BICHOLIN
ADHESIVE PRIMER

PRODUCT CODE: 2241

Description

BICHOLIN Adhesive Primer is a universal fast-drying Adhesive Primer based on a unique combination of binders. Specially developed for application on a variety of substrates such as metal, non-ferrous metal, plastic, etc. (see 'substrates').

Features

- excellent adhesion to various substrates
- fast-drying
- resilient and weather resistant
- excellent water resistance
- good filling power
- cures to a hard finish
- suitable for brush and spray application

Uses

As Adhesive Primer, both indoors and outdoors, on various (difficult) substrates. As substrate for Bicholin Enamel and on heavy equipment, such as agricultural machinery, earthmoving machines, forklift trucks, tractors and implements.

N.B.: For heavy rust we recommend using Bicholin Zinc Phosphate Primer, which contains active anticorrosive pigments.

Specifications
(at 20°C)

Finish	: matt
Gloss level (60°)	: n.a.
Colour	: white
Theoretical coverage	: approx. 10m²/l. at 40 µm dry film thickness
Specific gravity	: 1.20 g/ml
Solids content	: 60% wt. / 38% vol.
Flash point	: 40°C
Application conditions	: min. 5°C / 80% R.H.
VOC content	: 487 g/l
Shelf life in can	: min. 1 year in original unopened packaging (5 – 25°C)

APPLICATION INSTRUCTIONS

Surface preparation
The surface must be completely clean, dry, and grease-free. Remove rust and mill scale.
Remove loose material, then sand previously painted surfaces.
See also page 2: additional information.

Viscosity and thinning
BICCS Thinner 101
Max. 5% for brush application
Max. 10% for spray application

Air spray
Nozzle 1.5, 3 to 4 bar
30 – 35 sec. DIN cup 4

Airless
Nozzle 0,33 ->120 bar
70 – 120 sec. DIN cup 4

Tool cleaning
Wash Thinner or BICCS Thinner 0101

Spraying instructions
Within 1 – 2 cross-coats.

Recommended film thickness:
Min. 150 µm wet
Min. 70 µm dry.

Drying times

Touch-dry	**approx. 1 hour**
Tack free	**approx. 2 hours**
For overcoating	**approx. 4 hours with regular enamels and approx.. 24 hours with nitro lacquers**
For sanding	**approx. 4 hours or after curing**

* Data at 20°C and 65% RH

BICCS® INDUSTRIAL COATINGS BV

Substrates

old, intact paint layers, iron, steel and zinc-plated steel
zinc and aluminium, wood, plastic, masonry and plaster
also slightly moist substrates

Additional Information

General preparation
Pre-sand hard plastic that has a smooth surface. Thin the first layer applied to wood, to ensure better penetration into the grain. The moisture content of wood and other surfaces must not exceed 15%. Remove any wax layer that may be present on MDF and hardboard using nitro thinner. Smooth off any sharp edges. First fill any open joints or cracks. If in doubt, always paint a test area first.

Preparation of steel and iron
Remove rust and mill scale using hand tools or grit blasting, to surface quality SA ½. Apply a layer of Bicholin Adhesive Primer immediately after grit blasting.

Preparation of zinc and zinc-plated steel
First clean thoroughly using Zinc Cleaner, followed by a clean water rinse.
After drying, apply a layer of Bicholin Adhesive Primer.

Hard plastic
First clean thoroughly, followed by a clean water rinse. Once dry, sand off to be sure of good adhesion. Then apply a layer of Bicholin Adhesive Primer.

Warning/restricted applicability
Considering the great diversity of purpose-specific aluminium alloys available in the market, it is impossible for us to recommend a single coating system that will apply to all kinds of aluminium. Our product data is generally based on pure, unalloyed aluminium, also known as the 1000 series.

Safety
See the appropriate safety sheet

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The information provided in this product information sheet is based on accurate testing carried out in our laboratory, and is intended solely as a guideline. All recommendations and suggestions related to the use of products produced by BICCS, including but not limited to that provided in technical documentation or in response to a specific question, is based on data that we have compiled to the best of our knowledge.
The products and information are intended for users in possession of the required specific knowledge and industrial skills, and the suitability of any product for any purpose whatsoever remains at all times the responsibility of the end user. BICCS bv has no knowledge of the quality or condition of the substrate, nor of the many factors that can influence the use and application of the product. BICCS therefore accepts no liability of any kind pertaining to loss or damage as a consequence of the use of or reference to this data sheet, except where otherwise agreed in writing.

The data in this information sheet is subject to amendment, and is the result of practical experience and continuous product development. This data sheet replaces all earlier publications, and it is therefore the responsibility of the user to make certain that this sheet is the correct version, before proceeding to use the product to which it pertains.

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INDUSTRIAL COATING & COLOURANT SYSTEMS

N.B. De technische gegevens in deze publicatie steunen op onze huidige kennis. Zij gelden als aanduiding en leveren u vrijblijvend een beeld van de toepassingsmogelijkheden van onze producten. De gegevens kunnen door een recentere uitgave gewijzigd worden.

Please note: The technical data in this publication are based on our current knowledge. These should be regarded as indicative, providing an impression of possible applications of our products without obligations. The data may be updated or changed in future editions.