

TECHNICAL DATA SHEET

HYDRO PRIMER 15

Waterbased rust-proof paint

DESCRIPTION	<p>Paint with a suitable rust inhibiting effect for preventing the corrosion of ferrous metal substrates and for its excellent adhesion is also suitable as an adhesion primer. It is characterized by high wetting of the substrate, excellent adhesion, hardness and flexibility, to withstand the natural stresses due to dimensional variations of the substrate under varying climatic conditions. Easy to apply, with excellent filling, spreading and covering, provides good grip to enamels and enhances their covering power. It is formulated based on modified epoxy-acrylic resins dispersed in water and ionic exchange pigments which have particularly good adhesion properties on metal and barrier effect so as to ensure good water-impermeability and an antioxidant effect. It is ideal for use immersion.</p> <p>The good coverage and low tendency to splash properties allow applications with manual or mechanical tools which guarantee a homogeneous film with both professional application both in the "do it yourself." It is characterized by fast drying which allows a rapid execution of the painting and resistance to overcoating even with solvent-based products that makes it a multipurpose product. It is also suitable as an adhesion primer for the successive layers of paint.</p> <p>Being odorless, it is particularly suitable for application in poorly ventilated areas. It is made with raw materials chosen for their low environmental impact, reduced pollution and minimum emissions, so as to preserve the health and safety of users and people living in the environment.</p>
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TYPICAL USE	<p>It is ideal for the protection of iron manufactures new or undergoing maintenance subjected to particularly corrosive agents such as structural work, fixtures, railings, tanks or agricultural equipment in rural, marine and industrial. The thickness recommended for effective protection is established on the basis of the aggressiveness of the environment and should always be applied on perfectly clean surface.</p> <p>In the case in which the product has been stored at low temperatures it is recommended to take at least 15 ° C before proceeding to the application. The preheating of the product to about 30 ° C, gave good results by improving the coverage of the edges and avoiding sagging. The product is suitable for the forced drying tunnel and hot air at 35 ° / 50 ° C.</p>
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PROPERTIES OF THE PRODUCT	VALUE	METHOD
Working temperature	< +80 °C	
Solids by volume	50% ±2	
VOC	<50 g/l	
Gloss level 60°	10-15	Internal PF2
SPECIFICATION DATA	VALUE	METHOD
Specific weight	1130-1250 g/l	Internal PF3
Drying Time	Overcoatable 8h Fully 8 h	Internal PF2

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THICKNESS AND COVERAGE		Minimum	Maximum	Recommended
	Thickness of dry film, μm	40	100	60
	Thickness of wet film, μm	80	200	120
	Theoretical coverage, m^2/l	12,5	5	7.1
	Theoretical coverage, m^2/kg	10,5	4,2	6

SHELF LIFE 6 months in its original and unopened can at a temperature from +5°C and +30°C.

COLOUR RANGE The range of colours can be chosen in shades of RAL. Between one production and the other, tint may be slightly different, it is therefore important to finish the job with the same batch.

SURFACE PREPARATION

General considerations The better the degree of preparation, the better the corrosion performance; on surfaces with poor preparation we recommend applying the first layer with a brush produced slightly diluted to facilitate wetting and penetration of the product in order to promote better adhesion.

New steel
 The surface must be clean and dry, free of grease oils and other contaminants. The Sa2,5 blasting ensures the best anticorrosive performance.

Surfaces treated with shop primer
 If intact, clean and free from dirt, oil, grease, salts and dry can be overcoated otherwise perform the preparation as for coated surfaces.

Coated surfaces
With primer: if clean and free of dirt, oil, grease, salts and dry, and recoated part in a maximum of the primer coating can be over applied. If cleaning is necessary, perform high-pressure washing Wa 2 (surface free of oil, grease, salt, dirt).
With complete coating: if undamaged compatible and non-chalky perform cleaning oil and grease with detergent, then perform surface sanding followed by pressure washer to remove dirt and salts.
Rusty coating: perform mechanical preparation St2 or St3 followed by a pressure washer to remove oil, grease, dust and salts or sandblasting Sa2 or Sa2,5;
Localized maintenance: perform mechanical preparation St2 or St3 followed by a pressure washer to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2,5. Round off the edges of the paint well stuck and restore the system in the original layers and thicknesses.

TOOLS Roller, airless or conventional Spray, Brush

APPLICATION

Thinning 0-10% with water
 Application conditions +10°C +40°C
 >3°C to dew point
 relative humidity: < 70%
 Airless application method Nozzle pressure: 15 MPa (150 kp/cm², 2100 psi).
 Nozzle: 0,43 - 0,58 mm (0,017 - 0,023")

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		Angle range; 40 - 80° Air pressure: compression ratio 45:1 (pressure 150-180 kg/cm ²) Water		
	Thinner for washing			
DRYING TIME	The data supplied must be considered merely indicative. The actual drying time can be shorter or longer, taking account of film thickness, ventilation, humidity.			
TOOLS	Surface temperature	23 °C		
	Out touch	1h		
	Dry to touch	4h		
	Full catalysis	8h		
	Minimum time of over application	4-6h		
RECOMMENDED FINISHINGS	Water-based acrylic enamels Hydroacryl; alkyd Hydro RE			
RECOMMENDED SYSTEM	Urban, industrial and marine atmosphere			
	Product	coats	Wet thickness	Dry thickness
	Hydro Primer 15	1	140	70
	Hydro Primer 15	1	140	70
	Hydro RE 30	1	100	50
	Total	3	380	190
POSSIBLE SYSTEM	Product	coats	Wet thickness	Dry thickness
	Hydro Primer 15	1	140	70
	Hydro RE 30	1	100	50
	Total	2	240	120
INSTRUCTIONS	<p>To carry out the work in a proper way, it is needed to strictly follow the instructions for the preparation of the surfaces contained in the CAP Arreghini Books. The specification data and technical information have been calculated at +23 °C with relative ambient humidity of 65%. In different conditions the data and the time intervals between the two phases of the above reported coating system may vary.</p> <p>This technical information is intended as a rough guide. However, because of the enormous variety of media and application conditions, it is essential to check the suitability of the product and test the effectiveness on a sample.</p>			