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INDUSTRIAL COATINGS

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Water Borne Primer-Finish EPOX "W", series 7093.000

Description and main features

Low VOC water borne primer-finish.

Excellent anti corrosive properties and resistance to hydraulic oils just after 24 h from the application. Good adhesion on hot dipped galvanized steel.

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

Technical data

Finish	Semi-gloss, according to ISO 2813 (*) (**)
Color	RAL shades, other shades on request(*) (**)
Specific gravity	1,42 ± 0,05 kg/dm ³ at 23 °C, referring to 7093030 black, cured with 701402
Solid content	By weight 62 ± 3% referring to 7093030 black, cured with 701402
	By volume 46 ± 3% referring to 7093030 black, cured with 701402
VOC	38 g/kg referring to 7093030 black, cured with 701402 (*)
Viscosity	Brookfield on the base at 23 °C (spindle 3, 0.5 RPM) : 60.000-80.000 mPas, according to internal method MS 007 (*) (**)
Mixing ratio	By weight: 100:15 with 701402 By volume: 4,7:1 with 701402 <i>Mix carefully before and after the curing process</i>
Pot life	5-6 h at 20 °C - <i>Data vary with temperature and thinning.</i>
Drying time	At 23 °C ,50% RH, good ventilation, DFT 70 µm, referring to 7093030 black Touch dry: approx. 30' Hard dry: approx. 12 h
	<i>Drying time can be shortened by hot air. Outdoor exposure recommended after 10 days from the application. Drying times can vary depending on DFT and environmental conditions</i>

Thinning

Thinning	By water at application viscosity
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Application data

Method	Airless or air mix, brush, roller	
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	None. Inorganic Zinc Silicate series 706205-760210 or Zinc Rich Epoxy series 706176.	
Suggested Topcoats	Retron acrilico series 773.000-777.000-778.000 or water borne finishes series 4812.000 - 4814.000 - 4816.000	
Application conditions	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. Temperatures lower than 10°C and RH >60% can stop the film formation. It can be recoated by itself or with the suggested top coats after 12-24 h from the application and within 72 h at 20°C, 50% RH and good ventilation. After 72 h a careful cleaning is needed before over coating. Data vary with DFT and environmental conditions	

Recommended DFT

Recommended DFT	50-70 µm
Theoretical consumption	approx. 155-215 g/m ² referring to 7093030 black (*)
Practical spreading rate	30-40% lower than the theoretical, by airless application.
Number of coats	ONE or TWO

Storage indications

Shelf life: 6 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.



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Usability according to DL 27.03.2006 n°161

No limitations. It belongs to category **j)** Two components, water borne high performance paints
2010 limit = 140 g/l

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

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