



Technical Data Sheet

CrystalCoat™ PR-660A

Weatherable Primer for Flow Coat Application

DESCRIPTION

CrystalCoat™ PR-660A is a solvent based primer designed for flow coat applications to impart weatherability and UV protection to coated parts when used with a compatible hard coat.

FEATURES

- Weatherability
- Designed for flow coat application
- Adhesion promotor to PC

STORAGE AND USE

The recommended storage temperature for PR-660A is 20 - 25°C (68 - 77F). When stored at this temperature in the original closed container, it is recommended to start use of PR-660A within 6 months of the date received.

SOLUTION PROPERTIES

| PROPERTY | TYPICAL VALUES |
|---|----------------|
| Solids | 2.0 - 4.0% |
| Viscosity @ 25°C | 2 - 5 cP |
| Solvents: PM Glycol Ether, Diacetone Alcohol, PM Glycol Ether Acetate | |

CURED COATING PROPERTIES

| PROPERTY | TYPICAL VALUES |
|------------------|----------------|
| Primer Thickness | 0.2 - 1.0 µm |
| Refractive Index | 1.50 |
| Adhesion | 100 % |

RECOMMENDED OPERATING GUIDELINES

| PROPERTY | TYPICAL VALUES |
|--------------------------|---|
| Environmental Conditions | 20 - 25°C, 35 - 55 % RH |
| Air Flow | Filtered, Laminar (Class 100) |
| Coating Temperature | 20 - 23°C |
| Coating Filtration | 5 - 10 µm absolute |
| Extraction Speed | 3.5 - 4.2 mm/s |
| Dry Time/Temperature | 3 - 5 min infrared heater or 20 min @ 20 - 25°C |



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SDC TECHNOLOGIES CONTACT INFORMATION

Corporate Headquarters - USA
45 Parker, Suite 100
Irvine, California 92618 USA
800-272-7681 (Toll-Free USA)
+1-714-939-8300
technicalsupport.ca@sdctech.com

Europe Office
Unit 6 John Baker Close
Llantarnam Industrial Park
Cwmbran, Torfaen
NP44 3AX, United Kingdom
+44-1633-627030
technicalsupport.eu@sdctech.com

China Office
1585 Gumei Road
Xuhui District
Shanghai 200233
China
+86-21-61995035
customer-care.cn@sdctech.com

Singapore Office
27 Tuas South Street 1
Singapore 638035
+65-6210-6355
customer-care.ap@sdctech.com

SDC

Technologies

sdctech.com

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EQUIPMENT PREPARATION

Equipment Cleaning: Coating equipment should be cleaned prior to use of PR-660A in order to avoid any possible contamination problems. The cleaning process should include multiple solvent rinses (utilizing a solvent compatible with the material in prior use with the equipment) followed by a thorough PM Glycol Ether rinse. PM Glycol Ether should also be used for cleaning equipment after the use of PR-660A.

Equipment Materials: All equipment surfaces that are exposed to PR-660A should be constructed of stainless steel, polyethylene, polypropylene or Teflon®. Other materials should be tested for compatibility with PR-660A prior to use. Materials made with polyvinyl chloride (PVC) should not be used under any circumstances with PR-660A or other coatings that contain glycol ethers.

SOLUTION MANAGEMENT

For optimum performance, PR-660A coating solution should be maintained in a % solids range of 2.0 - 4.0%. Higher or lower solids can cause appearance problems or lead to a coating deposition that is either too thick or too thin, respectively. The % solids should be measured on a regular basis and adjusted as needed by the addition of an 80/20 mixture of PM Glycol Ether and Diacetone Alcohol.

HEALTH AND SAFETY INFORMATION

Before using this product, read and understand the Safety Data Sheet, SDS, which provides information on health, physical, and environmental hazards, handling precautions and first aid recommendations. For a copy of an SDS, contact a sales or customer service representative.

WARRANTY AND LIABILITY LIMITATIONS

Information contained herein is accurate to the best of our knowledge. The coating solution properties and cured coating properties listed herein represent typical values for PR-660A and are not meant as specifications. SDC Technologies, Inc. insists that users conduct their own tests for applicability and fitness for any purpose. Statements concerning use of products or formulations described herein shall not be construed as a warranty or license to infringe any patent or trademark, and no liability for infringement arising out of such use is assumed. Please refer to SDC Technologies' Standard Terms and Conditions or to your Purchase Agreement with SDC for the warranty coverage of SDC's product.

PRODUCT SHIPPING AND AVAILABILITY

Typical lead-time for shipment of PR-660A is four (4) weeks from confirmation of a purchase order. SDC provides several shipping options. Please contact an SDC representative to determine which option best fits your needs. All orders are shipped F.O.B. Additional shipment charges including customs clearance and fees (if applicable) are the responsibility of the customer.