

HYDRO PRIMER 40

Waterbased epoxy primer

FEATURES Two-component epoxy primer with a high content of active pigments. It is characterized by a high adhesion and excellent anti-corrosive properties. Suitable for spot welding of joints or for the repair of damages suffered by epoxy coating during construction. It can be covered with epoxy or polyurethane coating, water-based or solvent-based, and two-component also. It can also be covered with products based on chlorinated rubber, vinyl, acrylic and epoxy-tar.

USE Particularly suitable for the protection of stainless steel surfaces, light alloys, fiberglass, galvanized sheets; It can be used as a primer or intermediate both on new surfaces in maintenance allowing to realize protective systems in a simple way. Suitable for spot welding of joints or for the repair of damages suffered by epoxy coating during handling. It can be applied directly on an organic zinc.

PROPERTY OF THE PRODUCT	VALUE	METHOD
Specific weight (A+B)	1250-1350 g/l	
Working temperature	<+120 °C	
Solids by volume (A+B)	50% ±2	
VOC	<50 g/l	
Gloss level 60°	10-15	

SPECIFICATION DATA	VALUE	METHOD
Specific weight	1200-1340 g/l	Internal PF3
Pot-life	Max 3 h	Internal PF7
Drying Time	Fully 48 h	Internal PF2

THICKNESS AND COVERAGE	Minimum	Maximum	Recommended
Thickness of dry film, µm	40	100	60
Thickness of wet film, µm	80	200	120
Theoretical coverage, m²/l	12,2	5	8,3
Theoretical coverage, m²/Kg	9,4	3,9	6,4

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

COLOUR RANGE RAL 7035. 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 The treatment of the surface to be coated is of primary importance and affects the performance of the coating cycle.
A good and correct preparation of the substrate is a guarantee of quality on the duration of the coating: a high quality product applied on a poor substrate or on substrate inadequately treated is destined to an early wear, characterized by possible alteration of the coating itself.

HOT GALVANIZED STEEL

It is important to remember that the galvanized sheet must be passivated leaving the products exposed to atmospheric agents for at least two months; then proceed with a light sanding to remove the superficial oxidation patina formed and degrease

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the surfaces with Nitro NV 5000 thinner.
Alternatively, a light silica sandblasting is recommended.

ALUMINUM AND LIGHT ALLOYS

Perform a light sanding with P180 P220 sanding paper. Clean the surface to be treated with Nitro NV 5000 thinner and make sure it is dry and free from silicone, waxes, greases and foreign substances in general.

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

Mixing ratio in weight	100:20 with Induratore Hydro Primer Epox
Mixing ratio in volume	100:25 with Induratore Hydro Primer Epox
Thinning	Ready to use
Using time	Max 3 h
Application conditions	+10°C +40°C >3°C to dew point Relative humidity:<70%
Airless application method	Nozzle pressure:15 MPa (150 kp/cm ² , 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/cm ²)
Thinner for washing	Water

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DRYING TIME The given data must be considered purely indicative. The actual drying time may be taking account of the film thickness, ventilation, humidity. The complete curing temperatures 10 ° C. There are no maximum time limits of overpainting, however obtained when the application of the subsequent coat is performed before the full curing

DTF 60 micron				
Surface temperature	10°C	23°C	35°C	Oven 60°C
Out touch	60'	45'	30'	
Dry to touch	5h	2h	1,5h	
Full catalysis	72h	48h	18h	45'
Minimum time of over application	5h	2h	1,5h	
Maximum time of over application	6 days	5 days	3 days	

RECOMMENDED FINISHINGS Polyurethane, Epoxy, Chlorinated rubber, Vinyl

RECOMMENDED SYSTEM Urban, industrial and marine atmosphere

Product	coats	Wet thickness	Dry thickness
Hydro Primer 40	1	160	80
Hydro Primer 40	1	160	80
Hydro Epox 60	1	120	60
Total	3	440	220

Product	coats	Wet thickness	Dry thickness
Hydro Primer 40	1	200	100
Hydro Pur 70	1	120	60
Total	2	320	160

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.