

TECHNICAL DATA SHEET

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Name: SANDING NITRO FILLER

Definition: Nitrosynthetic primer

Code: 49.2

Category: primer

V.O.C. ready to use: g/l 570

Product outside the uses referred to
2004/42/CE

NATURE OF THE PRODUCT

One-pack sanding primer based on nitro-alkyd resins

GENERAL USES

Product for general use, car refinishing, carpentry, machines tools, very fast so indicated especially for spot repair.

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 perfect mechanical cleaning of the substrate by sanding to remove rust and calamine, followed by degreasing with surfactants aqueous solutions or organic solvents. Then proceed with the application of the nitro primer. Whether particular corrosion resistances are requested, we suggest applying previously an epoxy primer, like our 29.3 or 29W5, let it dry, sand and then proceed with the application of the nitro primer.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. Dilute with our anti-fog nitro thinner 07.001 at 30% to obtain a viscosity of 28"±5" Ford 4 at 20°C.

APPLICATION

Spray gun: nozzles of 1,4-1,6 mm. diameter and 3-5 atm. pressure.

Airless. nozzle 0,09 inches, 120-150 bar (dilution will be lower or none with this kind of application)

TECHNICAL DATA

PRODUCT TYPE: One pack product.

APPEARANCE (ASTM D 523): Matt (<25 gloss).

COLOURS: The standard is grey RAL 7047 (49.2.R7047). By a minimum request of 300kg, other colors can be prepared.

SPECIFIC WEIGHT (ISO 2811): 1,38 ± 0.20 kg/l

SUPPLY VISCOSITY(DIN 53211) : 20" ± 3" Ford 8

SOLID ON VOLUME: 47% (± 2%)

SOLIDS CONTENT: 65% (± 2%)

DRYING AT 20°C

- Dust dry: 5'
- Touch dry: 15-20'
- Total hardening : 2-4 hours

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	- Forced drying ¹	15' at 60°C
	- Maximum chemical resistance:	After 7 days
RECOMMENDED COATS:	Two or three (5' of flash off between the coats is suggested). An excessive film thickness, a low evaporation between the coats or the use of a not appropriate thinner can give problems in the final drying of the product.	
THICKNESS ²:	50-70 µm	
THEORETIC YIELD ³:	6 m ² /kg	
IMPACT TEST (ASTM D 2794):	25kg direct	
ADHESION (ASTM D 3359):	B= 5 on surfaces treated like above reported.	
REPAINTING:	Wet on wet with itself. After 2-4 hours, with or without a previous sanding, with synthetic systems or with 2K fast drying or polyurethane systems or also nitro and base coat (in this case we suggest a longer waiting and a preliminary test). A previous sanding process before topcoat application, guarantees a better smoothness and glossiness of the topcoat.	
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.