

PRODUCT DATA SHEET

PRIMER 15
Fast drying anti-corrosion undercoat

CHARACTERISTIC Paint with rust inhibiting effect ideal for preventing the corrosion of ferrous metal surfaces in interior and exterior. Its main features are the high penetration of the substrate, excellent adhesion, flexibility. It provides good grip to topcoats. It is formulated based on alkyd resins with phenolic modification, in the solvent phase, ionic exchange pigments and zinc phosphate which have particularly good adhesion properties on metal and barrier effect so as to ensure high impermeability to water and an antioxidant effect; It is characterized by fast drying and resistance to the subsequent quick-drying enamels and alkyd enamels, nitrosynthetic enamels and polyurethane enamels.

USE It is ideal for the protection of steel manufactures, new or undergoing maintenance, such as carpentry, fixtures, railings, barges, tanks, agricultural equipment, industrial body, subjected to the action of corrosive agents in rural, urban, industrial environments. The thickness recommended for effective protection is established depending on the aggressiveness of the environment. The preheating of the product to about 30 °C gave good results by improving the drying, the coverage of the edges and allowing application of greater thickness for single layer. Sanding dust and / or spraying and dry paint residue should not be accumulated since they can cause spontaneous combustion.

PROPERTY OF THE PRODUCT

| | VALUE | METHOD |
|-------------------------|-----------------------------|-----------------|
| Application temperature | <+120 °C | |
| Flash point | 27°C | |
| Solid by volume | 60% ± 2 | |
| VOC | 425 g/l | |
| Brilliance 60° | <15 | |
| adherence: ISO 2409- | 0 | UNI EN ISO 2409 |
| impact resistance: | greater 1 Kg/20 cm | |
| bending resistance: | unchanged with spindle 10mm | UNI EN ISO 1519 |

SPECIFICATION DATA

| | VALUE | METHOD |
|---------------------|---------------|---------------|
| Specific weight | 1300-1450 g/l | Internal PF3 |
| Brilliance 60°Gloss | <15 | Internal PF6 |
| Drying Time | 0 | Internal PF2 |

THICKNESS AND YIELD

| | Min. | Max | Recommended |
|----------------------------|------|-----|-------------|
| Thickness of dry film (µm) | 40 | 120 | 60 |
| Thickness of wet film (µm) | 67 | 200 | 100 |
| Theoretical yield (m²/l) | 14,9 | 5 | 10 |
| Theoretical yield (m²/kg) | 10,6 | 3,6 | 7,1 |

STORAGE

Product is stable till one year as long as it is kept in original and unopened buckets

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| | | |
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| | at temperature between +5°C e +30°C. | |
| COLOUR | The range of colors 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. | |
| PREPARATION OF SURFACE | <p>General observation: Surface must be dry and clean from any kind of oil, grease and salts.</p> <p>New steel The surface must be clean and dry, free of oils and other contaminants. Sandblasting Sa2,5 ensures the best performance corrosion.</p> <p>Surfaces treated with shop primer If undamaged, clean and free from any dirt, oil, grease, salts and dry, it can be painted otherwise perform the preparation as for coated surfaces.</p> <p>Coated surface <i>With primer:</i> it can be painted if the substrate is clean and free of dirt, oil, grease, and the application falls within the maximum re-coat time of the primer. If cleaning is required, perform pressure washing grade Wa 2 (surface free of oil, grease, salt, dirt). <i>With complete finishing coat:</i> if undamaged compatible and non-chalky perform cleaning from any oil and grease with detergent, then run sanding surface followed by pressure washing to remove dust and salts. <i>Rusty coating:</i> perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½; then restore the thickness of primer. <i>Localized maintenance:</i> perform mechanical preparation St2 or St3 followed by pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½. Round off the edges of the well anchored painting and restore the system in the original layers and thicknesses.</p> | |
| TOOLS | Conventional or airless spray: Nitro NV 5000 (with high temperature and humidity <40% it is possible the formation of "dusting"); in this case use Diluente fast drying, roller, brush with Diluente S800. | |
| APPLICATION | Thinning Application condition Application by airless Application by conventional spray Thinner for washing | 5-10% with Diluente Nitro NV5000 +5°C +40°C >3°C at dew point Relative humidity: <70% Nozzle pressure: 15 MPa (150 kp/cm², 2100 psi.). Nozzle: 0,28 - 0,38 mm (0,011 - 0,018") Angle range: 40 - 80° Air pressure: Compression ratio 30:1 (pressure 150-180 kg/cm²) Nozzle: 1,6 – 1,8 mm Angle range: 40 - 80° Air pressure: 3,5-4 kg/cm² Nitro NV5000 |
| DRYING TIME | Dry time are purely indicative as it might be longer or shorter by keeping in consideration ventilation, humidity, thickness of the applied film. High thicknesses | |

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per coat and unfavorable environmental conditions slow down the drying and hardening depth.

| | | |
|----------------------------------|------|------|
| DTF 50 micron | | |
| Surface temperature | 10°C | 23°C |
| Out touch | 45' | 15' |
| Dry touch | 3h | 45 |
| Full | 24h | 12h |
| Minimum time of over application | 90' | 45'' |

RECOMMENDED FINISHES

Fast drying enamels: Supersinteol Rapido Industriale, RE30;
 Synthetic enamels: Gladium, Eno, Sinto 26
 Micaceous iron enamels: FER RE GG16, FER ZN GG13.
 Nitro-synthetic enamels: Nitrolux 20

RECOMMENDED SYSTEM

Rural atmosphere

| Product | Coat | Wet Thickness | Dry thickness |
|-----------|------|---------------|---------------|
| Primer 15 | 1 | 100 | 60 |
| Primer 15 | 1 | 100 | 60 |
| RE 30 | 1 | 90 | 50 |
| Total | 3 | 290 | 170 |

ALTERNATIVE SYSTEM

| Product | Coat | Wet Thickness | Dry thickness |
|--------------|------|---------------|---------------|
| Primer 15 | 1 | 125 | 75 |
| Fer RE GG 16 | 1 | 90 | 50 |
| Total | 2 | 215 | 125 |

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.