TECHNICAL DATA SHEET

HYDRO PRIMER 15
Waterbased rust-proof paint

DESCRIPTION

Painting with anti-rust effect, suitable to prevent the corrosion of ferrous metal supports and for its excellent adhesion; moreover, it is adequate as an adhesion primer on different metals (galvanised steel and aluminium). Characterised by an optimal wetting of the substrate, an excellent adhesion, hardness and flexibility, it resists unaltered to natural solicitations caused by dimensional variation of the support to vary climatic conditions. Easy to apply, equipped with filling power, slackening and coverage, it offers a sturdy enamel anchorage and it enhances covering power. It is formulated with modified acrylic resins dispersed in water and zinc phosphates which guarantee an optimal metal adhesion and a barrier effect in order to assure good water resistance and antioxidant effect. It is ideal for submersible use. It is characterised by quick drying which allows a rapid painting execution and resistance to over-coating, even with solvent-based products that make it multi-use product. Furthermore, it is suitable as adhesion primer for next layers of varnish. Being odourless, it is particularly indicated for applications in low aerated environments. It is realized with selected raw materials for a low environmental impact, with reduced pollution and minimum emissions in order to preserve the wellbeing and the safety of users and inhabitants.

TYPICAL USE

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.
Suitable as adhesion primer on materials which offer low grip as galvanized steel, alloys, aluminium, plastic and fiberglass.
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.

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
Drying Time	Overcoatable 8h Fully 5 days	Internal PF2

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SPECIFICATION DATA		VALUE	METHOD
	Specific weight	1100-1250 g/l	Internal PF3

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.

Galvanised steel
It is important to remember that the galvanised sheet metal should be passivated, letting artefacts exposed to atmospheric agents for at least two or three months; go ahead with a light sanding to eliminate formed surface oxidative coat and degrease surfaces with Nitro NV 5000 thinner.
Alternatively, it is recommended a light siliceous sanding.

Aluminium and light alloys
Realize a light sanding with abrasive paper P180-P220. Clean carefully the surface to be treated with Nitro NV 5000 thinner and ensure that the surface is dry and free of silicone, waxes, greases and extraneous substances.

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, dry 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, dry 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).

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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") Angle range; 40 - 80° Air pressure: compression ratio 45:1 (pressure 150-180 kg/cm²)
Thinner for washing	Water

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	8h
Full catalysis	5 days
Minimum time of over application	8h

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

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INSTRUCTIONS

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.

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.

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