

323 PRIMER FOR METAL

Description	<p>Quick drying, alkyd-based, one component, anticorrosive primer for metals of industrial use. It contains special anticorrosive pigments of zinc phosphate and active zinc oxide. It doesn't contain lead or chrome substances. It shows great adhesion, flexibility and excellent anticorrosive protection. It is suitable for highly oxidative and corrosive conditions. It is certified by a European Institute for its anticorrosive-protective properties according to the standard ISO 12944.</p>														
Technical Information	<table border="0"> <tr> <td>Shade</td> <td>Black-Grey-Red oxide</td> </tr> <tr> <td>Gloss</td> <td>Mat</td> </tr> <tr> <td>Specific Weight</td> <td>1,45 (±0,05) kg/lit (EN ISO 2811)</td> </tr> <tr> <td>Theoretical coverage</td> <td>5,7 m²/kg (75µm),</td> </tr> <tr> <td>Solids</td> <td>77 % (± 2) by weight (EN ISO 3251, non-volatile) 62 % (± 2) per volume</td> </tr> <tr> <td>Temperature resistance</td> <td>Up to 80°C (service temperature)</td> </tr> <tr> <td>VOC</td> <td>Ready for use (+20% thinner): 495 g/lit EU LIMITS (2010): 500g/lit SUBCATEGORY: i one-pack performance coatings, primer coat for ferrous substrates, Type SB For professional use only.</td> </tr> </table>	Shade	Black-Grey-Red oxide	Gloss	Mat	Specific Weight	1,45 (±0,05) kg/lit (EN ISO 2811)	Theoretical coverage	5,7 m ² /kg (75µm),	Solids	77 % (± 2) by weight (EN ISO 3251, non-volatile) 62 % (± 2) per volume	Temperature resistance	Up to 80°C (service temperature)	VOC	Ready for use (+20% thinner): 495 g/lit EU LIMITS (2010): 500g/lit SUBCATEGORY: i one-pack performance coatings, primer coat for ferrous substrates, Type SB For professional use only.
Shade	Black-Grey-Red oxide														
Gloss	Mat														
Specific Weight	1,45 (±0,05) kg/lit (EN ISO 2811)														
Theoretical coverage	5,7 m ² /kg (75µm),														
Solids	77 % (± 2) by weight (EN ISO 3251, non-volatile) 62 % (± 2) per volume														
Temperature resistance	Up to 80°C (service temperature)														
VOC	Ready for use (+20% thinner): 495 g/lit EU LIMITS (2010): 500g/lit SUBCATEGORY: i one-pack performance coatings, primer coat for ferrous substrates, Type SB For professional use only.														
Drying Time 20 °C, 60% RH, 50 µm	<table border="0"> <tr> <td>Touch dry</td> <td>30 min</td> </tr> <tr> <td>Drying time</td> <td>4-6 hrs</td> </tr> <tr> <td>Recoating</td> <td>12 hrs</td> </tr> <tr> <td>Full drying</td> <td>24-48 hrs</td> </tr> <tr> <td>Oven force dry</td> <td>15-20 min / 60°C flash off time before oven: 5 min 25°C, 50 µm dft</td> </tr> </table> <p><i>(The above times are indicative and depend on the thinning percentage, relative humidity and temperature)</i></p>	Touch dry	30 min	Drying time	4-6 hrs	Recoating	12 hrs	Full drying	24-48 hrs	Oven force dry	15-20 min / 60°C flash off time before oven: 5 min 25°C, 50 µm dft				
Touch dry	30 min														
Drying time	4-6 hrs														
Recoating	12 hrs														
Full drying	24-48 hrs														
Oven force dry	15-20 min / 60°C flash off time before oven: 5 min 25°C, 50 µm dft														
Surface Preparation	<p>All applications on steel, including welding, cut with flame and smoothing, must be terminated before the preparation of the surface. All the remnants of the welding process must be removed. Cleaning of the surface from dust and other materials like oil, grease etc is necessary by using detergent and water. For better results, sandblast at least Sa 2 is recommended, according to ISO 8501-1 or for prolonged exposure of the surfaces, Sa 2 ½ with profile 30µm.</p>														
Application	<p>It is applied with: Brush or roller, after 10-20% thinning with thinner. Airless, (nozzle 0,019-0,023 in) after 10% thinning with thinner. Air pistol (diameter: 1,8–3,0 mm,) after 10-20% thinning of the product with thinner. It should not be recoated with two component paints.</p> <table border="0"> <tr> <td>Suggested layer thickness</td> <td>50-75 µm</td> </tr> <tr> <td>Application temperature</td> <td>10-40°C</td> </tr> <tr> <td>Suggested thinners</td> <td>1015-1119-1121-1120-601 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact with the technical department of our company</td> </tr> </table> <p>NOTE: When applicable, products primarily meant for use as primers may have slight color variations from batch to batch.</p>	Suggested layer thickness	50-75 µm	Application temperature	10-40°C	Suggested thinners	1015-1119-1121-1120-601 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact with the technical department of our company								
Suggested layer thickness	50-75 µm														
Application temperature	10-40°C														
Suggested thinners	1015-1119-1121-1120-601 The choice of suitable thinner depends on the application method, the temperature and the humidity conditions. For the suitable choice, please contact with the technical department of our company														
Storage	For 12 months in a dry and cool place. (5-30°C).														
Safety	Please consult the Material Safety Data Sheet. Available upon request.														

This Technical Data Sheet replaces and cancels every previously issued. The information, instructions, recommendations and specifications mentioned in this data sheet, represent the results and experience obtained from testing under controlled or specially adapted conditions. The accuracy and relevance of these results to the actual conditions, in which you apply the product, must be determined and depend only on the purchaser and/or applicator.