

TECHNICAL DATA SHEET

Item number: 0503-474-XXX0

Product name: ALMADUR UNIVERSAL PRIMER 4+1

ALMADUR UNIVERSAL PRIMER

Description: Two-component, anti-corrosion epoxy primer with a wide range of application and very good insulating properties. A universal primer for all surfaces ensuring superb resistance to corrosion and abrasion. The coat is resistant to weather conditions and fairly aggressive chemical splashes: alkali and salt solutions, petroleum and diesel oil.

Ideal primer for topcoats.

ADVANTAGES

- very good adhesion to steel, shop primers and non-ferrous metals
- good mechanical resistance
- filling with active inhibitors increases resistance to corrosion
- excellent anti-corrosion properties in weather conditions
- fast curing even at temperatures as low as 5°C
- perfect surface guaranteeing superb durability and premium sheen-like finish esthetics

RECOMMENDED USE

Suitable for steel, galvanized and aluminum elements of structures exposed to marine, marine coastal, urban and industrial environments.

Wherever high resistance to corrosion is required.

TECHNICAL PROPERTIES

- | | | |
|---|----------------|--------|
| • Density (approx.), kg/dm ³ | | 1,37 |
| • Recommended film thickness per one coat, dry/wet μm | | 95/150 |
| • Dry time (at 20 °C): 1st degree (tack-free), h | | 1,5 |
| • Pot life at 20 °C, h | 6 | |
| • Full cure at 20 °C, days | 7 | |
| | at 15 °C, days | 14 |
| • Theoretical coverage at 95 μm film thickness, dm ³ /m ² | | 0,15 |
| • Solvents (±2), % by mass | 26 | |
| • Solid parts (±2), % by volume | 63 | |
| • VOC in a ready-to-use product, g/l | | 480 |
| • Recommended number of coats | 1 – 2 | |

GLOSS semi-matte

COLOR 0102 – sand 0312 – beige-red
0711 - light gray 0761 - dark gray

Subsequent coatings

Two-component epoxy, polyurethane and one-component acrylic ALMA-COLOR paints.

APPLICATION

Paint preparation – Mix thoroughly contents I and II (content II – 0504-474-0000) in the following proportions by volume: by weight:

- | | | |
|--------------|---|-----|
| ● content I | 4 | 100 |
| ● content II | 1 | 15 |

The product is ready to use after 15 minutes (at 20 °C)

Product application method – commercial viscosity as delivered 65-85s (after mixing the contents)

- brush
- hydrodynamic spraying: Ø0,53-0,68 mm; 10 - 20 MPa
- pneumatic spraying after dilution to spraying viscosity – 30-35 s:
- tip size 2,0 – 2,5 mm
- spraying pressure 4,0 – 5,0 atm

It is possible to redry the coating at a higher temperature after approx. 25 minutes following application of the last coat (the time is required to reach the proper flow rate and initial evaporation of solvents).

Thinner number 8040

APPLICATION METHOD*

Surface - the higher cleanliness degree of a surface, the longer durability of the coating. The highest chemical and mechanical resistance are achieved when the coats are painted directly over steel substrates which have been sandblasted or shot-blasted down to the minimal cleanliness degree of Sa 2½*

- Steel surface: dry, degreased and free of any foreign contaminants – cleaned down to at least Sa 2* cleanliness degree (for immersed surfaces) or at least Sa 2* for exterior surfaces. In the case of exterior surfaces, a minimal cleanliness degree of Sa 3* is acceptable.
- Non-weathered hot-dip galvanized steel and dry aluminum surfaces should be tarnished with a fine abrasive cloth.
- Galvanized surfaces should be free of any contaminants and zinc corrosion products. They should be cleaned with hot water, pressure cleaned, steam cleaned, abrasive-cleaned or with the aid of mechanical hand tools.
- The surface to be coated should be dry, free of salt, grease, dust and any other contaminants.

Time lapse between subsequent layers: the shortest / longest for the recommended coat thickness:

- at 20 °C - 8 h / 1 month
- at 10 °C - 18 h / 2 months

Painting and curing conditions:

- minimal surface temperature 5°C
- surface temperature above the dew point (to avoid condensation)
- relative humidity of the air not higher than 85%
- efficient ventilation.

SHELF LIFE: 12 months from the production date in the original unsealed container.

***PN-ISO 8501-1:2008**

The above information, as much as is valid to the best of our knowledge — based on laboratory tests as well as on our hands-on expertise — should not be considered complete. As a manufacturer, we are not able to monitor all

various conditions in which the product is applied or many other factors that can influence the final result of the product application and use. We are not responsible for any damages caused by any misuse of the product be it by not following our recommendations or by using the product for purposes other than intended by the manufacturer. We keep the right to modify the manual any time without prior notice.

WARNING! This product is designed for professional use in the given industry. The detailed information regarding product safety can be found in the MSDS.