22880S™ LOW VOC ETCH PRIMER

GENERAL
DESCRIPTION
A two-component, olive green, non-sanding etch primer that provides premium-quality results, exceptional corrosion resistance and adhesion to bare steel, galvanized and aluminum.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING
COMPONENTS
22880S™ Low VOC Etch Primer
22806S™ Etch Primer Reducer
22808S™ Etch Primer Reducer High Temperature (80˚F+)

MIX RATIO
Combine the components by volume or weight (cumulative pt.). Mix thoroughly.

<table>
<thead>
<tr>
<th>Component</th>
<th>Volume</th>
<th>Weight</th>
</tr>
</thead>
<tbody>
<tr>
<td>22880S™ Low VOC Etch Primer</td>
<td>2</td>
<td>312 grams</td>
</tr>
<tr>
<td>22806S™ / 22808S™ Reducer</td>
<td>1</td>
<td>441 grams</td>
</tr>
</tbody>
</table>

Tips for Success
- Hand stir components or agitate on a mechanical shaker prior to mixing.
- Stir thoroughly while adding activator, until uniform.
- Use 22808S™ Reducer when temperature is above 80˚F (27° C) or when priming large areas.

POT LIFE
8 hours at 70°F (21° C)

ADDITIVES
Accelerator: Not recommended
Fish Eye Eliminator: Not required
Flex Additive: Not recommended
Reducer: Not recommended
Retarder: Not recommended

APPLICATION
PRIMERS OR SEALERS
4004S™ Ultra Productive 2K Primer Filler
ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler
ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer
ChromaPremier® Pro 33430S™ Productive Primer Sealer
ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
ChromaPremier® Pro 44410S™ / 44440S™ / 44470S™ 2K Premier Sealer
Cromax® LE LE3004S™ 2K Primer Surfacer
Cromax® LE LE3010S™ / LE3040S™ / LE3070S™ 2K Premier Sealer
Cromax® Premier LE LE3401S™ / LE3404S™ / LE3407S™ Urethane Primer Filler
Cromax® Premier LE LE3410S™ / LE3440S™ / LE3470S™ Urethane Primer Sealer

ChromaPremier® 22880S™ must always be followed with a primer-surfacer or sealer.
SUBSTRATES
Properly prepared/cleaned steel, aluminum, and galvanized.

SURFACE PREPARATION
- Wipe surface with surface cleaner
- Sand and featheredge with P180 DA grit paper followed by P240 DA grit
- Remove sanding sludge with surface cleaner

GUN SETUPS*
Compliant
Siphon Feed: 1.4 mm-1.6 mm
Gravity Feed: 1.3 mm-1.6 mm

HVLP
Siphon Feed: 1.6 mm-1.8 mm
Gravity Feed: 1.3 mm-1.6 mm

AIR PRESSURE*
Compliant Panel Overall
Siphon Feed: 30-40 psi at the gun 35-45 psi at the gun
Gravity Feed: 25-35 psi at the gun 30-40 psi at the gun

HVLP 6-8 psi at the cap 6-8 psi at the cap

*The listed setups cover the usual range for standard application equipment.

APPLICATION
Apply 1 medium-wet coat to ½ mil dry film thickness.

CLEANUP
Clean spray equipment as soon as possible with equipment cleaning solvent.

DRY TIMES
Nib Sanding: 20 minutes after flash
Wet sanding not recommended
Priming: 20 minutes
Max Allowable Dry Time: 8 hours, then sanding is required
Force Dry: Not recommended

RECOATABILITY/REPAIR
If 22880S™ Low VOC Etch Primer is allowed to air dry for more than 8 hours, re-coat with itself.

SANDING
No sanding is necessary. May be nib sanded after 20 minutes. Do not wet sand.

Tips For Success
If sanding is required to remove imperfections, dry sand with P600-1000 grit paper using light hand pressure to avoid any cut-throughs.
PHYSICAL PROPERTIES
All Values Ready To Spray

Max. VOC (LE): 655 g/L (5.5 lbs./gal)
Max. VOC (AP): 312 g/L (2.6 lbs./gal)
Avg. Gal. Wt.: 931 g/L (7.77 lbs./gal)
Avg. Wt.% Volatiles: 84.8%
Avg. Wt.% Exempt Solvent: 51.9%
Avg. Wt.% Water: 1.2%
Avg. Vol.% Exempt Solvent: 53.6%
Avg. Vol.% Water: 1.1%
Theoretical Coverage: 265 sq. ft. per RTS gallon at 0.5 mil DFT
Recommended Dry Film Thickness: 0.5 mils in 1 coat
Flash Point: See MSDS/SDS

VOC REGULATED AREAS
These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING
For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS/SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: April 2015