

This data sheet represents the actual status of the development and substitutes all previous.

TECHNICAL INFORMATION		
Name	TX-F #23 PRIMER BLACK	SENOSOFT SF-10 WK(BD)
Type	BTX-Free Solvent-borne <input checked="" type="checkbox"/>	BTX-Free Solvent-borne <input checked="" type="checkbox"/>
Color	Black	Black
Gloss	4.4 ± 0.3 (60° Geometry)	3 ± 0.2 (60° Geometry)
Supply viscosity	61 ± 3 KU (stomer , 25°C)	59.5 ± 3 KU (stomer , 25°C)
SG wet	0.99 ± 0.03 kg/ℓ	1.02 ± 0.03 kg/ℓ
Weight solids	34.4 ± 2 %	52.1 ± 3 %
Film thickness dry	15 ± 2 μm DFT	35 ± 5 μm DFT
Rec. coating system	Base Coat	Top Coat
Shelf life	9 months	9 months

The above data does not represent a specification

APPLICATION TIPS		
Before using	stir well	
Substrate	ABS, PC+ABS	TX-F #23 PRIMER BLACK
Pre treatment	Cleaning with IPA	Air Blowing
Application method	Air assisted spraying	
Thinner	A/T#570(TX-F) THINNER	SF#300 THINNER
Hardener	POLY HARD TX-F	POLY HARD NC-37
Mixing ratio	100 / 16 / 60-80 w/w (Paint/Hardner/Thinner)	100 / 25 / 20~30 w/w
Application viscosity	14 ~ 15 sec (F/Cup#4, 20°C)	15 ~ 18 sec (F/cup#4, 20°C)
Pot life	4 hrs	1 hrs
Flash off	5~10 mins × RT	5~10 mins × RT
Curing schedule	Wet On Wet or 10 mins × 80°C	Over 30 mins × 85 ± 5°C (Obj. Temp.)
Disposal	Do not allow into drains or watercourse	

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