

## PRODUCT DATA SHEET

**PRIMER 39**
**Epoxy primer**

**PRODUCT DESCRIPTION** Dual-component epoxy-polyamide primer zinc phosphate. It is characterized by high adhesion and excellent anti-corrosion properties. Long recoating intervals are possible with epoxy or polyurethane.

**RECOMMENDED USE** Ideal for the protection of stainless steel surfaces, light alloys, fiberglass, galvanized sheets; It can be used as primer or intermediate both on new surfaces and in maintenance allowing to realize protective systems in a simple way. Suitable for retouches on welded joints or to repair damage from the epoxy coating during handling. It can be applied directly on zinc organic.

**PROPERTY OF THE PRODUCT**

|                         | VALUE         | METHOD |
|-------------------------|---------------|--------|
| Specific weight (A+B)   | 1150-1250 g/l |        |
| Application temperature | < +120 °C     |        |
| Flash point             | 31°C          |        |
| Solids (vol%)           | 55 ± 2%       |        |
| VOC                     | 450 g/l       |        |
| Gloss 60°               | 10-15         |        |

**SPECIFICATION DATA**

|                 | VALUE         | METHOD       |
|-----------------|---------------|--------------|
| Specific weight | 1250-1350 g/l | Internal PF3 |
| Drying Time     | Fully 24 h    | Internal PF2 |

**FILM THICKNESS AND SPREADING RATE**

|                                                | Minimum | Maximum | Typical |
|------------------------------------------------|---------|---------|---------|
| Film thickness, dry, µm                        | 40      | 100     | 60      |
| Film thickness, wet, µm                        | 73      | 182     | 109     |
| Theoretical spreading rate, m <sup>2</sup> /l  | 13,7    | 5,5     | 9       |
| Theoretical spreading rate, m <sup>2</sup> /kg | 11,4    | 4,6     | 7,7     |

**STORAGE** Product is stable till one year as long as it is kept in original and unopened buckets at temperature between +5°C e +30°C.

**COLOUR** Grey RAL 7035. 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.

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

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**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 oils and other contaminants. Sandblasting Sa2,5 ensures the best anti-corrosion performance.

**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.

**COATED SURFACE**

With primer: 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).

**With complete finishing coat:** 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.

**Rusty coating:** 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.

**Localized maintenance:** 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.

## APPLICATION METHODS

Conventional spray, airless, roller, brush.

## APPLICATION DATA

|                              |                                                                                                                                                                                                                   |
|------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| Mixing ratio (weight)        | 100:20 with Induritore Multiepox                                                                                                                                                                                  |
| Mixing ratio (volume)        | 100:30 with Induritore Multiepox                                                                                                                                                                                  |
| Thinner                      | 0-5% with Diluente S800                                                                                                                                                                                           |
| Pot life                     | 4-5 h                                                                                                                                                                                                             |
| Condition during application | +5°C +40°C<br>> 3°C at dew point<br>Relative humidity:<70%                                                                                                                                                        |
| Guiding data airless spray   | Pressure at nozzle:15 MPa (150 kp/cm <sup>2</sup> , 2100 psi).<br>Nozzle: 0,43 - 0,58 mm (0,017 - 0,023")<br>Spray angle: 40 - 80°<br>Air pressure: compression ratio 45:1 (pressure 150-180 kg/cm <sup>2</sup> ) |
| Cleaner                      | Diluente Nitro NV 5000                                                                                                                                                                                            |

## 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. The complete curing takes place at temperatures >5 ° C; it is however possible to apply the

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product at even lower temperatures. In case of low temperatures, it is important to ensure the induction time indicated. There is no limit to the maximum time of over painting, however the best adhesion is achieved when applying the next coat before the time of complete curing.

|                        |     |      |      |      |
|------------------------|-----|------|------|------|
| DTF 60 micron          |     |      |      |      |
| Substrate temperature  | 5°C | 10°C | 23°C | 30°C |
| Surface dry            | 10h | 60'  | 45'  | 30'  |
| Through dry            | 8h  | 3h   | 2h   | 1h   |
| Cured                  | 3gg | 48h  | 24h  | 18h  |
| Dry to recoat, minimum | 8h  | 3h   | 2h   | 1h   |
| Dry to recoat, maximum | nn  | nn   | nn   | nn   |

 RECOMMENDED  
 TOPCOAT

Polyurethane, epoxy, vinyl, chlorinated rubber.

## TYPICAL PAINT SYSTEM

Industrial and marine atmosphere

| Product       | Layers   | Film thickness wet | Film thickness dry |
|---------------|----------|--------------------|--------------------|
| Epox zinc 2K  | 1        | 90                 | 60                 |
| Primer 39     | 1        | 109                | 60                 |
| Pur TOP 52 HS | 1        | 100                | 60                 |
| <b>Totale</b> | <b>3</b> | <b>299</b>         | <b>120</b>         |

 ALTERNATIVE PAINT  
 SYSTEM

| Product       | Layers   | Film thickness wet | Film thickness dry |
|---------------|----------|--------------------|--------------------|
| Primer 39     | 1        | 109                | 60                 |
| Pur Car 51 HS | 1        | 100                | 60                 |
| <b>Totale</b> | <b>2</b> | <b>209</b>         | <b>120</b>         |

## 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.