

TECHNICAL DATA SHEET

Date of issue: 04/05/2006

Last updating:n°4 25/01/2016



SIRO S.r.l.

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Name:	SIRNOX N	Category:	primer
Definition:	Phenolic nitroresistant primer	V.O.C. ready to use:	540 g/l
Code:	79.2	Product outside the uses referred to	2004/42/CE

NATURE OF THE PRODUCT

Anticorrosive primer based on oleophenolic resins.

GENERAL USES

General use primer, fit for steel structural works, coachworks, agricultural machines tools, etc.

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 and oils on the surfaces, is absolutely not allowed.

- Ferrous surfaces. SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners, then proceed with the direct application of the product.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. For airless applications no dilution is requested, for standard airmix application dilute with our 07.002 nitro thinner or 07.005 synthetic thinner in a percent of 15-20% to obtain a viscosity of 25-28" Ford 4 .

APPLICATION

Spray gun: nozzles of 1,6-1,8 mm. diameter and 3-5 atm. pressure.

Airless. nozzle 0,09 inches, 120-150 bar

Brush/roller Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE: Monocomponent

APPEARANCE (ASTM D 523): Matt (15±5 gloss).

COLOURS: By request (the binder 79.2.K1 has to be used in a ratio 85/15 with the tintometric system tinters). To have a better corrosion resistance 79.2.70121, produced by direct grinding and not with the tintometric system, is suggested.

SPECIFIC WEIGHT (ISO 2811): 1.42 ± 0.05 kg/l

SUPPLY VISCOSITY(DIN 53211): 12" ± 2" Ford 8

SOLID ON VOLUME: 48 % (± 2%)

SOLIDS CONTENT: 68 % (± 2%)

DRYING AT 20°C - Dust dry: 15-20' - Touch dry: 40-60'

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	- Total hardening :	24h	- Forced drying ¹	30' at 60°C
	- Maximum chemical resistance:	After 7 days		
RECOMMENDED COATS:	One crossed coat.			
THICKNESS²:	60-80 µm			
THEORETIC YIELD³:	6-8 m ² /kg			
SALT SPRAY TEST (ASTM B 117):	If applies in a cycle primer-topcoat with a dry film thickness of 100-120 µm, 500 hours, a dried film of 60 µm of primer, 300 hours.			
IMPACT TEST (ASTM D 2794):	36 kg direct, 15 kg reverse, on sanded iron.			
ADHESION (ASTM D 3359):	B= 5 on surfaces treated like above reported.			
REPAINTING:	After minimum 4 hours with a solvent based system, or even after 30-60' with a water based system. Over 7 days a light sanding is suggested before overcoat.			
STORAGE STABILITY:	One year, stored in closed packs, in a cool, dry place, away from any sources of heat.			

¹Baking the product can produce the popping effect, to avoid this is better a flash-off time of 30'-60' before put the paint to dry in the oven

² Considering a dry film.

³ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces for product ready to be used.