

## DESCRIPTION AND USES

MetalForce 3406-134X is a fast dry alkyd primer specifically formulated to comply with VOC Regulations\*. This product is ideal for metal application where very fast recoating is required. Depending on use, 3406-134X can be used as temporary protection or be topcoated with Metal Force 45X-8XX coatings.

Intended uses:

- Surfacing primer for manufacture, maintenance, repair or restoration of mobile equipment: truck dump bodies, agricultural machinery, mobile industrial machinery;
- Metal structures and equipment: containers, fixed machinery, conveyors, steel beams, architectural metal structures.

\* In accordance with existing Canadian Regulations on Volatile Organic Compounds (SOR/2009-264 and SORS2009-197).

## ADVANTAGES

- Fast dry / recoat time
- Excellent intercoat and metal adhesion;
- Low V.O.C.
- Offer a soft finish without sanding.

## TECHNICAL DATA

Available colors	Grey : 3406-1342 White : 3406-1343 Black : 3406-1348 Oxide Red: 3406-1345	Packaging	946 ml 3.78 l 18.9 l
Gloss	Matte	Density	1.40 +/- 0.2 kg/l (may vary according to color)
Solids by volume	45 % ± 2 (may vary according to color)	Shelf life	12 months @ 25 °C (77 °F)
Solids by weight	65 % ± 2 (may vary according to color)	Viscosity	70 ± 5 KU (25 °C)
Theoretical coverage	95 ft <sup>2</sup> /litre US @ 2 D.F.T. 9 m <sup>2</sup> /litre	VOC	130 g/l (< 1.1 lb/gal. US) < 200 g/l diluted at 15%

## PRODUCT DATA

Recommended dry film thickness	2.0 – 4.0 mils D.F.T.
Induction time	Not required
Thinner	ST661 or ST653 (maximum 15%)**

\*\* For more recommendations in accordance with VOC Regulations, contact your representative.

## DRYING TIME

Drying schedule @ 25 °C (77 °F) @ 40 % R.H. @ 3 mils wet (75 microns wet)	
Dry to touch	15 to 30 minutes
To recoat	15 to 30 minutes
To handle	1 hour
Hard	12 hours
Full cure	7 days

Drying and recoating time may vary according to thickness and temperature.

## SURFACE PREPARATION

Remove all traces of oil, grease, salt or dirt according to SSPC-SP-1 procedure (solvent cleaning). Remove all peeling paint, paying particular attention to areas where rust has infiltrated. Remove rust with the help of a steel brush or sandpaper. Sand glossy areas. For new or existing structures: "direct to metal" coatings achieve maximum performance over "near white blasted" surfaces in accordance with SSPC-SP-10. If situations of cost limitations dictate, then lesser degrees of surface preparation are acceptable (see SSPC-SP-6, SSPS-SP-3, SSPC-SP-2).

## APPLICATION

**MIX WELL BEFORE USING.** Apply using spray gun at a dry film thickness of 1 to 2 mils. Dilute 10 to 15 % with Pepin ST661 or ST653 thinner. All applications must be done at air, surface and product temperature between 10°C and 32°C. Apply generously and evenly. One coat is sufficient.

## IMPORTANT

Product must be used in accordance with the information in this technical data sheet, label and Safety Data Sheet.

See label and Safety Data Sheet for more information on safety and precautions requirements.

Keep away from open flame or sparks. Flammable

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