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INDUSTRIAL COATINGS

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MIO Epoxy Primer/Intermediate NP, series 7073000

Description and main features

Two pack, high volume and high build, MIO 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	1,44 ± 0,05 kg/dm³ at 23°C, referring to 7073404 RAL 7030 cured with 701455 1,56 ± 0,05 kg/dm³ at 23°C, referring to 7073404 RAL 7030 cured with 701477 1,58 ± 0,05 kg/dm³ at 23°C, referring to 7073404 RAL 7030 cured with 701478 according to ISO 2811-1 (*)
Solid content	**By weight** 78 ± 3% referring to 7073404 RAL 7030 cured with 701455 84 ± 3% referring to 7073404 RAL 7030 cured with 701477 86 ± 3% referring to 7073404 RAL 7030 cured with 701478 (*)
	By volume 64 ± 3% referring to 7073404 RAL 7030 cured with 701455 72 ± 3% referring to 7073404 RAL 7030 cured with 701477 75 ± 3% referring to 7073404 RAL 7030 cured with 701478 (*)
VOC	220g/Kg referring to 7073404 RAL 7030 cured with 701455 160g/Kg referring to 7073404 RAL 7030 cured with 701477 140g/Kg referring to 7073404 RAL 7030 cured with 701478 (*)
Viscosity	Brookfield on the base at 23°C (spindle 5, 0.5 RPM) : > 200.000 mPas according to internal method MS 007 (*) (**)
Drying time	*At 23°C ,50% RH, good ventilation, DFT 100 µm*, referring to 7073404 RAL 7030 **with 701455** **with 701477** **Touch dry**: 15h 10h **Hard dry:** 48h 48h *Touch dry:* according to internal method *MS 035* based on *ISO 4622* *Hard dry:* according to internal method MS 036 based on ISO 4622 (*)
	Drying times can vary depending on DFT and environmental conditions

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Mixing and thinning

Mixing ratio	**By weight:** 100:20 with 701455 100:8 with 701477 - 701478 **By volume**:2,7:1 with 701455 7,2:1 with 701477 *Mix carefully before and after the curing process*
Pot life	> 6 h at 20°C - *Data vary with temperature and thinning.*
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 *Chose the thinner according to the environmental and application conditions in order to allow at least 5-10' drying time.*

Application data

Method	Airless o air mix *for brush or roller application, specific curing agent and thinners must be used*	
Airless or air mix	**Pump ratio**	45:1
	Nozzle orifice	015-017"
	Nozzle pressure	140-180 atm
	Filters must fit the used nozzle.	
	Indicative data; it is the user's responsibility to chose the right equipment.	
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	

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Recommended DFT

Recommended DFT	80-200 µm
Theoretical consumption	approx. 180-450 g/m² referring to 7073404 RAL 7030 cured with 701455 approx. 175-430 g/m² referring to 7073404 RAL 7030 cured with 701477 approx. 170-420 g/m² referring to 7073404 RAL 7030 cured with 701478 (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	ONE or TWO

Specific tests

The product, when cured with C.A.701455, 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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