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INDUSTRIAL COATINGS

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Epoxy Primer/Intermediate NP, series 7073.000/DP

Description and main features

Two pack, high volume and high build, 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. C.A. 701477 allows applications in wet and cold environment.

Recommended use: as a primer or an intermediate on steel and hot dipped galvanized steel; as a finish coat if chalking is not an issue.

Technical data

Finish	Semi-gloss (*)								
Color	RAL shades on request (*) (**)								
Specific gravity	1,43 ± 0,05 kg/dm ³ at 23°C, referring to RAL 7035 cured with 701455 1,55 ± 0,05 kg/dm ³ at 23°C, referring to RAL 7035 cured with 701477 according to ISO 2811-1 (*)								
Solid content	By weight 77 ± 3% referring to RAL 7035 cured with 701455 83 ± 3% referring to RAL 7035 cured with 701477 (*)								
	By volume 64 ± 3% referring to RAL 7035 cured with 701455 70 ± 3% referring to RAL 7035 cured with 701477 (*)								
VOC	220g/Kg referring to RAL 7035 cured with 701455 170g/Kg referring to RAL 7035 cured with 701477 (*)								
Viscosity	Brookfield on the base at 23°C (spindle 5, 0.5 RPM) : 50.000 - 150.000 mPas according to internal method MS 007 (*) (**)								
Drying time	<i>At 23°C, 50% RH, good ventilation, DFT 100 µm, referring to 7073321</i>								
	<table border="0"> <tr> <td></td> <td style="text-align: center;">with 701455</td> <td style="text-align: center;">with 701477</td> </tr> <tr> <td>Touch dry:</td> <td style="text-align: center;">15h</td> <td style="text-align: center;">10h</td> </tr> <tr> <td>Hard dry:</td> <td style="text-align: center;">48h</td> <td style="text-align: center;">48h</td> </tr> </table> <p><i>Touch dry: according to internal method MS 035 based on ISO 4622</i> <i>Hard dry: according to internal method MS 036 based on ISO 4622 (*)</i></p> <p><i>Drying times can vary depending on DFT and environmental conditions</i></p>		with 701455	with 701477	Touch dry:	15h	10h	Hard dry:	48h
	with 701455	with 701477							
Touch dry:	15h	10h							
Hard dry:	48h	48h							

Mixing and thinning

Mixing ratio	By weight: 100:20 with 701455 100:8 with 701477 By volume: 2,7:1 with 701455 7,2:1 with 701477
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	<i>Mix carefully before and after the curing process</i>
Pot life	> 6 h at 20°C - <i>Data vary with temperature and thinning.</i>
Thinning	10-15% by Thinner 900033 or 901040 winter type 10-15% by Thinner 903015 or 901042 summer type 10-15% by Thinner 903014 slow or when applied on top of Zinc Rich Epoxy or Inorganic Zinc Silicate <i>Chose the thinner according to the environmental and application conditions in order to allow at least 5-10' drying time.</i>

Application data

Method	Airless o air mix <i>for brush or roller application, specific curing agent and thinners must be used</i>	
Airless or air mix	Pump ratio	30:1
	Nozzle orifice	013-015"
	Nozzle pressure	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>		
Suggested Primers	Zinc Rich Epoxy series 706176-706192-706220-706181, Inorganic Zinc Silicate series 760205-76021, Epoxy primers series 706.000 or series 703.000.	
Suggested Topcoats	Retron Acrilico 777.000-778.000	
Application conditions	Application suggested between 5°C and 30°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. C.A.701477 allows applications at 0 °C. Maximum recoat time depends from local environmental conditions. The best adhesion will be achieved applying the topcoat before the primer's complete curing time. Anyhow, to obtain a good adhesion be sure that the surface to be painted is free from any contaminants and chalking. When used as a primer, a sandblasting to SA2½ according to ISO 8501-1: 1988 allows the best performance in terms of chemical-mechanical strength. Data vary with DFT and environmental conditions	

Recommended DFT

Recommended DFT	50-120 µm
Theoretical consumption	approx. 110-270 g/m ² referring to RAL 7035 cured with 701455 approx. 110-270 g/m ² referring to RAL 7035 cured with 701477 (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	ONE or TWO



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Specific tests

The product can be used as second coat in the ANAS B paint system.

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

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

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