TECHNICAL DATA SHEET

PRIMER 45
Epoxy vinyl primer

FEATURES

Dual-component primer modified with epoxy and vinyl resins with zinc phosphate. It ensures maximum grip even on non-ferrous metals and provides excellent anti-corrosive properties. Recoating intervals are possible with no time limit with epossidci or polyurethane coatings. It can also be overcoated with products, chlorinated rubber, vinyl, acrylic.

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 zinc rich organic.

PROPERTY OF THE PRODUCT

	VALUE	METHOD
Specific weight (A+B)	1250-1350 g/l	
Working temperature	< +120°C	
Flash point	31°C	
Solid by volume (A+B)	55 ± 2%	
Gloss level 60°	10-15	

SPECIFICATION DATA

	VALUE	METHOD
Specific weight	1300-1400 g/l	Internal PF3
Pot-life	Max 5 h	Internal PF7
Drying Time	Fully 24 h	Internal PF2

THICKNESS AND COVERAGE

	Minimum	Maximum	Recommended
Thickness of dry film µm	40	100	60
Thickness of wet film µm	73	182	109
Theoretical coverage (m²/l)	13,7	5,5	9,2
Theoretical coverage (m²/kg)	10,5	4,2	7,1

SHELF LIFE

1 year in its original and unopened can at a temperature from +5°C and +30°C.

COLOUR RANGE

Grey RAL 7035. 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.

GENERAL CONSIDERATIONS
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

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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 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 pressure washing to remove oil, grease, dust and salt or sand blasting Sa2 or Sa2½; then restore the thickness of primer.
Localized maintenance: remove all contaminants and run a preparation as rusty coating. Round off the edges of the well anchored painting and restore the system in the original layers and thicknesses.

TOOLS: Conventional and airless spray, roller, brush

APPLICATION

Mixing ratio in weight	100 Primer 45-20 Induritore Multiepox
Mixing ratio in volume	100 Primer 45-30 Induritore Multiepox
Thinning	0-5% con Diluente S800
Use time	Max 5 h
Application condition	+5°C +40°C, > 3°C to dew point Relayive 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/cm^2)
Thinner for washing	Thinner Nitro NV 5000

DRYING TIME: The given data must be considered as guidelines. The actual drying time may be shorter or longer, taking account of the film thickness, ventilation, humidity. Full curing takes place at temperatures 5 ° C; it is still possible to apply the product even at temperatures below: 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.

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DTF 60 micron

	5°C	10°C	23°C	30°C
Surface temperature				
Out touch	10h	60’	45’	30’
Dry to touch	8h	3h	2h	1h
Complete catalysis	3gg	48h	24h	18h
Minimum time of overcoating	8h	3h	2h	1h

RECOMMENDED FINISHINGS

Polyurethane, Epoxy, Chlorinated rubber, Vinyl

RECOMMENDED SYSTEMS

C4 industrial and marine atmosphere

Product	Coats	Wet thickness	Dry thickness
Epox zinc 2K	1	90	60
Primer 45	1	109	60
Pur TOP 52 HS-PC	1	100	60
Total	3	299	180

POSSIBLE SYSTEMS

Product	Coats	Wet thickness	Dry thickness
Primer 45	1	145	80
Pur Car 51 HS-PC	1	100	60
Total	2	245	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.

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