

Name **Primer 1K based on Alkyd & Vinylic Resin**  
Definition: **Vinyl primer**  
Code: **71.3.K1**

Category: **primer**  
V.O.C (ready to use): **640 g/l**  
Product outside the uses referred to 2004/42/CE

## **NATURE OF THE PRODUCT**

Anticorrosive primer based on alkyd and vinyl resins.

## **GENERAL USES**

General use primer, fit for steel structural works, industrial bodywork, agricultural machines, machines tools, furniture, etc.

## **APPLICATION METHOD**

### **PREPARATION OF SURFACES**

The cleaning of the application surface should be total and painstaking and it is a fundamental and necessary condition to obtain positive result of the painting cycle.

This means that the presence on the support of substances such as fats, oils, grease and dirt (and of course, for other reasons, rust and calamine) is absolutely not tolerated.

- **Ferrous surfaces.** SA 2½ grade sandblasting. Alternatively, perfect mechanical cleaning of the support by sanding with elimination of rust, calamine and subsequent cleaning by degreasing with aqueous solutions of surfactants or with organic solvents.
- **Aluminum:** Accurate sanding with scotch brite coarse grain, followed by degreasing using thinners.
- **Galvanized sheet.** Accurate sanding with scotch brite paper coarse grain, followed by degreasing using thinners.

### **PREPARATION OF THE PRODUCT**

Carefully mix until an even color and consistency are obtained. For airless applications no dilution or maximum 5% dilution. For standard airmix application dilute with our nitro anti-fog thinner (OG.001) or synthetic thinner (OG.005) thinner at 20% to obtain a viscosity of 25-30" Ford 4. For applications with dry film thickness lower than 30 µm, dilute between 20 and 40%<sup>1</sup>.

## **APPLICATION**

Spray gun:	nozzles of 1,4-1,7 mm diameter and 3-5 atm pressure.
Airless.	nozzle 0,09 inches, 180-240 bar
Brush/roller	Only for large surfaces

## **TECHNICAL DATA**

<b>PRODUCT TYPE:</b>	One-pack
<b>APPEARANCE (ASTM D 523):</b>	Matt (5 ±2 gloss)
<b>COLOURS:</b>	By request (by using the binder 71.3.K1 in a ratio of 85/15 with the tinting system tinters)
<b>SPECIFIC WEIGHT (ISO 2811):</b>	1,30 ± 0,08 kg/
<b>SUPPLY VISCOSITY(DIN 53211) :</b>	25" ± 5" Ford 8
<b>SOLID ON VOLUME:</b>	45% (± 2%)

<sup>1</sup> The VOC value indicated above is evaluated considering a dilution at 20%

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<b>SOLIDS CONTENT:</b>	60 % ( $\pm$ 3%)	
<b>DRYING AT 20°C</b>	Dust dry:	15-20 minutes
	Touch dry:	25-30 minutes
	Total hardening:	24 hours
	Forced drying <sup>2</sup> :	30 minutes at 60°C
	Maximum chemical resistance:	After 10 days
<b>RECOMMENDED COATS:</b>	One crossed coat	
<b>THICKNESS</b> <sup>3</sup> :	30-60 $\mu$ m	
<b>THEORETIC YIELD</b> <sup>4</sup> :	8-10 m <sup>2</sup> /kg	
<b>REPAINTING:</b>	After minimum 4 hours, or using a water base topcoat after 30-60 minutes. Over 48 hours it can be overcoated without sanding.	
<b>STORAGE STABILITY:</b>	One year, stored in closed packs, in a cool, dry place, away from any sources of heat. Keep from freezing, keep at temperatures > 5°C.	

<sup>2</sup> Baking the product can produce the popping effect, to avoid this is better a flash-off time of 5'-10' before put the paint to dry in the oven

<sup>3</sup> Considering a dry film.

<sup>4</sup> The theoretical yield has been calculated for the thickness suggested and over plane and regular surfaces for product ready to be used.