ARREGHINI®
ITALIAN PAINTS SINCE 1950

INDUSTRIAL coating

TECHNICAL DATA SHEET

HYDRO PRIMER 46

Waterbased polyacrylic primer

FEATURES

Two-component primer based on hydroxylated acrylic resins in water emulsion with a high content of active pigments. It is characterised by high adhesion and excellent anti-corrosive properties. It can be coated with both water- and solvent-based epoxy or polyurethane coatings. It can also be coated with chlorinated rubber, vinyl and acrylic products.

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)	1200-1300 g/l	Internal PF7
Working temperature	<+120 °C	
Solids by volume (A+B)	50% ± 2	
Gloss level 60°	10-15	Internal PF6
Drying Time	To touch 1.5 h Recoatable 2h Fully 5 days	Internal PF2
Pot-life	2 h	Interno PF7

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1270-1370 g/l	Internal PF3

THICKNESS AND COVERAGE

	Minimum	Maximum	Recommended
Thickness of dry film µm	50	75	63
Thickness of wet film µm	100	150	125
Theoretical coverage (m^2/l)	10	6,7	8
Theoretical coverage m^2/kg	8	5.4	6,4

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

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.

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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.

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 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.

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).
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

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APPLICATION	Mixing ratio in weight	100:15 with Induritore Hydro Pur
	Mixing ratio in volume	100:20 with Induritore Hydro Pur
	Thinning	0-10% with water
	Using time	2 h
	Application conditions	+10°C +35°C, >3°C at 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 (pressione 150-180 kg/cm^2)
	Conventional spray application method	Nozzle:1,8 – 2 mm Fan angle; 30 - 50° Air pressure: 3,5-4 kg/cm^2
	Thinner for washing	Water

DRYING TIME

The given data must be considered purely indicative. The actual drying time may be shorter or longer, taking account of the film thickness, ventilation, humidity. The complete catalysis curing takes place at temperatures >10°C. There are no maximum time limits of overpainting, however the best adhesion is obtained when the application of the subsequent coat is performed before the full curing time.

DTF 50 micron	
Surface temperature	23°C
Out touch	1h
Dry to touch	1,5h
Full catalysis	5 days
Minimum time of over application	2h
Maximum time of over application	5 days

RECOMMENDED FINISHINGS

Polyurethane, Epoxy, Chlorinated rubber, Vinyl

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RECOMMENDED SYSTEM

Urban, industrial and marine atmosphere

Product	coats	Wet thickness	Dry thickness
Hydro Primer 46	1	125	63
Hydro PUR 70	1	125	63
total	2	250	126

POSSIBLE SYSTEM

Product	coats	Wet thickness	Dry thickness
Hydro Primer 46	1	125	63
Hydro Pur 72	1	120	60
totale	2	245	123

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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