

TECHNICAL DATA SHEET



Anticorrosive Epoxy Primer 3+1 RANAL

Two component, anticorrosive epoxy primer 3+1 provides very durable coat and excellent anticorrosive and insulating properties. The coat has good adhesion to various types of surfaces, mechanically and elastically resistant. The coat is resistant to scratches, squirts of not very aggressive chemical substances such as solutions of alkalies and salts, petrols and diesel fuel and to atmospheric conditions. It is an ideal basis for all the known top coats available on the market.

It can be used for:

- active anticorrosive protection of passenger cars, buses and trucks,
- very good adhesion to steel, galvanized steel, aluminium, polyester laminates,
- car body renovation,
- for precise coating of primed surfaces,
- ideal substrate ensuring high durability and excellent look of the coat,
- each time when high anticorrosive properties are required.

Proceeding:

Component	by volume	by weight
Primer	3	5
Hardener	1	1
Thinner	10%	

After careful mixing and thinning to spray viscosity apply with a spray gun. After 10 minutes (at 20°C) it is ready to use.

Technical properties:

- density (about), kg/dm ³	1,4
- recommended single coat thickness, µm.	60
- recommended single layer thickness, µm	100
- usability of the mixture of components at 20°C, h	8
- curing time of a layer - at 20°C, h	24
- at 60°C, h	1
- theoretical yield for the coat of the thickness of 60 µm dm ³ /m ² 0,09	
- content of non volatile substances (about), % vol./mixture	70
- VOC (cat. B/5) limit, g/l	540
- VOC actual content, g/l , depending on thinning 420-510	

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- recommended number of layers

2-3

Real level of Volatile Organic Compounds (VOC):

VOC II/B/c limit= 540g/L, VOC= 420-510 g/L (depending on thinning)

Application methods:

Airless spraying, brush, air spraying – after adding 10% - viscosity DIN ϕ 4 – 35-40 s:

- nozzle diameter 1,6 – 2,2 mm;
- spraying pressure 3,0 – 4,0 atm;
- recommended layers 2 - 3;
- time for thinner evaporation between the coats 25 min;
- possibility of continuation of curing the coat in higher temperature after about 25 min from the application of the last coat (time necessary to get the appropriate fluidity and preliminary evaporation of the thinners).

Methods of use:

Substrate- the surface should be degreased, clean, free from oils, grease, dust, loose old paint coating, mill scale and foreign contaminants. The coat sanded with 120 – 220 paper, free from grease, dust, corrosion, dry.

- The surface of steel dry, free from foreign contaminants, degreased – clean until reaching at least Sa 2 (wet blasting) for external surfaces. For external surfaces the cleaning can be at least St 3 (manual cleaning or using a power tool in accordance with PN-ISO 12944-4 standard).
- Old paint coats degrease and dry sand with P220-P360 paper.
- Not seasoned surfaces of galvanized steel and aluminium surfaces dry, mat with abrasive needled cloth.
- Galvanized surfaces should be free from any contaminants, and zink corrosion products. Cleaning with hot water, pressured water, abrasive cloth or manual cleaning using a power tool.
- Surface ready for cleaning should be dry, free from salt, grease, dust and other contaminants.
- For an adequate anticorrosion protection the thickness of the coat should be higher than 80 μ m.

Conditions during coating and curing:

- minimal surface temperature 5°C;
- surface at temperature higher than dew point (to avoid condensation);
- relative air humidity max. 85%;
- effective ventilation.

Hardening time:

In the temperature of 20°C: about 24h

In the temperature 60°C : about 1h

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Nitrocellulose thinner RANAL.

Color:

Grey

Storage:

To be stored in dry and cool place, away from the sources of light and heat. Avoid sun exposure. Storage time of the product in the original package is equal to 12 months, and of the hardener – 12 months in the temperature of 5°C-35°C.

Health and safety recommendations:

Apply safety data sheet of the particular product.

Packaging:

Art. Nr	Capacity, L:	Package, pieces:	Weight of the carton, kg
80670	0,75 + 0,25 hardener	6	6,90

This information is based on careful, laboratory research and our long-standing experience. Strong market position does not absolve us from constant control of the quality of our products. However, we are not responsible for the final results after incorrect use of the product.