

# STOVING PRIMER

Product code: PS1251

## Composition and Application Field

**EVI Stoving Primer** is based on a special non-drying Alkyd composition and a curing agent, containing Titanium dioxide and other carefully chosen pigments suitable for stoving. It is a product used for Stoving applications as a custom nary primer surface. It can withstand wide range of temperatures. It has good adhesion and exhibits good anchorage on the metal and also provides the base for the top coats. It exhibits good mechanical properties.

Substrates: Steel furniture, steel frame, steel drum or other metal substrates.

Area of Use: Interiors and Exteriors.

## Specification

Finish	: Matt and Smooth.
Color	: White, Red Oxide, Grey and restricted shades.
Specific gravity	: $1.32 \pm 0.02$
Solids (% by volume)	: $52 \pm 2$
Diluent	: EVI Stoving Thinner
Flash point	: $29^{\circ}\text{C}$
Spread Rate:	

While the spread rate is directly dependant on the surface profile and also the type of undulations it has, as a thumb rule EVI Stoving Primer would cover 10 – 12 sq. meters per liter.

Stoving Schedule ( $120^{\circ}/150^{\circ}\text{C}$ ) :  $120^{\circ}\text{C}$  for 25-30 minutes/ $150^{\circ}\text{C}$  for 15 minutes (The stoving schedule of the product can be adjusted based on the production line in case of industrial production).

Recommended DFT : Apply mist coat on wet followed by full coat.  
: 1 mist coat followed by a good full coat.  
App 40 - 50 mic.

## Surface Preparation

A good surface preparation and following the method statement / recommended system procedure of EVI is an ideal recommendation for the application of EVI Stoving Primer.

Exclusions for successful application include perpetually wet surfaces and also large cavities on wood, metal or concrete surfaces.

### For Metals & Steel Surfaces

Achieve a good and clean surface by removing all contaminants by cleaning & drying. A laitance free surface should be achieved by good sweep blast or a wire brush. Apply one coat of EVI Stoving Primer and proceed for EVI Stoving Topcoat Enamel after successive stoving.

Apply one good coat or two nominal coats with a spray or a suitable roller and obtain the desired coverage.

## Application Method

Adequate ventilation is an ideal situation as it helps in drying and the good application itself. Avoid high humid conditions i.e.,  $>95\%$  when condensation is likely to interfere and also when the surface temperature is at least  $3^{\circ}\text{C}$  above dew point.

Application: To be done by conventional roller or spray at 2000 – 2500 psi for airless spray or 50 – 60 psi for conventional spray. Nozzle size: 0.017 - 0.023 inches.

One can add 5 - 10% of EVI Stoving Thinner for ease of application of brush/roller/or spray viscosity. App 25sec. Ford cup No 4 ( $30^{\circ}\text{C}$ ). Give adequate flash off say around 5 to 10 minutes and perform the stoving schedule.

Caution: Over diluting would result in sag and run downs.

## Paint System

EVI STOVING PRIMER	
- EVI Stoving Primer	<b>1 coat</b>
- EVI Stoving Topcoat	1-2 coats

\* Or as per EVI technical advice

## Storage and Shelf Life

Under dry and cool condition, storage stability can be sound up to 18 months in original sealed containers.

### Handling

Disposal: As per the guidance and legislations of the local Authority e.g., by controlled landfill. In case of doubt, consult local authority. Do not empty into drains, sewers or other water courses.

Flash Point:  $29^{\circ}\text{C}$  and contains aromatic hydrocarbons.

Caution: It is strongly advised not to keep open half used drums as it forms a skin on the top layer.

## Safety Precaution

Avoid contact with the skin and eyes. Wear suitable protective clothing such as overalls, goggles, dust mask and gloves. Use a barrier cream. Ensure that there is adequate ventilation in the area where the product is being applied. Do not breathe vapour or spray. MSDS is available on request for the safe handling of this product.

### First Aid

Eyes: In the event of accidental splashes, flush eyes with warm water immediately and obtain medical advice.

Skin: Wash skin thoroughly with soap and water or approved industrial cleaner. Do not use solvent or thinners.

Inhalation: Move to fresh air, loosen collar and keep patient rested.

Ingestion: In case of accidental ingestion DO NOT INDUCE VOMITING. Obtain immediate medical attention.

