

# DOLWAPRIM

High-filling 1-component adhesion primer (reaction primer), solvent-based, for indoors and outdoors

Technical information Version  
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Quick-drying rust and adhesion primer based on polyvinyl butyral with active corrosion protection for interior and exterior use with excellent adhesion to a wide variety of substrates.

## Beschreibung

**Areas of application** 1K adhesion primer with active corrosion protection and excellent adhesion to iron, steel, galvanized substrates, aluminium and other substrates. Can be coated over with 1K and 2K paints. Can be used as a primer and primer filler. Chromate and lead-free.

## Core data

<b>Properties</b>	<b>Delivery viscosity</b>	Pasty (stir well before use)
	<b>Binder</b>	Polyvinylbutyral
	<b>Density</b>	Approx. 1.2 kg/l
	<b>Solid state</b>	Approx. 40 % (white)
	<b>Gloss level</b>	Matt
	<b>Flash point</b>	23 °C
	<b>Tintable</b>	With Spaceline system, manual tinting up to max. 3% possible with suitable universal pastes.
	<b>Storage life</b>	Store in tightly closed original container for 1 year at 5 - 25°C.
	<b>Processing temperature</b>	Do not process below + 5°C (object temperature), ideal temperature range 15 - 22°C.
	<b>Adhesive strength</b>	Protect from direct sunlight. Gt 0-1 (DIN EN ISO 2409)
	<b>Environmental label</b>	G
	<b>Highlight</b>	Quick-drying rust and adhesion primer

## Substrate / Processing

<b>Substrates</b>	<b>Iron, steel</b>
	Clean, sand if necessary (remove rust, scale, mill scale) and degrease with silicone remover
	<b>Aluminium</b>
	Clean, sand and degrease with silicone remover
	<b>Galvanized substrates</b>
	Ammoniacal wetting agent wash

Application	<b>Material pressure (bar)</b>	<b>Atomizer pressure (bar)</b>	<b>Nozzle (mm)</b>
	<b>Compressed air (cup gun)</b>	3 – 4	–
	<b>Airless</b>	120 – 150	–
	<b>HVLP</b>	2.5 – 3	–
			1.4 – 1.5
			0.28 – 0.33
			1.4 – 1.5
Dilution	<b>Viscosity (s)</b>	<b>Addition (%)</b>	<b>Thinner</b>
	<b>Compressed air (cup gun)</b>	–	40 – 50
	<b>Airless</b>	–	5 – 10
	<b>Painting/rolling</b>	–	–
	<b>HVLP</b>	–	40 – 50
			–
			Universalverdünner unverdünnt verarbeiten
Drying at 20 °C	<b>Dust-dry (TG1)</b>	After approx. 15 - 20 minutes	
	<b>Touch-dry (TG4)</b>	After approx. 45 - 60 minutes	
	<b>Ready for installation (TG6)</b>	After approx. 4 - 5 hours	
	<b>Ready for overpainting</b>	After approx. 60 minutes	
	Drying depends on the relative humidity, the air and object temperature and the layer thickness. The data determined correspond to the standard conditions at 20°C room temperature and 65% relative humidity.		
Drying at 60 °C	<b>Ready for installation (TG6)</b>	After approx. 30 minutes	
Structure	<b>Iron, steel, aluminum</b>	Primer: Dolwaprim (layer thickness: 20-30 µm) Top coat: Various Dold 1K and 2K top coats	
	<b>Aluminium, galvanized substrates:</b>	Primer: Dolwaprim (layer thickness: 20-30 µm) Top coat: Various Dold 1K and 2K top coats	
Coverage	8 – 12 m <sup>2</sup> /kg (at 20µm dry film thickness) When used as a primer, only 1 spray coat (15-20 µm) is necessary.		
Tool cleaning	Clean immediately and thoroughly with thinner (e. g. universal or cellulose thinner).		

### Information

Hazard warnings	For further information see the corresponding EU safety data sheet.
Further information	The SMGV information sheets and the FSO guidelines must be observed.

Important

**Thinning**

F 6290 Universal thinner

**Further information**

- We recommend creating sample surfaces in advance for components such as doors, frames, etc.
- Can be applied electrostatically.
- Use Docamin primer on zinc and aluminum in exterior areas (increased requirements).
- Suitable for coating wooden floor panels in rail vehicles.

## Quality and environment



The Spaceline tinting system is the ideal colour mixing solution for today's needs. It cuts your costs for expensive storage and gives you new flexibility of supply. Spaceline paint concentrates are universal colour pastes with high-quality pigmentation. You can use them to produce RAL, NCS, IGP and many other colours with the DOLD Spaceline tinting system.



With the environmental label, coating materials can be identified in a transparent and clear scheme according to environmental and health protection criteria, as well as suitability for use. The environmental label creates transparency for the builder, architect, planner and client. All products of Dold AG are classified in the category A to G.



Dold AG was founded on August 01, 1921 by Hans Dold in Wallisellen. Until Dold is still located at the same site and is one of the leading paint and varnish manufacturers in paint manufacturers in Switzerland. In Wallisellen, Dold AG develops and manufactures its innovative range of paints and varnishes for the construction painter as well as for industrial customers.



Swiss paint and varnish factory certified according to ISO 9001 / 14001 / 45001. Dold AG is one of the few one of the few paint and varnish factories which not only has its quality management, management, but also its environmental management system, as well as the occupational safety and health protection processes have been certified. These certifications are a clear commitment for Dold AG towards all its commitment to all its stakeholders.



Environmentally friendly products are a concern for DOLD. The foundation KMU Clima confirms Dold AG's contribution to voluntary climate protection. For this concern all direct emissions of CO<sub>2</sub> in form of electricity, heating and mobility are compensated by DOLD to a reforestation project in Uruguay. This is a long-term contribution to climate protection and for the sake of the environment.

The above information is for general guidance only. The working conditions beyond our control and the large number of different substrates mean that no claims can be made on the basis of this information. In case of doubt, we recommend that you carry out sufficient tests yourself. A guarantee can only be given for the consistently high quality of our products. All previous editions of this data sheet hereby lose their validity.