



TECHNICAL DATA SHEET No 823

# SPRAY P311 ZINC WELDING PRIMER

## GENERAL TECHNICAL DESCRIPTION

Fast drying anticorrosive, conductive primer.  
To be applied prior to welding works.  
Suitable for MIG / SPOT welding.  
Provides excellent physical properties and protection to metals.

## SURFACE

Sanded metallic surfaces

## PRETREATMENT/CLEANING OF SUBSTRATE



Clean substrate using a soft cloth and 770 ANTISIL NORMAL / 771 ANTISIL FAST DEGREASER

Make sure the surface is first wiped dry and then air dried

## PRODUCT APPLICATION



Shake well before using:  
2 - 3 min



Spray at a distance of  
20 - 30 cm, thinly applied  
coats



5 min / 23°C (73°F)



2 - 3 coats approximately  
20 - 30 microns  
(0.8 - 1.2 mil)



10 min / 23°C (73°F)



Overcoat with any HB  
BODY 2K Primers



After use turn bottle  
upside down and spray  
out a small quantity,  
for the cleaning of the  
nozzle

## SPECIFIC GRAVITY

1.35 ± 0.02 g/cm<sup>3</sup>

## SOLID CONTENT

10 ± 0.02% Weight

## VOC (2004/42/EC)

This is an aerosol product based on its ingredients and its properties. The maximum VOC content in this category is 840 g/L. The VOC content in the ready for use form of this product is 840g/L.  
2004/42/IIIB(e)(840)840

## THEORETICAL COVERAGE

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## CLEANING OF EQUIPMENT

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## REMARKS

- Always try to use the product in accordance with the specifications provided
- Shake for 2 - 3 min after agitator ball has started to rattle
- After preparing the area to be painted ensure it to be free from dirt, wax, oil etc
- Optimum operating temperature range 10°C - 25°C (50°F - 77°F)

## STORAGE SHELF LIFE

Guaranteed shelf-life 36 months in unused original containers stored in a cool place (+5°C - +25°C) (41°F - 77°F).



Always wear protective equipment



Follow the application instructions mentioned in this TDS

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