



730 Sanding Primer

USER-FRIENDLY POLYURETHANE PRIMER

730 Sanding Primer is an easy-to-use white two-pack sanding primer with supreme features. It provides up to four hours pot life, fast sanding times, dry over-spray and excellent top coat "hold-out".

730

Key Product Features

- Fast dry-free sanding
- Is unaffected by wax extraction on MDF Boards
- Good wetting of MDF Board end grain
- Easy application ensuring quick sanding surface
- High build and cover
- Excellent working pot life
- Excellent topcoat hold out

Ideal Use

730 Polyurethane Primer is widely used by quality manufacturers and applicators throughout Australia as a sanding primer for compatible Evic polyurethane finishes, particularly 2000 Spraythane and the new 1600 Global range. Applications may include kitchens, vanities, commercial fitouts and other work that requires a solid, even finish.

Suitable for most wood substrates including MDF, melamine and wood veneers.

Available Sizes

PART A (730A) is available in 3L and 15L cans

PART B (730B) is available in 1L and 5L sizes

Kits (A+B) are also available

MIXING RATIO (A:B) IS 3:1 – product must be applied strictly as specified.

Coverage Rate

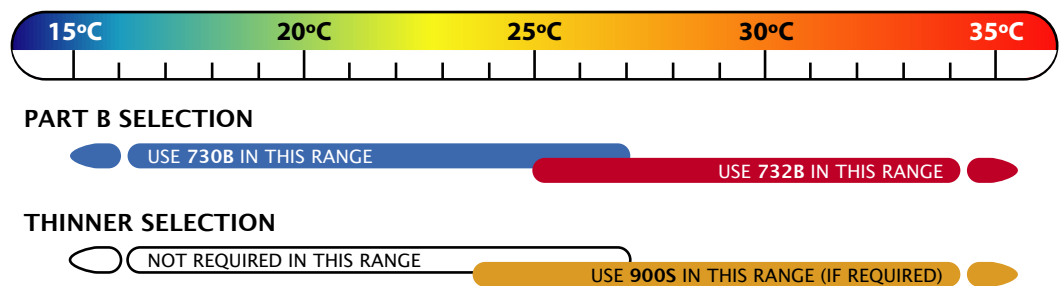
Approximately four square metres per litre in practice. Use 3–4 coats to achieve optimum coverage.

Mixing

Stir separately Part “A” and Part “B” thoroughly. Ensure only the quantity that can be applied within the normal pot life is mixed at any one time.

MIX BY VOLUME 3 part of “A” to 1 part of “B”.

Working Temperature



Thin Quantity

In cool conditions, 730 can be applied as mixed using 730 Part B.

In Hot or Humid Conditions or on porous substrates, 732B may be used as a substitute for 730B and/or 730 can be thinned up to 15% with 900S solvent to stop surface pin holing.

Recommended Film Build

It is recommended that dry film build not exceed 100 µm (250 µm wet film build); inadvertent excessive build in, for example routed corners, may reduce the coating’s flexibility and can create cracking. This should be remedied by sanding back to a maximum thickness of 100 µm.

Suggested Equipment

Conventional Spray Guns: Anest Iwata W200 at 275 kpa (40 psi) or Star Pro-Series SP770 at 310 kpa (45 psi).

Gravity Spray Gun: Star Pro-Series SP106 gravity gun.

Pressure Pot: 55 kpa (8 psi) pot pressure using a Star S770 pressure gun at 240–275 kpa (35–40 psi).

Pot Life Estimates The Estimated pot life at 25°C is 2–3 hours. Pot life can be extended if thinned 10% with 900S Solvent. Higher temperatures shorten pot life.

Dry Times* **Touch Dry:** 8–15 minutes
Time to Sand: 6–8+ hours

*Stated times apply only for the standard film thickness. Overnight drying gives better gloss top coat hold out.

Important Application Information Mix or handle product in a spray booth or equivalent ventilated space. Spray application in a spray booth is required using a positive pressure air-fed face mask.

Preparation **ALUMINIUM, ZINCALUME, GALVANISED & MILD STEEL (for interior use ONLY):** Use Evic 145E Etch and Protect Primer in either light grey.

MDF BOARD: Sand edges and routes with 180 grit free-cut sandpaper or 3M Medium Sanding Sponge to remove excess raised fibre. Apply primer in 2 to 3 double wet coats allowing solvent flash off between coats.

Alternatively seal routes and edges with thinned 860 polyurethane sealer and allow to dry. Sand sealed edges and routes with 150 to 180 free-cut sandpaper or 3M Medium Sanding Sponge. Sealer will prevent fibres from resurfacing during the priming coat. Apply 2 to 3 double header wet coats, allow solvent flash off between coats. Allow 4 hours to overnight dry.

MELAMINE: Correctly sand with 240 to 320 grit free-cut paper and apply “top coat” directly. Alternatively, sand with 150 to 180 free-cut paper, remove all surface gloss, dust off, then apply 2 to 3 double header wet coats of primer allowing flash off between coats.

Warning: 730 does not stick to unsanded melamine. This surface must be prepared correctly especially in corners or hard to get at areas. Melamine can easily wear out paper which then effectively polishes the surface making adhesion by further coats impossible.

MELAMINE WITH RAW EDGES & ROUTES: Thin down 860 or 866 Polyurethane Sealer 30% with 850S Solvent. Spray apply thinned sealer directly onto the raw routes and edges only, and allow to dry. Sand back sealer with 150 to 180 free-cut paper or 3M Medium Sanding Sponges. Dust off, then prime the sealed routes and edges only with 730 primer and allow to dry.

Method A: Scrape excess primer and sealer off melamine surface using razor blade scrapers. Sand routes and edges with 320 to 400 free-cut paper or 3M Fine Sanding Sponges. Machine sand the melamine face with 240 to 320 free-cut paper.

Method B: Sand edges and routes with 320 to 400 free-cut paper or 3M Fine Sanding Sponge. Machine sand the primer off the melamine face with 240 to 320 free-cut paper making sure that all primer is removed and that there is no gloss areas left on the melamine. Dust off and wipe clean for top coating.

TIMBER: Apply 730 primer thinned 15% directly to all raw timber and veneer surfaces.

SANDING: 730 polyester should be sanded within 48 hours otherwise the primer further hardens and sanding time will increase.

Routes and Edges: (by hand) 3M Fine Sanding Sponges or 320 free-cut paper; (by machine) Festool ES125 Lightweight sander with 400 free-cut paper

Face or Broad Areas: (by machine) Festool RS1C orbital sander, Festool ET2 disk orbital or Festool Rotex eccentric disk sander with 400 or 500 free-cut paper.

Application **FINISH COAT:** It is recommended that Evic’s 2000 Spraythane or 1600 Global finish coat be applied within 24 hours of sanding the 730 Polyurethane Primer to ensure good intercoat adhesion.

Baking

730 Sanding Primer responds positively to baking and dry times to sand can be reduced to as little as 1 hour. Allow 45–60 minutes flash off time then bake at up to 60°C for 45 minutes to 1 hour.

Shelf Life

Up to 12 months if stored in properly sealed containers. Part “B” is moisture sensitive and should be stored in full containers with minimal air pad.

Note to Users

This is a specialised industrial coating and should only be applied by experienced and competent tradesmen and in accordance with the manufactures specification.

Please read Material Safety Data Sheets M730.

More Information

Go to www.evic.com.au for product and material safety data on all Evic products. Information is also available in booklet and CD-ROM form, or by e-mail and fax transmission.

For further enquiries, call the Evic Group on (freecall) 1800 761 761.



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