in µm (mils)
Theoretical	8	30.3	86	20-30 (1)
Practical				
Conventional Air Spray Equipment	4.8	18.2	52	20-30 (1)
HVLP Air Spray Equipment	6	22.7	65	20-30 (1)

- 5. Substrate pre-treatment** The substrate must be clean, dry and free from dust and grease.
- To achieve optimum performance and adhesion ALEXSEAL® Suede Coating 702 should always be applied over the suitably colored ALEXSEAL® Suede Primer 701 (see color card or price list for appropriate primer color selection).

Due to the variety of plastics combined with numerous application methods, tests must be carried out regarding the reducer to be used before application and production in order to check the substrate's surface and adhesion properties.

- 6. Trade names**
- | | | |
|---------------|-------|--|
| Base Material | P7492 | ALEXSEAL® Suede Primer 701, White |
| | P7473 | ALEXSEAL® Suede Primer 701, Light Gray |
| | P7478 | ALEXSEAL® Suede Primer 701, Anthracite |
| Converter | C7451 | ALEXSEAL® Suede Primer 701 Converter |
| Reducer | R7097 | ALEXSEAL® Suede Reducer 702 / 701 Standard |
| | R7093 | ALEXSEAL® Suede Reducer Slow |

- 7. Mixing ratio**
- | | | |
|----------------------|-------|--|
| 7 parts by volume | P... | ALEXSEAL® Suede Primer 701 |
| 1 part by volume | C7451 | ALEXSEAL® Suede Primer 701 Converter |
| 25 to 35 % by volume | R7097 | ALEXSEAL® Suede Reducer 702 / 701 Standard |
| or | R7093 | ALEXSEAL® Suede Reducer Slow |

Example: 7 : 1 : 1³/₄ up to 2¹/₂ = 25 to 35 % reduction

The amount of reducer required may vary depending on the application conditions.

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8. Application

Viscosity	Zahn #2: ≈ 28 - 32 sec, DIN 4 cup 4mm: ≈ 18 - 22 sec
Nozzle Size Gravity Gun	1.0 to 1.4 mm (0.04 to 0.055) – Conventional & HVLP
Nozzle Size Siphon Cup	1.4 to 1.6mm (0.061 to 0.070) – Conventional & HVLP
Fluid Nozzle Size Pressure Pot	1.0 to 1.2 mm (0.04 to 0.046) – Conventional & HVLP
Atomizing Pressure	3.0 to 4.0 bar (42 to 56 PSI) – Conventional & HVLP
Pot Pressure	0.7 to 1.5 bar (10 to 20 PSI) – Conventional & HVLP

Application by Spraying: Apply 1 cross coat to a wet film thickness (WFT) of 50-80 microns (2 mils) total thickness. This will achieve a dry film thickness (DFT) of 15-25 microns (1 mil). Maximum recommended film thickness during a spray application is 1 coat totaling 80 microns (2 mils) WFT, or 25 microns (1 mil) DFT. A cross coat application will insure a more uniform finish.

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Time
Pot Life - approx.	3 hrs max	3 hrs max	3 hrs max	2 hrs max	N/A
Dust Free	1 hr	45 min	30 min	30 min	N/A
Tape Dry	4 - 5 hrs	3 - 4 hrs	2 - 3 hrs	2 hrs	N/A
Fully Cured	36 hrs	30 hrs	24 hrs	18 hrs	N/A
Over-coat with ALEXSEAL® Suede Coating 702	60 min	30 min	15 min	15 min	24 hrs

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will effect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point. To achieve optimal adhesion between ALEXSEAL® Suede Coating 702 and ALEXSEAL® Suede Primer 701 this primer must be over-coated within 24 hours.

10. Packaging

P7492	ALEXSEAL® Suede Primer 701, White	0.857	Liter
P7473	ALEXSEAL® Suede Primer 701, Light Gray	0.857	Liter
P7478	ALEXSEAL® Suede Primer 701, Anthracite	0.857	Liter
C7451	ALEXSEAL® Suede Primer 701 Converter	0.123	Liter
R7097	ALEXSEAL® Suede Reducer 702 / 701 Standard	1	Liter
R7093	ALEXSEAL® Suede Reducer Slow	1	Liter

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