

SHOP PRIMER 865



Product Code: 865

Description

Two-pack phosphatizing and passivating primer for the temporary protection of steel. It contains non-toxic rust-preventive pigments. It allows oxy-fuel cutting and welding. On blasted steel grades Sa. 2.5 (or Sa3) it reaches a protection of more than six months in marine atmospheres.

Fields of Application

Pre-treatment of blasted steel. Base for alkyd, chlorinated rubber, epoxy, polyurethane, etc... on steel, aluminium, and on different non ferrous alloys. (Consult).

Technical Data

Product Type	Phenolic vinyl
Finish	Matt
Colour (UNE EN ISO 11664-4)	Iron red oxide
Density (UNE EN ISO 2811-1)	1.07 - 1.11 Kg/L
Coverage (UNE 48282)	11 - 14.5 m ² /L (15- 20 dry microns)
Drying at 23°C 60 % RH (UNE 48301)	10 - 15 minutes
Recoat time at 23°C 60% RH (UNE 48283)	Minimum: 2 hours , Maximum: None
Mixing Rate	Base: 3 , Hardener: 1
Pot Life at 23°C	10 hours
Methods of Application	Brush and roller (Just for patching), Air Spray-Gun (The data quoted are only hints.), Airless(The data quoted are only hints.)
Thinning	Air Spray-Gun: 20-25%, Airless: 10-15%
Nozzle Diameter	Air Spray-Gun: 1.7 mm., Airless: 0.015"-0.018"
Nozzle Pressure	Air Spray-Gun: 3-4 bar, Airless: 75 bar
Thinner	876 Thinner.
Equipment Cleaning	876 Thinner.
Recommended Thickness (UNE EN ISO 2808)	Max. 15 dry microns
Application Temperature, RH<80%	10 - 30°C
Flash Point (UNE EN ISO 3679)	Base: 15 °C / Endurecedor: 14 °C
Volume Solids (UNE EN ISO 3233-3)	30 - 32 %
Pack sizes	4 L .For 20 L a minimum order of 200 L is required

Variations in temperature, humidity, thickness, tinting or surface type, etc. may lead to changes in drying, in coverage or in

other properties.

Directions for use

GENERAL REMARKS:

Carefully stir the product in the can.

The surfaces to be painted have to be clean, dry and sound.

Let to dry for 15 minutes before use in order to help to remove the air contained in the mixture.

BARE SURFACES:

Steel: Remove rust by sandblasting up to Sa 2 ½ grade of the ISO 8501-1 standard. The surface needs a medium roughness corresponding to the pattern N9a of the No. 3 Roughness Test. Immediately after sandblasting, apply a uniformly thick coat of Shop Primer. Avoid dry spraying and too thick coats.

Precautions

Always read the pack label before use. For more information, please refer to the Safety Data Sheet.

Issue date: 2016-10

Any technical sheet is automatically cancelled by a subsequent sheet or five years after the issue date. We guarantee the quality of our products. However, we disclaim any liability in relation to factors other than the coating itself or in relation to an unsuitable use or application method. In case of doubt, please refer to our technical service before applying the products.



TITAN

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