

PRODUCT DATA SHEET

PRIMER 40 HS ST
High solids epoxy primer

CHARACTERISTIC Dual-component epoxy primer/intermediate with high anti-corrosion and mechanical performance. Suitable for surfaces submerged periodic or exposed. The product can be used with Induratore Multiepoxy HS and Induratore Multiepoxy IN (during the winter season) to meet applications at high and low temperatures. Being a high solids ensures limited emissions into the atmosphere. Long intervals in recoating are possible with epoxy or polyurethane coating. It can also be covered with chlorinated rubber, vinyl, acrylic products.

USE It can be used as primer or intermediate both on new surfaces and in maintenance allowing to realize protective systems in a simple way. The product is suitable for applications on building sites with rapid handling. It can be applied directly on organic zinc.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Specific weight (A+B)	1300-1400 g/l	
Application temperature	< +120 °C	
Flash point	31°C	
Solid by volume (A+B)	80 ± 2%	
Brilliance	(6 <5	
VOC, point 9.2 safety data sheet, revision 2, color Ral 7038	Max 250 g/l	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1350-1450 g/l	Internal PF3
Pot-life	Max 2h	Internal PF7
Drying Time	To touch 2,5 h	Internal PF2

THICKNESS AND YIELD

	Min.	Max	Recommended
Thickness of dry film, µm	80	200	160
Thickness of wet film, µm	100	250	200
Theoretical yield, m²/l	10	4	5
Theoretical yield, m²/Kg	7.4	3	3,7

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 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 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 .

GENERAL CONSIDERATIONS

On surfaces with poor preparation, we recommend the application of the first layer by brush with product slightly diluted to facilitate wetting and penetration of the product in order to promote better adhesion.

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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.

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.

TOOLS

Conventional spray, airless, roller, brush.

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APPLICATION	Mix ratio in weight	100:11 with Induritore Multiepoxy HS 100:10 with Induritore Multiepoxy IN 100:10 with Induritore Multiepoxy Speed
	Mix ratio in volume	100:15,5 with Induritore Multiepoxy HS 100:14 with Induritore Multiepoxy IN 100:14 with Induritore Multiepoxy Speed
	Thinning	0-5% with thinner Diluente S800
	Induction time	10' with temperature <10°C
	Time of use	Max 2h at 25°C Max 3h at 20°C
	Application condition	-5°C +40°C >3°C at dew point Relative humidity: <70%
	Application by airless	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	Thinner 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 product at even lower temperatures. In case of low temperatures, it is important to ensure the induction time indicated. In case of high temperatures, apply the product immediately. 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 125 micron by Induritore Multiepoxy IN o HS

Surface temperature	23°C
Out touch	30 minutes
Dry touch	2.5h
Full catalysis	6 days
Minimum time of over application	4.5h

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RECOMMENDED FINISHES Epoxy, polyurethane

RECOMMENDED SYSTEM Marine and industrial atmosphere C5 high

Product	Coat	Wet Thickness	Dry thickness
Epoxy zinc 2K	1	80	60
Primer 40 HS ST	1	250	200
Pur 55	1	100	60
Total	3	430	320
Epoxy zinc 2K	1	80	60
Primer 40 HS ST	1	200	140
Primer 40 HS ST	1	200	140
Pur 55	1	100	60
Total	4	580	400

ALTERNATIVE SYSTEM

Product	Coat	Wet Thickness	Dry thickness
Primer 40 HS ST	1	200	140
Pur 55	1	100	60
Total	2	300	200

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.