

TECHNICAL DATA SHEET

HYDRO PRIMER FINISH 5

Waterbased undercoat finishing

FEATURES

Monocomponent matt paint air-drying, such as to prevent the corrosion of metal supports. Characterized by excellent substrate wetting, flexibility and excellent adhesion on different metals including galvanized steel and aluminum. It's based on epoxy-modified acrylic resins dispersed in water and anticorrosive pigments that perform a barrier effect so as to ensure good water resistance and antioxidant characteristics. It's characterized by fast drying which enables rapid execution of the painting. Being odorless is particularly suitable for applications in poorly ventilated rooms. It is made with raw materials selected for low environmental impact, with reduced pollution and with minimum emissions. It's suitable for use with immersion and its resistance to overcoating with solvent-based products makes it a multipurpose product.

USE

It's ideal for protection of iron artifacts, new or undergoing maintenance, such as carpentry, doors, railings, tanks, agricultural equipment in rural atmosphere, marina and industrial. The recommended thickness for good protection is to be determined depending on the aggressiveness of the environment. In the event that the product has been stored at low temperatures, it is advisable to bring it up to at least 15° C before applying. The preheating of the product at 30° C gave good results by improving the coverage of edges and avoiding sagging. The product is suitable for forced drying tunnels and hot air at 35°/50° C.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Working temperature	< +80° C	
Solids by volume	50% ± 2	
Gloss level 60°	15-20	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1000-1200 g/l	Internal PF3
Gloss	15-25	Internal PF6
Drying Time	Recoatible 5h Fully dry 5 days	Internal PF2

THICKNESS AND COVERAGE

	Minimum	Maximum	Recommended
Thickness of dry film, µm	40	100	70
Thickness of wet film, µm	80	200	140
Theoretical coverage, m²/l	12,5	5	7.1
Theoretical coverage, m²/kg	11.4	4.6	6.5

SHELF LIFE

1 year 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.

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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.

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 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.

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TOOLS

Roller, airless or conventional Spray, Brush

APPLICATION

Thinning 0-10% with water
 Application conditions +10°C +40°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
 (pressure 150-180 kg/cm²)
 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.

DTF 70 micron

Surface temperature	23°C	50°C
Out touch	90'	30'
Dry to touch	5h	3h
Full catalysis	5 days	4 days
Minimum time of over application	5h	3h

RECOMMENDED FINISHINGS

Acrylic waterbased enamels Hydroacryl; alkyd Hydro RE

RECOMMENDED SYSTEM

Product	coats	Wet thickness	Dry thickness
Hydro Primer Finish5	1	140	70
Hydro Primer Finish 5	1	140	70
Hydro RE 30	1	100	50
Total	3	380	190

POSSIBLE SYSTEM

Product	coats	Wet thickness	Dry thickness
Hydro Primer Finish 5	1	140	70
Hydro Primer Finish 5	1	140	70
Total	2	280	140

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.