

TECHNICAL DATA SHEET

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SIRO S.r.l.

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Name:	SIRODUR GREEN	Category:	Wash primer
Definition:	Two pack wash primer	V.O.C. limit:	780 g/l
Code:	49.9.60117	V.O.C. ready to use:	780 g/l
Product according to 2004/42/CE			

NATURE OF THE PRODUCT

Two pack wash primer to mix before use, based on polyvinyl and phenolic resins and zinc phosphate.

GENERAL USES

Primer specific for light alloys. Good for steel, galvanized sheet¹, aluminium.

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.

Steel surfaces: remove with a slight sanding every possible rust formation, degrease and clean using thinners.

Aluminium. Chromate or phosphorous chromate treatment or in alternative a slight sanding procedure followed by degreasing using thinners. Coat as soon as possible.

Galvanized sheet. Delicate sanding followed by degreasing using thinners. Coat as soon as possible.

PREPARATION OF THE PRODUCT

	code	name	By Volume
Component A	49.9.60117	Sirodur green	100 parts
Component B	07.115	Hardner for sirodur	100-120 parts

Carefully mix until an even colour and consistency are obtained. If the final viscosity appears to high, more than 30" ford 4, (especially with temperatures < 15°C) dilute with another 20% of our nitro thinner 07 .002 in a way to be able to apply in the right way the product. Pay attention, if the viscosity is too high the final thickness will be higher than 10-15 µm and this can give adhesion problems to the final cycle of application used.

APPLICATION

Spray gun: use nozzles of 1.4-1.6 mm diameter and 3-5 atm pressure

TECHNICAL DATA

PRODUCT TYPE: Two pack product

FILM APPEARANCE Matt (<20 gloss)
(ASTM D 523):

COLOURS: Green

SPECIFIC WEIGHT 1,00 kg/l (± 0,05)

¹ The galvanized sheet are normally passivated.

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(ISO 2811):

SUPPLY VISCOSITY 18" Ford 8 at 20°C (± 3")

(DIN 53211):

SOLID ON VOLUME: 37% (± 2)

SOLIDS CONTENT: 37% (± 2)

DRYING AT 20°C	- Dust dry:	15-20'	- Touch dry:	1 hour
	- Total hardening :	24 hours	- Forced drying ²	20-30' at 60°C

- Maximum chemical resistance: After 7 days

RECOMMENDED COATS: One coat

THICKNESS³: 10-15 µm. on dry film

THEORETIC YIELD⁴: 13 m²/kg.

POT-LIFE AT 20°C: 6-12 hours

IMPACT TEST (ASTM D 2794): 35 kg direct, 20 kg reverse

ADHESION (ASTM D 3359): B=5 on iron, steel, zinc plated and aluminium surfaces treated like above reported

REPAINTING: The product, after total hardening, can be repainted with stoving, quick drying and synthetic enamels. With solvents contained in epoxy, nitrosynthetic and vinyl products, it can verify problems of blistering of the primer. In these cases it is better, considered the different available products, make preliminary tests of compatibility of the top coat.

STORAGE STABILITY: One year for A component, 6 months for B component in closed packs, in a cool, dry place, away from any sources of heat.

² Baking the product can change the final gloss result, it could result more matt

³ Considering a dry film.

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