

TECHNICAL DATA SHEET

Date of issue: 25/11/2008

Last updating:n°5 07/02/2017



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Name:	ACRYDUR	Category:	B/c
Definition:	Industrial acrylic primer	V.O.C. ready to use:	540 g/l
Code:	69.3	Product according to	2004/42/CE

NATURE OF THE PRODUCT

Product based on hydroxylated acrylic resins and isocyanic polymer to mix before use. It contains anti corrosion pigments based on zinc phosphate.

GENERAL USES

Primer for steel, aluminum and galvanized steel of general use, machine tools, metal structural work, earth moving machines, buses, trucks and industrial vehicles in general. Sandable.

APPLICATION METHOD

PREPARATION OF SURFACES

The cleaning of the application surface should be total and painstaking and it is a fundamental and necessary condition to obtain positive result of the painting cycle.

This means that presence of grease, oils, dirt, rust and calamine on the surfaces, is absolutely not allowed.

- Ferrous surfaces. Remove all presence of rust, calamine, grease and moisture by SA2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners.
- Galvanized sheets. Very careful cleaning of dirt and oxidation, followed by degreasing using organic solvents.
- Aluminium. Chromate or phosphorous chromate treatment or light sanding procedure followed by degreasing using organic solvents.

PREPARATION OF THE PRODUCT

	Code	name	By weight	By volume
Component A	69.3	Acrydur	100 parts	100 parts
Component B	01.014	Polirex NI	15 parts	25 parts
Component B	01.016 ¹	Polirex medium yellowing	15 parts	25 parts

Carefully mix until an even colour and consistency are obtained. For airless applications no dilution is requested, for standard airmix application dilute with our acrylic thinner 07.013 at 10-20% to obtain a viscosity of 28"-32" Ford 4. At temperatures over 25°C use slow thinner 07.030 and slow hardener 01.012.

APPLICATION

Spray gun:	Nozzles of 1,4-1,7 mm. diameter and 3-5 atm. pressure.
Airless.	Nozzle 0,09 inches, 180-240 bar
Electrostatic	Suitable
Brush/roller	Only for large surfaces ²

¹ Using this hardener, the adhesion could be worse, especially on flexible surfaces.

² You may need Antifoam additive 03.009 in order to avoid bubble formation whilst using these tools.

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TECHNICAL DATA

PRODUCT TYPE:	Two pack primer										
APPEARANCE (ASTM D 523):	Matt (<10 gloss).										
COLOURS:	White (69.3.90150), beige RAL 1001 (69.3.R1001)										
SPECIFIC WEIGHT (ISO 2811):	1,70 g/cm ³ comp. A (±0,08)										
SUPPLY VISCOSITY(DIN 53211) :	55" ± 5" Ford 8										
SOLID ON VOLUME:	A + B 48% (± 2% with 01.014)										
SOLIDS CONTENT:	A + B 73 % (± 2% with 01.014)										
DRYING AT 20°C	<table><tbody><tr><td>- Dust dry:</td><td>20-30 minutes</td></tr><tr><td>- Touch dry:</td><td>2-3 hours</td></tr><tr><td>- Total hardening :</td><td>24-36 hours</td></tr><tr><td>- Forced drying</td><td>30' at 60°C</td></tr><tr><td>- Maximum chemical resistance:</td><td>After 7 days</td></tr></tbody></table>	- Dust dry:	20-30 minutes	- Touch dry:	2-3 hours	- Total hardening :	24-36 hours	- Forced drying	30' at 60°C	- Maximum chemical resistance:	After 7 days
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- Maximum chemical resistance:	After 7 days										
RECOMMENDED COATS:	one or two, waiting 30 minutes between the two coats										
THICKNESS³:	40-60 µm each coat										
THEORETIC YIELD⁴:	6-8 m ² /kg										
POT-LIFE AT 20° C:	1 hour. At higher temperatures, pot-life decreases.										
SALT SPRAY TEST (ASTM B 117):	If applied on a cycle with primer and topcoat with a final dried film thickness of 120 µm, 400-600 hours, depending on the quality of the topcoat used										
IMPACT TEST (ASTM D 2794):	30 kg direct, 10 kg reverse on sanded iron.										
ADHESION (ASTM D 3359):	B=5 on surfaces treated like above reported.										
REPAINTING:	After 30 minutes - 2 hours depending on room temperature. Over 8-12 hours it is necessary a light scratch before overcoating (8 hours when using 01.016 hardener, 12 hours when using 01.014 hardener).										
STORAGE STABILITY:	One year for A component, 6 months for B component stored in closed packs, in a cool, dry place, away from any sources of heat.										

³ Considering a dry film.

⁴ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.