

SCHEDA TECNICA

VEREPOS PRIMER

SERIE. 35000341

○ Polyamide Cured Epoxy Primer

Description	General Purpose two component polyamide cured epoxy primer, pigmented with zinc phosphate and inert extenders
Use and principal characteristic	<ul style="list-style-type: none"> • Excellent rust inhibitive shop primer in corrosive environments • Form durable coating system with a range of topcoats for immersion and non-immersion services • Special primer for the aviation and aerospace industry • Good adhesion on properly treated galvanizes steel, cadmium plated steel, aluminium alloy, magnesium alloy • Good weather resistance including resistance to aggressive industrial and chemical contaminated atmospheres, to use on structural steel, machinery, pipes and tank, oil refineries, power plant, chemical process
Certificates/Approval	In accordance to the military specification Alenia n. 11 P236 P401
Resistance to	
Corrosion	Excellent
Dry heat	Up to 95°C/203°F
Flexibility	Good
Adesion resistance	Excellent
Abrasion resistance	Good
Basic data at 20°	
Colour and gloss	White - eggshell
Mass density	1,230 kg/l
Solids content by volume	approx. 41% by volume
Substrate	abrasive blasted steel. Galvanizes steel, cadmium plated steel, aluminium alloy, magnesium alloy
Number of components	2
Curing mechanism	chemical reaction between components
Number of coats	1 or 2 coats

VOC	470 g/kg (Directive 1999/13/EC)	
Calculated coverage	8,13 m ² /kg for 40 µm. The actual coverage will be less, depending on application technique, job conditions and type of surface to be coated	
Recommended dry film thickness	40 – 60 mm (application at 100 mm wet film thickness will normally provide 40 mm dry film)	
Application methods	Conventional spray, brush or roller	
Drying times		
Dry to touch	3 hours	
Dry to handle	4 hours	
Full cured after	7 days with good ventilation <i>Drying and curing times are dependent on air and steel temperature, applied film thickness, ventilation and other environmental conditions: Times are proportionally shorter at higher temperature and longer at lower temperatures:</i>	
Shelf life	24 months if protected against weathering and at a max.temperature of 40°C/104°F	
Flash point (DIN 53213)	Resin	21°C/70°F
	Hardener	32°C/90°F
	Thinner	25100200 28°C/136°F
Surface preparation and application condition	All surfaces to be coated must be clean, dry and free of rust, oils, dust, dirt, scale, shop primer, and other contaminants.	
Steel	Remove any oil or soap film with suitable oil cleaner, or lightly blast with fine grade of non-metallic abrasive: Blast pressure should be typically 30 p.s.i. At the nozzle and approximately 70 p.s.i. (5 at.) at the compressor. Average profiles 20-30 microns are ideal	
Newly Galvanised Surfaces	Blast cleaning to near-white in accordance with SSPC-SP 10 to a degree of cleanliness in accordance with NACE 2 or ISO Sa2 ½ to obtain blasting profile (Rz) 25 - 50 mm. Prime surfaces immediately after blast cleaning, and dust or sand removal by means of vacuum cleaning	
Weathered galvanised surfaces	If galvanised has been exposed to exterior weathering for 6 months or more, remove zinc corrosion products by mechanical means (like power sander). Remove oil or grease with oil cleaner	
Application conditions	Apply only on a dry and clean surface with a temperature above the dew point to avoid condensation. Use only where application and curing can proceed at temperatures above: 10°C/50°F. The temperature of paint itself should be 15°C/59°F or above. In-can temperature of the paint should preferable be below 25°C/77°F. Curing requires a relative humidity of: max 70% In confined spaces provide adequate ventilation curing application and dry	
Material preparation	Product is supplied in pre measured standard pails so that the right ratio is reached by mixing one pail of base product with one pail of cure. If smaller quantities are required, the ratio by weight is: Base product 100 p Cure 30 p Flush equipment with recommended cleaner before use. Stir each of the components prior to mixing to an even consistency with a power mixer. Add Hardener to resin, and continue stirring for a few minutes. Stir during application to maintain uniformity of material Thinner should be added after mixing component	

Introduction time	not applicable			
Pot Life a 20° C	10°C/50°F	8 hours	the figures are valid for quantities of approx.5 litres	
	15°C/59°F	6 hours		
	20°C/50°F	4 hours		
	25°C/77°F	2 hours		
	30°C/86°F	1 hours		
Environmental Conditions	During application and drying:			
	Air temperature	5 to 50°C		
	Surface temperature	5 to 60°C		
	<i>To prevent moisture condensation during application, surface temperature must be at least 3°C above dew point.</i>			
	<i>Minimum temperature for satisfactory cure is 10°C. Never apply coatings under adverse environmental conditions. Ensure good ventilation when applied in confined areas to assist evaporation of solvents.</i>			
Airless spray	Recommended thinner	cod. 25100200		
	Volume of thinner	5-10%		
	Nozzle orifice	1,5 - 2 mm		
	Nozzle pressure	0,3 MPa (approx. 3 at.-43 p.s.i.)		
Brush/Roller	<i>Use clean, short bristled brush or medium nap roller</i>			
	Recommended thinner	cod. 25100200		
	Volume of thinner	0 - 5%		
Cleaning solvent	cod. 25100200 (flash point 28°C/136°F)			
	<i>All application equipment must be cleaned immediately after use, and the paint inside the spraying equipment must be removed before the pot life time has been expired</i>			
Overcoating table for two pack epoxy-or polyurethane paint	Surface temperature	10°C (50°F)	20°C(68°F)	30°C(86°F)
	To recoat minimum	24 h	8 h	4 h
	To recoat maximum	6 months	6 months	6 months
	* NR = Not Recommended, Ext. = Extended, m= minute, h= hour, d= day * surface should be cleaned from chalking and contamination. When coating intervals are longer, abrade the coated surface before recoating			
Packaging	Base	cod. 35000341	25 Kg	
	Hardener	cod. 25120106	5 Kg	
	Thinner	cod. 25100200	25 - 5 lt	