

# Over Fire Primer

Linea : Industry      Scheda tecnica n° 02.02.04    Rev.1    10/07/00

## Product's description

### Double-component, epoxy-polyamide, low thickness primer

**Over Fire Primer** is a modified, epoxy-polyamide resins based primer, with zinc phosphate based pigmentation and lamellar filling particles, providing the product with an excellent adhesion on the uncoated or primed substrate; easy to apply; quick drying power; finish applicability wet over wet; excellent and long lasting active protection.

## Practical advice

Suitable for industrial maintenance, sheds, equipments, underbodies of agricultural vehicles, trucks and train wagons, banisters, foot bridges, tanks, sanded and brushed pipes.

## Technical features

Aspect	Flat – Semi-flat
Colour	Grey – Red – White
Density Kg/Lt	1,33 ± 0,05
Viscosity 25°C	140 sec. ford 4
Solid content by volume %	45 ± 2%
Theoretical spreading rate Sq.m/lt – gr/m <sup>2</sup>	1,5 Sq.m./l – 90 g/Sq.m.
Typical thickness humid/dry micron	65 humid / 30 dry
Mixing ratio Base/Hardener	80 Base / 20 Hardener (in peso)
Pot Life	24 hours
Thinner	DPE 310 epoxy thinner
Painting method	Brush
	Roller
	Spray
	Airless spray
	2 – 5% thinning
	2% thinning
	10-15% thinning
	Nozzle's diameter 1,5 - 1,7 mm
	Pressure 3,5 – 4,5 kg/Sq.m. (atm)
	2-5% thinning
	Nozzle's diameter 0,400 – 0,500 mm
	Compression Ratio 30:1
	Exit pressure 130 – 150 kg/Sq.m. (atm)
Drying times 25°C	Untouched :
	Dry to the touch :
	Dry :
Heat resistance	100° outdoor – 40° in water
Min./ Max. over-coating times	24 hrs / no limitation
Flash point	26°
Shelf life	24 months
Standard package	Kg 20 - Kg 5

## Notes

Protect from frost and direct sunlight. Do not use fire or inflammable materials.

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## Application instructions

### Preparation of the surfaces

New iron: cleaned and free from oil and grease. The best preparation is sandblasting with SA 2 degree of the Svensk scale standard SIS 1967 (SSPC SP 6), otherwise mechanical brushing, according to SSPC SP 2 specification. Apply two or more coats of **Over Fire Primer** with a minimum thickness of 80 micron – dry film, especially over sanded sheet iron, to coat completely the surface roughness .

Painted and partially deteriorated iron: remove the old peeling paintwork, by staking off or by manual or mechanical brushing. Sandblast and completely remove any trace of dust, dirt and sanding rests. Apply over the uncoated areas a first coat of **Over Fire Primer** or Primepox. After 24 hrs. drying, apply evenly a coat over the whole surface. Allow to dry and apply the finish coat.

New wood: clean, sandblast and check that residual humidity is below 15%. Apply one or two coats of **Over Fire Primer**, as needed.

Old wood: sandpaper and remove any trace of peeling paintwork. Clean carefully and apply one coat of **Over Fire Primer**.

Application note: apply with temperatures above 5° and below + 45°, with air relative humidity below 90%. Do not apply during windy nor rainy days.

## It is recommended for

Marine, medium and heavy industrial, country, urban environments; immersion in aliphatic oil products, vegetable and mineral oils.

## It is not recommended for

Immersion in acid and alkaline solutions; immersion in drinking and distilled water.

## Recommended finishes

Over Fire Btr 02 , Bicar, Atriacar, Atriamac, Seratria, Idrosint, Idrolux, Idrolux SL, Atrianitro gofrato, Atriamet.

## Safety precautions

The product is inflammable. Respect the safety norms in force for transport, storage and application. In case of application in closed places, provide a proper ventilation or forced exhaust. Do not waste the empty tins in the environment, let them dry and dispose them of as special waste. For any further information, see the technical data.

(\*) These information, even if reliable, are absolutely approximate. The company owns the right to change them without any notice. Moreover, it is not responsible for the use of the present information. The user must previously test the product's suitability, before using it. For any further explanations or requirements on the products, please contact the staff of our technical lab.