

TECHNICAL DATA SHEET

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Name:	ZINC RICH PRIMER	Category:	Primer
Definition:	Anticorrosive epoxy primer	V.O.C. limit:	540 g/l
Code:	29.4.70223	V.O.C. ready to use:	510 g/l
Product outside the uses referred to 2004/42/CE			

NATURE OF THE PRODUCT

Two pack epoxy enamel to be mixed before use containing 88% of zinc metallic on dried film

GENERAL USES

Primer for iron suggested when cathodic protection (due to the zinc metallic presence) is requested

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.

- Ferrous surfaces: SA2 sanding or very careful mechanical cleaning followed by degreasing with thinners.

Then, after 4-6 hours and within 24 hours, proceed with the application of an intermediate like our epoxy primer 29.3.

PREPARATION OF THE PRODUCT

	code	name	By Weight	By Volume
Component A	29.4.70223	Zinc rich primer	100 parts	100 parts
Component B	02.023	Eporex for zinc rich primer	10 parts	parts

Carefully mix until an even colour and consistency are obtained. Dilute with our epoxy thinner 07.006 in a percent of 3-6 % depending on the application way. For airless no dilution is requested, and use low pressure. For spraying plants in which product is already mixed in A and B component in a big can, continuous stirring is necessary because zinc metallic component precipitates on the bottom of the can if not mixed or shaken.

APPLICATION

Spray gun: nozzles of 1,4-1,8 mm. diameter and 3-3.5 atm. pressure.

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

Roller or brush: Only for small surfaces

TECHNICAL DATA

PRODUCT TYPE: bicomponent

FILM APPEARANCE matt (25±10 gloss)
(ASTM D 523):

COLOURS: dark grey

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SPECIFIC WEIGHT A + B 2,72 kg./l. ($\pm 0,05$)
(ISO 2811):

SUPPLY VISCOSITY 8000-15000 CPs
:

SOLID ON VOLUME: 33% (± 2) A+B

SOLIDS CONTENT: 88% (± 2) A+B

DRYING AT 20°C

- Dust dry:	30-40'	- Touch dry:	4-5 hours
- Total hardening :	24 hours	- Forced drying ¹	45' at 60°C
- Maximum chemical resistance: After 7 days			

RECOMMENDED COATS: One

THICKNESS²: 40-60 μm

THEORETIC YIELD³: 4-5 m^2/kg

POT-LIFE AT 20°C: 6 hours. At higher temperatures, pot-life decreases.

SALT SPRAY TEST (ASTM B 117): For the cycle primer 29.4.70223, 40 μm , intermediate 29.3.70121, 60 μm , top coat 68.1, 50 μm , 1500 hours

IMPACT TEST (ASTM D 2794): B=30 kg direct

ADHESION (ASTM D 3359): B=5 on iron treated like above reported

REPAINTING: After minimum 4-6 hours

STORAGE STABILITY: Two year stored in closed packs, in a cool, dry place, away from any sources of heat.

¹ Baking the product can change the final gloss result, it could result more matt

² Considering a dry film.

³ The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces.