

TECHNICAL DATA SHEET

Date of issue: 30/05/2000

Last updating:n°3 07/02/2017

Name:	1K ZINC PRIMER	Category:	Al/i
Definition:	One-pack primer with high metallic zinc content	V.O.C. limit:	500 g/l
		V.O.C. ready to use:	500 g/l
Code:	39.4.70223	Product according to 2004/42/CE	

NATURE OF THE PRODUCT

One-pack anticorrosion primer based on modified epoxy resins and high metallic zinc content with excellent resistance to corrosion.

GENERAL USES

Primer for metals, iron, aluminum and galvanized steel, indicated for general purpose, industrial carpentry, agricultural machinery, machine tools. Especially suitable when you need high cathodic protection. Good resistance to medium temperature 150 ° C with peaks of 200 ° C.

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. SA2 1/2 sandblasting or very careful mechanical abrasion followed by degreasing using thinners.
- Aluminium. Chromate or phosphorous chromate treatment or in alternative sanding procedure followed by degreasing using thinners. The coating must follow within 30-60 ', to avoid oxidation of the substrate.
- Galvanized sheet. Sanding followed by degreasing using thinners.

PREPARATION OF THE PRODUCT

Carefully mix until an even colour and consistency are obtained. The product is ready to use and the COV indicated is without considering dilution. If, due to some particular request in applications dilution is necessary, dilute a 0-5% with our nitro thinner 07.002 or synthetic thinner 07.005.

APPLICATION

Spray gun:	nozzles of 1,7-2,0 mm. diameter and 3-5 atm. pressure.
Airless.	nozzle 0,09 inches, 120-150 bar (5% dilution)
Brush/roller	For large surfaces

TECHNICAL DATA

PRODUCT TYPE:	One pack product
APPEARANCE (ASTM D 523):	Matt (<10 gloss).
COLOURS:	Dark grey (similar to ral 7005)
SPECIFIC WEIGHT (ISO 2811):	2.45 ± 0.05 kg/l
SUPPLY VISCOSITY(DIN 53211) :	9" ± 3" Ford 8
ZINC CONTENT:	72%
SOLIDS CONTENT:	80% (± 1%)

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DRYING AT 20°C¹:

- Dust dry: 20-30 minutes
- Touch dry: 1 hour
- Total hardening : 24 hours
- Forced drying 45' at 60°C
- Maximum chemical resistance: After 10 days

RECOMMENDED COATS: One crossed coat

THICKNESS ²: 40-60µm

THEORETIC YIELD ³: 6 m²/kg

SALT SPRAY TEST (ASTM B 117): For a dry film thickness of 50µm on direct adhesion on iron, 250 hours.
For the cycle zinc primer 39.4.70223, intermediate 79.2.70121 and top coat 72.1 for a final film thickness of 140-160µm, 1500 hours.

IMPACT TEST (ASTM D 2794): 36kg direct, 10kg reverse on scratched iron

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

REPAINTING: After 1 hour at 20°C it can be overcoated, but for a better result we suggest to wait at least 4-6 hours. For an optimal degree of the top coat is always advisable to apply a bottom intermediate between the zinc primer and the final coat.

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

¹ High humidity and high film thickness can cause a late hardening.

² Considering a dry film.

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