



# TECHNICAL SHEET



Product name:

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Date: 13.4.2016

<b>Characteristics:</b>	Anticorrosion priming paint for industrial use
<b>Description:</b>	Single-pack water-thinnable semi-matte priming anticorrosion paint formulated on the bases of styrene acrylic dispersion.
<b>Composition (general):</b>	The mixture based on the styrene-acrylic dispersion. It contains anticorrosion and color-fast pigments, fine extenders, coalescent agents and other ingredients enhancing its properties. As a thinner, it contains water and a small amount of glycol-ether-based solvents; it does not contain any aromatic solvents or white spirit.
<b>Application:</b>	It is used as a primer for steel, aluminum and galvanized structures. The paint is fit for the coating of metal roofs, plumber structures, steel bridges, columns, railings, industrial buildings and technological facilities and other structures in civil construction and reconditioning. The paint can be used for coatings on exteriors as well as in interiors. After drying, the paint forms a medium-hard elastic film featuring excellent anticorrosion properties and cohesion with metal substrates.
<b>Colors:</b>	It is made according to RAL, EUROTREND, NCS, ČSN color charts or in agreed color shades.
<b>Properties:</b>	<b>Paint:</b>
<b>Density (g/cm<sup>3</sup>):</b>	1.25 - 1.35
<b>Volume solids ONL (%):</b>	48 - 52
<b>Weight solids (%):</b>	54 - 58
<b>KU viscosity:</b>	85 - 95
<b>Flow time by use of flow cups F6 (s):</b>	45 - 60
<b>pH (at 20 °C):</b>	8.5 - 9.0
<b>VOC (volatile organic compounds) (kg/kg):</b>	0.03
<b>0.006 TOC (total organic carbon content) (kg/kg):</b>	0.018
<b>Maximum permissible value of VOC content (g/l):</b>	140
<b>Max. VOC content in the product in the ready-to-use condition (g/l):</b>	40
<b>Water-thinnable paint category:</b>	A/i - single-pack paints with a special function.
<b>Appearance/color:</b>	Slightly thixotropic fluid
<b>Gloss value (at 60°):</b>	20 - 40
<b>Pendulum hardness (2H/80 °C):</b>	min. 30%
<b>Miscibility:</b>	Miscible with water.
<b>Adhesion by the grid-cutting method:</b>	Degree 0 (cut edges are completely smooth and free of any defects)
<b>Drying time, degree 2 (dry to touch):</b>	1 hrs
<b>Drying time, degree 4 (dry-through):</b>	2 hrs
<b>Substrate preparation:</b>	<p>For the corrosion environments of C2 and C3, the surface must be cleaned by blasting to the degree Sa 2 ½ according to ČSN EN ISO 8501-1 (welds and edges must be treated according to ČSN EN ISO 8501-3).</p> <p>For the corrosion environment C1, the substrate must be clean, dry, free from grease and rust residues, mechanically cleaned to the degree St 2 - St 3.</p> <p>Previously painted surfaces must be cleaned and degreased, and old non-adherent coatings must be removed. To ensure the compatibility of the new coating with the old one, it is recommended that you contact the manufacturer or perform test reference coating. The substrate must be dry, free from any mechanical and greasy impurities, and residues of old paint incoherent with the substrate. Recommended substrate treatments include blasting, degreasing of phosphatizing.</p>
<b>Application conditions:</b>	<p>The paint is supplied in a slightly thixotropic consistency to be applied by high-pressure spray painting; for application using a paint brush or a paint roller, the paint should be thinned with 10 wt. % of water. Other application methods and application conditions should always be discussed with the manufacturer. The air and substrate temperatures during the coat application and drying must not fall below +15 °C, min. 3 °C above the dew point, max. humidity 70 vol. %.</p>
<b>Thinning:</b>	Water - see "Application Conditions"



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<b>Recommended method of application:</b>	With a paint brush, a paint roller or by soaking or spray painting - air, pneumatic, high-pressure - Airless, Airmix												
<b>Recommended coating system:</b>	1 - 2 layers of DENAKOR Z 200, the optimum paint thickness 50 -80 µm DFT, the re-spray interval with two layers is 12 hrs at 20 °C; if additional drying is employed at temperatures to 80 °C, the interval can be reduced up to 2 hrs. 1 - 2 layers of DENATOP P, dispersion acrylic enamel, the optimum layer thickness 80 µm DFT, the re-spray interval between the primer and the enamel must be at least 6 hrs; the same applies to 2-layer enamel at 20 °C; if additional drying is employed to 80 °C, the interval can be reduced. DENATOP R, DENATOP P/AU, DENAPUR or EPOXIDEN E can also be used as top coats.												
<b>Application data:</b>	The paint shall be applied with a paint brush, a paint roller or by soaking or spray painting - air, pneumatic, high-pressure - Airless, Airmix The paint can be additionally dried. <b>Data concerning conventional pneumatic spray painting</b> Spray gun, for example EST 311, EST 314 or EST 115 Nozzle according to the required performance 14-20 Air pressure 2.5 - 3 atm. <b>Data concerning the high-pressure spray painting Airless</b> , e.g. VYZA VARIO 56-45 ( EST ) Nozzle 0.011 inch (0.28 mm) or 0.013 inch (0.33 mm) Nozzle pressure 22 - 28 MPa (220-280 atm.; 3200-4100 psi) Spray angle 20 - 60° Yellow gun filter 100/149 (mesh/µm), for the spray angle 60 °C red gun filter 200/74 (mesh/µm)												
<b>Spreading capacity and recommended thickness:</b>	The recommended coat thickness ranges from 60 to 120 µm, which depends mainly on the substrate roughness <table border="1"><tr><td>Wet-film thickness WFT (µm)</td><td>100</td><td>160</td></tr><tr><td>Dry-film thickness DFT (µm)</td><td>50</td><td>80</td></tr><tr><td>Theoretical spreading rate (m<sup>2</sup>/kg)</td><td>7.70</td><td>4.80</td></tr><tr><td>Theoretical spreading rate (kg/m<sup>2</sup>)</td><td>0.13</td><td>0.21</td></tr></table>	Wet-film thickness WFT (µm)	100	160	Dry-film thickness DFT (µm)	50	80	Theoretical spreading rate (m <sup>2</sup> /kg)	7.70	4.80	Theoretical spreading rate (kg/m <sup>2</sup> )	0.13	0.21
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<b>Packaging:</b>	Containers weighing 20 - 200 kg.												
<b>Storage:</b>	Store in original and well-closed containers in cool, dry and well-ventilated areas at temperature from +5 to +25 °C. Protect from freeze. Keep the mixture separated from drinks, foodstuff, feedstuff and medicine. Store away from the reach of children. The shelf life is a minimum 12 months from the date of manufacture. The product must not freeze.												
<b>Disposal of packaging and waste:</b>	Product residues and contaminated packaging shall be disposed of as hazardous waste in accordance with the applicable regulations.												
<b>Safety and hygiene:</b>	When handling the product, observe the instructions provided in the safety data sheet. Observe the principles of personal hygiene. If on the skin, wash the affected areas with soap and water. In case of contact with eyes, rinse immediately with plenty of water, seek medical advice. If swallowed, rinse mouth with water, do not induce vomiting and get medical attention.												
<b>Legislation, certificates, attestations, other tested parameters:</b>	See the Declaration of Conformity Consent No. 31015 on the suitability of the application for railway vehicles in the production of new railway vehicles and for repairs to and refurbishment of existing railway vehicles.												