

OROPRIMER 485

EPOXY PRIMER

Mix 4:1 by volume with **OROCAT 744**

Two pack epoxy anti-corrosive primer, pigmented with zinc phosphate. Suitable for painting all types of metal structures requiring high resistance against rust. Ideal as a primer in epoxy-polyurethane systems.

Physical parameters	Base OROPRIMER 485	Catalyst OROCAT 744
Viscosity	15000 – 20000 cpoise (Brookfield sp6 10rpm)	180 – 300" (Ford cup #4)
Specific gravity	1,35 – 1,40 g/cc	0,89 – 0,92 g/cc
Solids content	63 – 66%	65 – 67%
In-can appearance	Viscous liquid	Viscous liquid
Stability	12 months at 10 – 25°C	12 months

Characteristics of the mixture	
Mix ratio	4:1 by volume (OROPRIMER 485:OROCAT 744)
Viscosity of the mixture	-"
Specific gravity of the mixture	1,26 – 1,30 g/cc
Solids content	63 – 66%
Colour	White, Grey, Red oxide, Red RAL 3012
Dry film appearance	Eggshell finish with good hiding power and leveling
Spreading rate	8 – 9 m ² / L (135 – 170 g/m ²)
Gloss	5 – 20%
Adhesion	100% (Max: GT0)
Salt spray test	>800 hours
Pot life of mixture	8 – 10 hours
VOC	<500 g/L Directive 2004/42/CE: Limit value (2010) for this product (sub. cat. A/j): 500 g/L

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Product use information

Surface	Iron, steel
Surface preparation	Metal should be sandblasted to SA 2½, or deoxidized by mechanical brushing, without grease or moisture.
Product preparation	Never apply at temperatures below 14°C. Stir thoroughly the contents of the container with a spatula. Make the mixture (by volume) 4 parts of OROPRIMER 485 (Base) to 1 part of OROCAT 744 (Catalyst)
Application method	Brush, Roller, Pneumatic spray, Airless spray
Dilution	Up to 10 – 15% with ORODIS 718
Application	Apply 1 – 2 coats of 50 – 60 µm dry film thickness
Drying	Touch drying time: 1 – 2 hours Forced drying time: 10 – 15 min. at T _{room} and 20-30 min. at T = 70 – 80°C Drying time is very influenced by the applied quantity, the environment and the substrate's type and condition.
Recoatable	24 – 48 hours
Cleaning	ORODIS 718

Application process

	Primer	Top coat
Iron, steel	OROPRIMER 485	OROLUR 384 OROLUR 364

Additional information

Safety	Consult package labelling. For further information, ask for the Material Safety Data Sheet
Storage	1 year

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