

323 PRIMER FOR METAL

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|---|--|---------------------------|----------------------|-------------------------|---------|--------------------|--|----------------------|--------------------------------|----------------|---|------------------------|----------------------------------|-----|---|
| Description | 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 shows great adhesion, flexibility and excellent anticorrosive protection. It is suitable for highly oxidative and corrosive conditions. | | | | | | | | | | | | | | |
| 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. |
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| 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 | | | | |
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| Surface Preparation | 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. | | | | | | | | | | | | | | |
| 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 | | | | | | | | |
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| 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.