



www.zetagi.it

zetagi

Veneziani

## INDUSTRIAL COATINGS

Issued 08.01.2009

### Epoxy Primer HB, series 706.700

#### Description and main features

Two pack polyamide epoxy primer.

Good wetting properties, high chemical and physical strength. Excellent adhesion on steel and, further to testing to ensure adhesion, on most of the metals. Curing agent 701461 helps limiting the yellowing.

**Recommended use:** as a primer on steel surfaces and equipment in general; as a finish coat (with C.A. 701461) if chalking is not an issue.

#### Technical data

<b>Finish</b>	Semi-gloss (*)
<b>Color</b>	RAL shades on request (*) (**)
<b>Specific gravity</b>	1,44 ± 0,05 kg/dm <sup>3</sup> at 23°C, referring to 706730 RAL 7035 cured with 701450-701451-701461 according to ISO 2811-1 (*)
<b>Solid content</b>	<b>By weight</b> 67 ± 3% referring to 706730 RAL 7035 cured with 701450-701451-701461 ,(*)
	<b>By volume</b> 47 ± 3% referring to 706730 RAL 7035 cured with 701450-701451-701461(*)
<b>VOC</b>	330 g/kg referring to 706730 RAL 7035 cured with 701450-701451-701461(*)
<b>Viscosity</b>	Brookfield on the base at 23°C (spindle 3, 0.5 RPM) : 70.000-130.000 mPas according to internal method MS 007 (*) (**)
<b>Drying time</b>	At 23°C ,50% RH, good ventilation, DFT 70 µm, referring to 706730 RAL 7035 <b>with 701450-701461</b>
	<b>Touch dry:</b> 8 h <b>Hard dry:</b> 32 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>

#### Mixing and thinning

<b>Mixing ratio</b>	<b>By weight:</b> 100:20 with 701450-701451-701461 <b>By volume:</b> 2,8:1 with 701450-701451-701461 <i>Mix carefully before and after the curing process</i>
<b>Pot life</b>	> 8 h at 20°C - <i>Data vary with temperature and thinning.</i>
<b>Thinning</b>	5-15% by Thinner 900033 or 901040 winter type 5-15% by Thinner 903015 or 901042 summer type 5-15% by Thinner 903014 slow <i>Chose the thinner according to the environmental and application conditions in order to allow at least 5-10' drying time.</i>



www.zetagi.it

**zetagi**

**Veneziani**

## INDUSTRIAL COATINGS

### Application data

<b>Method</b>	Airless or air mix <i>for brush or roller application, specific curing agent and thinners must be used</i>	
<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 choose the right equipment.</i>		
<b>Suggested Primers</b>	None. It can be applied on top of Epoxy primers series 706.000.	
<b>Suggested Topcoats</b>	Retron Acrilico 777.000-778.000 or epoxy 700.000, 700.300,702.000, 705.000, 702.800 or Retron Polyurethane 732.000 or 733.000	
<b>Application conditions</b>	<p>Application suggested between 5°C and 35°C and at least 3°C above dew point. Substrate perfectly dry and clean, no rain nor fog.. Temperatures lower than 5 °C can impair the film formation.</p> <p>The product can be over coated between 12 and 72 h from the application, at 20°C, 50% RH, and good ventilation. After 72 h a roughening or a careful cleaning (according to the finish coat and painting system) is needed before over coating.</p> <p>Data vary with DFT and environmental conditions</p>	

### Recommended DFT

<b>Recommended DFT</b>	60-80 µm
<b>Theoretical consumption</b>	approx. 180-245 g/m <sup>2</sup> referring to 706730 RAL 7035 cured with 701450-701451-701461 (*)
<b>Practical spreading rate</b>	30-40% lower than the theoretical, by airless application.
<b>Number of coats</b>	ONE or TWO

### Storage indications

Shelf life: 12 months (base only: 18 months), provided the cans are kept sealed and undamaged, into a cool and dry place with temperature between 5 and 35°C.

### Usability according to DL 27.03.2006 n°161

No limitations. It belongs to category j) Two component, high performance solvent based paints.  
2010 limit = 500 g/l



www.zetagi.it

**zetagi**

 **Veneziani**

## INDUSTRIAL COATINGS

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

*The information in this data sheet about the use of our products are based on our present scientific knowledge and practice. Zetagi accepts no commitment and / or responsibility on the final result of the work with our products. It is the customer's responsibility to verify the suitability of our products for the intended use. All the products and the advice given are subject to our general conditions of sale which we recommend you to request and read carefully. This data sheet replaces and annuls the previous ones: it is the user's responsibility to ensure that this sheet is updated prior to using the product. This data sheet is a translation; the Italian text of this document shall prevail over any translation thereof.*