



Group	944 – VALDE PRIME
Curing	min: 180°C @ 15' to 20'   max: 200°C @ 8' to 10'
Surface	Smooth
Gloss	N/A
Approvals	Qualisteelcoat approval for steel: PE-0066, PE-0069. Qualisteelcoat approval for HDGS: PE-0070, PE-0071. GSB No. 903 b

**PRODUCT DESCRIPTION**

Thermosetting hybrid powder coating containing special anticorrosive pigments to maximise corrosion protection of the coated component.

Valde Prime has excellent sandability for ease of over-coating.

It forms a smooth hard film with good resistance to chemical agents, fuels, oils and mechanical damage.

The product is designed to afford corrosion protection to metal structures and is independently certified to meet the requirements detailed in the Qualisteelcoat specification.

**Storage Life:**

Store at temperatures from 5°C and lower than 30°C with max 60%RH;  
Storage life in original package: 18 months.

**CHARACTERISTICS**

**Spec. Gravity (kg/l):** 1.3 to 1.8  
**DFT (micron):** 50 - 80  
**Theoretical Coverage @60um:** 11 m<sup>2</sup>/kg

**Recommended film thickness:**

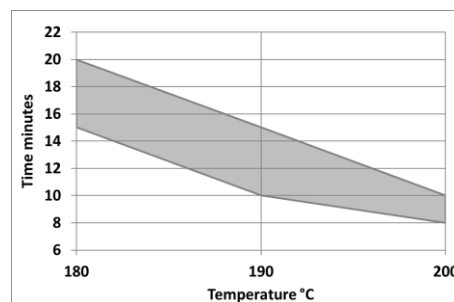
Dry: 50 -80 microns

**APPLICATION**

Suitable for automatic and manual electrostatic application  
Please contact your Sherwin-Williams representative to discuss tribo-static application

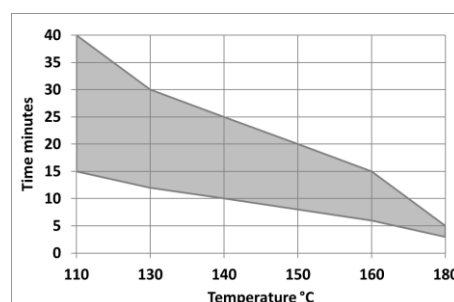
**Cure Cycles**

Time	Substrate temperature
8 - 10 min	200°C
10 - 15 min	190°C
15 - 20 min	180°C



After a preliminary plant test, the VALDE PRIME can be applied and **green-cured** (only partial curing /gelling) prior the application of the top-coat:

Time	Substrate temperature
15 - 40 min	110°C
12 - 30 min	130°C
10 - 25 min	140°C
8 - 20 min	150°C
6 - 15 min	160°C
3 - 5 min	180°C



Green curing is not recommended for fine texture, texture and liquid top-coats where the VALDE PRIME needs to be fully cured before the top-coating.

For all of the top-coat smooth low bake products, it is possible to partial cure the VALDE PRIME, but for the final curing cycle must achieve full cure of both the primer and topcoat system.

**SUBSTRATE PREPARATION**

The surface to be coated must be cleaned from oils, grease or flash rust. If particular resistance to corrosion or humidity is required, it is suggested the following pretreatment of the surface: Apply on sand blasted steel Sa 2" grade or chemically treated steel or HDGS, for Qualisteelcoat applications. It can be top-coated with Inver Architectural Class 1 Qualicoat approved products.

It gives also a good intercoat adhesion if it is top-coated with Inverpul Polyester, Epoxypolyester or Polyurethanic powder and 2K liquid enamel like Inverplast and Inverpur.

### **PERFORMANCE DATA**

Sand blasted steel Sa 2" grade  
 Thickness 50 - 80 microns 15 minutes at 180°C  
 The hardness test was carried out on sand blasted steel Sa 2" after overpainting with 50-80 Micron of Inverpul Polyester Extra.  
 The test panel satisfied the following requirements:

#### **Erichsen cupping test (mm):**

more than 5  
 UNI EN ISO 1520

#### **Direct impact test (cm.Kg):**

more than 25  
 ASTM D 2794; ISO 6272-2:2002

#### **Reverse impact test (cm.kg):**

more than 25  
 ASTM D 2794; ISO 6272-2:2002

#### **Conical mandrel size: Bend test**

maximum 20 mm  
 UNI EN ISO 6860

#### **Crosscut adhesion (2mm) (GT):**

Class 0  
 UNI EN ISO 2409

#### **Salt fog test :**

1000 hours  
 Scribe creep 2-3 mm  
 UNI ISO 9227

#### **Resistance to humidity : (Humidity test)**

500 hours later – no change

### **CAUTION**

#### **FOR INDUSTRIAL SHOP APPLICATION**

Thoroughly review product label and Safety Data Sheet (SDS) prior to using this product.

A Safety Data Sheet is available from your local Sherwin-Williams facility or distributor

**Note:** Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the user obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in user handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.