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## INDUSTRIAL COATINGS

Issued 28.10.2009

### Water Borne Primer NT, series 4812.000

#### Description and main features

Low VOC water borne primer for steel and cast iron.

Like all water-based products, it is influenced by the drying temperature and relative humidity, therefore the structures must be protected for an appropriate time, depending on the environmental conditions, during the drying time of the product.

**Recommended use:** as a primer for steel structures where speed of drying, handling time and environmental issues are crucial.

#### Technical data

<b>Finish</b>	Flat (*)
<b>Color</b>	RAL shades, other shades on request(*) (**)
<b>Specific gravity</b>	1,50 ± 0,05 kg/dm <sup>3</sup> at 23°C, referring to 4812410 grey RAL 7003
<b>Solid content</b>	<b>By weight</b> 60 ± 3% referring to 4812410 grey RAL 7003
	<b>By volume</b> 40 ± 3% referring to 4812410 grey RAL 7003
<b>VOC</b>	14 g/kg referring to 4812410 grey RAL 7003 (*)
<b>Viscosity</b>	At 23°C DIN cup n°4 : 40-60" according to ISO 2431 (*) (**)
<b>Drying time</b>	At 23 °C ,50% RH, good ventilation, DFT 70 µm, referring to 4812410 grey RAL 7003 <b>Touch dry:</b> 2 h <b>Hard dry:</b> 18 h <i>Touch dry:</i> according to internal method MS 035 based on ISO 4622 <i>Hard dry:</i> according to internal method MS 036 based on ISO 4622 (*)
	<i>Drying times can vary depending on DFT and environmental conditions</i>

#### Thinning

<b>Thinning</b>	By water at application viscosity
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### Application data

<b>Method</b>	Airless or air mix, brush, roller	
<b>Airless or air mix</b>	<b>Pump ratio</b>	30:1
	<b>Nozzle orifice</b>	013-015"
	<b>Nozzle pressure</b>	140-180 atm
	<i>Filters must fit the used nozzle.</i>	
<i>Indicative data; it is the user's responsibility to chose the right equipment.</i>		
<b>Suggested Primers</b>	None Epoxy primers series 706.000, 703.000 or 7073.000, Retron Acrilico primers series 773.000, Alkyd primer series 194.000 and, further to testing, on most of the other primers.	
<b>Suggested Topcoats</b>	Primer-Finish NT SL series 4814.000, Finish NT LD extra series 4816.000, Retron Acrilico series 778.000 or 777.000, Agrizan series 167.000 or 168.000, Retron FL series 732.000 or 733.000.	
<b>Application conditions</b>	Application suggested above 10°C, RH<60%. Substrate perfectly degreased or sandblasted to SA 2 ½ according to ISO 8501-1: 1988, no rain nor fog. <b>Temperatures lower than 10°C and RH &gt;60% can stop the film formation.</b> It can be recoated by itself or with the suggested top coats after 24 h from the application and within 96 h at 20°C, 50% RH and good ventilation. After 96 h a surface roughening and a careful cleaning are needed before over coating. Data vary with DFT and environmental conditions	

### Recommended DFT

<b>Recommended DFT</b>	60-80 µm
<b>Theoretical consumption</b>	approx. 225-300 g/m <sup>2</sup> referring to 4812410 grey RAL 7003 (*)
<b>Practical spreading rate</b>	30-40% lower than the theoretical, by airless application.
<b>Number of coats</b>	ONE or TWO

### Specific tests

**Pull-off adhesion test according to ISO 4624**  
≥ 1 MPa



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### Storage indications

Shelf life: 8 months provided the cans are kept sealed and undamaged, into a cool and dry place with temperature between 5 and 35°C. Susceptible to frost damage.

### Usability according to DL 27.03.2006 n°161

No limitations. It belongs to category **d)** Indoor/Outdoor water borne finishes for wood or plastic.  
2010 limit = 130 g/l

(\*) indicative value, depending on the color - (\*\*) parameters subject to testing for each batch

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