

STOVING PRIMERS

Product Scope

Buxly Stoving Primer is specially designed for two wheeler industry to meet the harsh test requirements including salt spray test, gasoline resistance, hardness and flexibility.

Product Application

Buxly Stoving Primer is an excellent blend of anticorrosive pigments and inert extenders dispersed in epoxy ester medium to provide exceptional corrosion, gasoline and chipping resistance.

Technical Information

Type of Product	Single Pack Stoving
Specific Gravity	1.30–1.34
Grind	6.5
Pack Viscosity	60–70 Seconds @ F-4 Cup @ 30°C
Color	Grey
Stoving Schedule	160 ± 5°C @ 29–31 Minutes (PMT)
Volume Solids	42 ± 3 %
Flash Point	23°C
Finish	Full Gloss
Cross Hatch	97/100–100/100
Gasoline Resistance (After 3 Hours of Baking)	7 Hours (Full System)
Pencil Hardness	Passes H Grade (Full System)
Salt Spray Test	96 Hours (Full System)
Flexibility	Passes Conical Mandrel (Full System)
MEK Test	Passes 10 Rubs (Full System)

Application Information

Application Method	Conventional, pressure feed, electrostatic spray
Spray Viscosity @ F-4 @ 25°C	20–22 Sec
Solvent/Cleaner	Buxly's Stoving Thinner
Number of Coats	2 Coats
Dry Film Thickness	35–40 μm
Inter-Coat Time	05–10 Minutes (depending on booth temperature)
Flash-Off Time	10–15 Minutes (depending on booth temperature)
Recommended Booth Conditions	Temperature: 25–30°C Relative Humidity: 55–70 %