

1K Primer PF 02

Product Description

One component air drying alkyd product.

Use

For corrosion protection of both new and repaired old ferrous metal surfaces, which are not permanently exposed to aggressive environment and organic solvents.

In system with suitable finish coating, meets the requirements for C1 and C2 according to ISO 12944.

Properties

Good filling and protective properties.

Suitability for grinding.

Good storage behavior.

Colours

Grey; Oxide Red; Black; White

Technical properties

Technical properties	Test method	Values
Solid content	SR ISO 3251/2003	min 83%
Density	BNS EN ISO 2811-1	1,55±0,10g/cm ³
Flash point	ISO 2719:2016	36°C
VOC values	BNS EN ISO11890-1:2008	max 500g/l

Recommended thickness of layer

Dry film	40-50µm
Wet film	50-60µm
Theoretic consumption	100-150g/m ² , depending on the required thickness of dry film.

Substrates & Surface preparation

To achieve maximum adhesion and durability of the system, the surface preparation must comply with the following requirements:

Surface	Minimum	Recommended
Ferrous metals	Rust cleaning with sandblasting or blasting, up to Grade St2, according to ISO 8501-1	Rust cleaning with sandblasting or blasting, up to Grade Sa 2 ½, according to ISO 8501-1
	Cleaning, drying and no visible surface injuries according to ISO 12944-4 6.1	

Application equipment

By machine

Information on nozzles and pressure for machine application

Conventional Spray	nozzle - 1.8mm; pressure - 3-4atm;
Airless spray	nozzle - 0.013-1.015mm; pressure - 180-200bar;

Thinning and cleaning of tools

Air spraying - up to 10% c Thinner AMB;

Airless spraying - up to 5% with Thinner AMB;

Drying and curing schedule

Temperature	5°C	10°C	23°C	40°C
Surface drying	-	8 h	5 h	2-3 h
Fully drying	-	24 h	15 h	8-10 h

The times mentioned in the above table are measured in a laboratory environment at a controlled temperature and air humidity. Depending on different application environments these values may vary.

Surface dry - time necessary for touch dry

Applying a second layer - At temperatures above 15 ° C, the application of finishing coatings containing xylene or stronger solvents should be applied within a couple of hours after priming or after complete drying.

In case of application at lower temperatures, the overlapping should be carried out not earlier than 72 hours. Otherwise, poor adhesion and wrinkling of the top layer may occur due to the ongoing drying process of the bottom layer.

Product compatability

Depending on the specific need and the expected result, this product can be used in a system with different finish coatings (alkyd, alkyd-urethane).

For other types of coatings or special requirements, please contact us.

Packaging

	net weight	volume
Metal package	0,900kg ,25kg	0,550L ,15L

Depending on the color of the product and the individual requirement of the customer, the packages may vary.

Storage

The product should be stored in closed, dry and fire-proof warehouses and premises at a temperature of not more than 30 ° C. Do not expose to direct sunlight. Keep out of reach of children!

Shelf life:

18 months from production date in factory-sealed package.

Safety

According to safety data sheet (MSDS).



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