

METAL PRIMER

Series 0789

Universal, zinc-phosphate-based wash primer for metals and alloys



TECHNICAL FEATURES

Thin filming, semi-covering, adhesion promoting wash primer based on particular PVB acid-hardening resins characterized by excellent adhesion on light alloys, galvanized steel, stainless steel (or polished) and by anticorrosive protection on iron. The use of the specific hardening thinner is mandatory in order to achieve the declared mechanical adhesion performance.

APPLICATION FIELD

Wash primer ideal as adhesion promoting primer on machined parts, flanges, mechanical parts and stainless and galvanized steel structures. By virtue of its acidity, the product guarantees high (and better than some traditional 2K systems) chemical-physical adhesion on difficult substrates. The product can be used also as temporary primer for the treatment of elements that must be stored and subsequently re-coated with protective systems

GENERAL INFORMATION

System: One pack - 1K

Nature: Solvent-based

Packages: 4 l

Colors ready in stock: Clear yellow

Suitable Substrates: Iron, Galvanized surfaces, Light alloys, Aluminum, Stainless steel

Overcoatable with: Fast drying nitro, epoxy and acrylic enamels

SUBSTRATE PREPARATION

The surface pre-treatment process, to be carried out prior to the application of the coating product, is of considerable importance in order to obtain and guarantee optimal and long-lasting results and performance over time. The substrate must be perfectly clean, dry, degreased and free from rust and/or calamine. It is also advisable to make sure that the substrate is free from particles and other paints that are not perfectly adherent or incompatible with the coating of paint that will be applied. For the purpose of a correct and complete preparation, it is recommended to consult, where necessary, the explanatory notes attached to the technical data sheet, the painting manual and the technical assistance service of the Research & Development Laboratory. The explanatory notes, specifically, depending on the type of surface and the result to be obtained, indicate different pre-treatment methods such as degreasing, manual and mechanical cleaning using special equipment, mechanical preparations (scraping, sanding, tapping, brushing), light or accurate sandblasting, shot blasting, shot peening and wet sandblasting (or hydro sandblasting).

APPLICATION

Application conditions

The application of the coating product is subject to various factors such as environmental conditions (among which it is necessary to mention temperature, humidity and ventilation), geometry and laboriousness of the products to be painted, surface profiles and thicknesses to be applied. The application system to be used is of particular importance as, depending on the type of system, various parameters may vary including the transfer efficiency of the coating product, the overspray, the aesthetic appearance obtained, the sagging stability of the product and the ease or complexity of application. For these reasons, prior to applications on systems and lines of considerable scope, it is advisable to contact the technical assistance service in order to carry out the inspection and the necessary surveys for a consultancy activity relating to the application methods and the definition of ad hoc technical details on the plant in question.

EQUIPMENT	VISCOSITY	NOOZLE	PRESSURE	NOTES
AIRBRUSH - CUP GUN	20" - 30" Ford Cup 4	1,3 - 1,6 mm	3,5 - 4 bar	-

ENVIRONMENTAL CONDITIONS



ENVIRONMENT
TEMPERATURE

5°C - 35°C



SUBSTRATE
TEMPERATURE

5°C - 35°C



RELATIVE
HUMIDITY

60 %



SHELF LIFE

Store 1 year in original sealed packaging at +5/+35°C.

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TECHNICAL DATA



THEORETICAL AVERAGE SPREADING RATE	APPLICATION	DILUTION	GLOSS	WET FILM THICKNESS EACH COAT	DRY FILM THICKNESS EACH COAT	N° OF COATS	TOTAL DRY FILM THICKNESS	THEORETICAL AVERAGE CONSUMPTION
19 m²/l each coat at the dry film thickness of 10 µ	Spray	50-60% with Wash Primer Thinner Series 0963	-	50 µ	10 µ	1 or 2 coats to achieve the total desired thickness	20 µ	51.4 g/m²

DRYING



OVERCOATING INTERVAL	AIR DRYING	DUST-FREE DRYING	DRY TO TOUCH	DRY THROUGH	FULL CURE	FLASH OFF	STOVING DRYING	RESISTANCE TO TEMPERATURE
12 - 24 hours	20°C	2 - 3 minutes	1 hour	18 - 24 hours	2 days	-	-	80°C

WARNINGS AND RECOMMENDATIONS

- Being an anticorrosive primer, if exposed outdoors or where a long maintenance of the initial features is required, it is necessary to apply a suitable protective final coat.
- For overcoating with epoxy and polyurethane enamels, allow at least 24 hours to elapse, in order to avoid resolubilization of the first coat with consequent loss of adhesion. Given the acidic nature of the product, do not leave it in contact with light alloy application equipment for an excessively long time.
- The product must be diluted with the relative hardening thinner, Wash Primer Thinner Series 0963 at 50-60%, in order to ensure proper adhesion.
- The product can be re-coated with fast drying and nitro synthetic coating systems within 12 hours; for epoxy and polyurethane coating systems, wait at least 24 hours to avoid resolubilization of the first coat with consequent loss of adhesion.
- Being a thin film thickness product, it is recommended to apply a TOTAL DRY FILM THICKNESS not exceeding 15-20 microns to avoid inter-adhesion between the coats.

SUPPLY TECHNICAL DATA

Composition: Phenolic modified polyvinyl butyral
Reference color: Transparent Yellow
% solid content by weight: 33 ± 2%
% solid content by volume: 19 ± 2%
VOC: 659 ± 2 g/l
VOS: 66.9 ± 2%

PARAMETER	DATA	TEST METHOD
VISCOSITY	500 - 1000 mPa.s (20°C) Rod 3 Speed 20	ISCOL 1
SPECIFIC WEIGHT	0.95 - 1 g/ml	ISCOL 2

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NOTES

Cleaning tools: At the end of the application, carefully wash the spray guns, the painting systems and the containers with a suitable thinner and store the tools dry to avoid encrustations.

Sanitary labelling: Handle the product with care. Make reference to the MSDS and respect the national and local regulations in force concerning personal and environmental safety.

Additional notes:

- The data reported in this data sheet have been obtained using only Franchi&Kim production materials (coatings, hardeners, thinners) applied in accordance with the specifications described. The improper use of thinners and/or hardeners, different from those suggested or not manufactured by Franchi & Kim, can compromise application features, performances and final curing of the product. Therefore, in case of mixed coating systems with Franchi & Kim and other brand products, the conformity of the results with the parameters indicated in the technical data sheet cannot be granted.
- The times related to pot life and drying intervals refer to a standard temperature of 20°C, except when it is expressly indicated.
- The spreading rates are theoretical, indicative and intended per coat as they can be influenced by the color and the application system. Practical application test is suggested.

The information contained in this technical document is correct and accurate to the best of our knowledge, and should therefore be considered reliable. In any case, they cannot imply a guarantee on our part, as certain factors such as the preparation of the product and the substrate, the conditions of use, application, drying and overcoating, as well as the state of conservation of the products, are outside our strict control. It is responsibility of the user to verify the suitability of the products for the specific use, as well as the correct and precise execution of the work in accordance with the content of the technical data sheet, the recommended coating system and preparation of the support. For further information regarding the method of application and conditions of use, it is recommended to contact our technical support service. It should be noted that the packaging image could have a placeholder purpose and could therefore be an indicative reference. The packages indicated may vary according to the additions or changes of the annual price lists. This document replaces all previous versions. In any case, it is advisable to refer to the annexes with the explanatory notes to better understand and deepen the parameters of the technical data sheet. The updated edition, available on the website www.franchi-kim.com in the section technical data sheets of the download area is to be considered the only ones to consult as reference.

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