IL FIORE DELLA PITTURA
vernital

# SCHEDA TECNICA

| VEREPOFEN PRIMER | COD. 35000704 |
|---|---|
| | o High-Build |

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|---|---|
| **Description** | Two component high-build amine cured phenolic epoxy primer |
| **Use and principal characteristic** | • good flow with low spray dust fall out<br>• excellent resistance to a wide range of organic acids, alcohols, edible fat (regardless of free acid content) and solvent<br>• good resistance to hot water<br>• prime coat in the Vernital Verepofen Finish tankcoating system<br>• good application properties, resulting in a smooth surface |
| **Resistance to** | |
| **Adhesion** | Very Good |
| **Flexibility** | Good |
| **Abrasion resistance** | Very good |
| **Basic data at 20°** | |
| **Colour and gloss** | Red oxide Ral 3009- eggshell |
| **Mass density** | 1,50 kg/l (mixed product) |
| **Solids content by volume** | 68% |
| **VOC** | 125 g/Kg |
| **Recommended dry film thickness** | 50-175 mm depending on system |
| **Number of coats** | 1 |
| **Coverage theoretical** | 6,0 m2/kg at 75 mm. The practical coverage will be less, depending on application technique, job conditions and type of surface to be coated |
| **Application methods** | airless; brush or roller for strip coat |
| **Set - to - touch** | 4 hours |
| **Read for handling** | 8 hours at 20°C - 4 hours at 30°C |
| **Readof overcoating** | min. 8 hours at 20°C; 5 hour at 30°C<br>max. 1 month |
| **Full cured** | 5 days with good ventilation |

**Note**

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:

**Shelf life**

Base: al least 24 months when stored cool and dry
Hardener: al least 24 months when stored cool and dry

**Mixing ratio (by volume)**

| | | |
|---|---|---|
| Resin | 35000704 | 100 part |
| Cure | 35120190 | 10 part |

**Flash point (DIN 53213)**

Resin 26°C, Cure 100°C, thinner 25100200 24°C

**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 -Dry abrasive blast cleaning to near-white in accordance with SSPC-SP 10 to a degree of cleanliness in accordance with NACE 2 or ISO Sa 2 ½ to obtain blasting profile (Rz) 50 - 100 mm.
Prime surfaces immediately after blast cleaning, and dust or sand removal by means of vacuum cleaning.

**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 volumet is:

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|---|---|
| Base product | 100 p. |
| Cure | 10 p. |

the temperature of the mixed base and cure should above 15°C, otherwise extra solvent may be required to obtain application viscosity
Flush equipment with recommended cleaner before use. Stir each of the components prior to mixing to an even consistency with a power mixer. Add cure to resin, and continue stirring for 10 minutes
Thinner should be added after mixing components

**Induction time**

| Allow minimum indication time before use | |
|---|---|
| 15°C | 15 min. |
| 20°C | 20 min. |

**Pot life at 20°**

After mixture, product must be used within 2 hours or 1 hour at 30°C. Afterwards it becomes thick and cannot be used any more hours and less at higher temperatures. Pot-life ends when coating loses body and begins to sag.

**Environment condition**

During application and drying:
Air temperature: 5 to 50°C
Surface temperature: 10 to 60°C
To prevent moisture condensation during application, surface temperature must be at least 3°C above dew point.

**Airless spray**

| | |
|---|---|
| Recommended thinner | 25100200 |
| Volume of thinner | 0-5% |
| Nozzle orifice | approx. 0,46 - 0,53 mm (0,018 - 0,021 inch) |
| Nozzle pressure | 15 MPa (approx. 150 at.-2100 p.s.i.) |

The product must be applied by means of airless equipment with compression ratio 45:1 or 60:1

**Air spray**

| | |
|---|---|
| Recommended thinner | 25100200 |
| Volume of thinner | 0-5% |
| Nozzle orifice | 2 mm |
| Nozzle pressure | 0,3 MPa (approx. 3 at.-43 p.s.i.) |

**Brush/Roller**

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|---|---|
| Use clean, short bristled brush or medium nap roller. For strip coating and spot repair only | |
| Recommended thinner | 25100200 |
| Volume of thinner | 0-5% |

**Cleaning Solvent**

25100200 (flash point 28°C)

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

**Additional Data**

**Film thickness and spreading rate**

| | | | | |
|---|---|---|---|---|
| Theoretical spreading ratio | m2/lt | 13,6 | 9 | 6,8 |
| Dft in µm | | 50 | 75 | 100 |
| max. dft without sagging with airless spray | | | | 200 µm |
| min. dft for closed film with airless spray | | | | 50 µm |
| max. dft when brushing | | | | 60 µm |

**Overcoating table for Verepofen Finish coating**

| substrate temperature | 10°C | 15°C | 20°C | 30°C | 40°C |
|---|---|---|---|---|---|
| minimum interval | 24 hours | 16 hours | 8 hours | 6 hours | 4 hours |
| maximum interval | 2 months | 2 months | 1 months | 1 months | 1 months |
| Surface should be cleaned from chalking and contamination | | | | | |

**Curing Table**

| substrate temperature | curing time |
|---|---|
| 10 C° | 10 days |
| 15 C° | 7 days |
| 20 C° | 5 days |
| 30 C° | 4 days |
| 40 C° | 3 days |
| Adequate ventilation is required during application and curing | |

**SAFETY PRECAUTIONS**

Caution

This product is flammable: Keep away from heat and open flame: Keep container closed: Use adequate ventilation: Avoid prolonged and repeated contact with skin. If used in confined areas. Observe the following precautions to prevent hazards of fire or explosion or damage to the health:

1. circulate adequate fresh air continuously during application and drying
2. use fresh air mask and explosion proof equipment;
3. prohibit all flames, sparks, welding and smoking