

61200001 BASE X SERIE 6120 EPOTEC PRIMER



epoxy primer

High-performance primer or undercoat, used to provide maximum protection of iron materials in coating cycles in aggressive environments, where maximum performance is required in terms of corrosion resistance, adhesion and resistance to chemical agents.



Date of revision	23/03/2020
Composition	Two-component primer with an epoxy resin base and polyamide hardener. Contains zinc phosphate as an anti-corrosive pigment.
Main properties	<ul style="list-style-type: none">• quick drying• excellent anti-corrosive power• excellent adhesion on metal
Applications	Suitable for protecting new iron materials and those requiring maintenance, boasts excellent application versatility; the main applications include the metal structuring, mechanical and petrochemical industries and the plant maintenance sector for aggressive environments. Excellent adhering properties on properly prepared iron and galvanised sheet metal and aluminium surfaces.
Colour	Can be coloured with the Colormaker Professional tinting system. Colours available on the Colormaker Lab software.

Technical specifications	Reference	UoM	Value
(data measured at 20°C, with 65% R.H.)			
Specific weight (pycnometer)	C022	kg/l	1.430 ± 0.15 (Coloured)
Ford viscosity cup no. 8	C076	s	14 ± 2 (Coloured)
Appearance of the film			matt
Adherence	ISO 2409		0 (zero) standardised support of type Q-Panel Type S Ground
Dry residue by volume (A+B)		%	45 ± 2 (Coloured)
Recommended DFT	ISO 2808	µm	50–80
Recommended wet thickness		µm	110–180
Theoretical coverage		m ² /l	5.5–9 at the recommended thickness.
		m ² /kg	4–7 at the recommended thickness.
Practical coverage			Consider an appropriate loss factor.

Method of use

- Surface and application conditions Ambient temperature min. +5°C / max. +35°C and R.H. < 80%.
Temperature of the support min. +5°C / max. +35°C and at least 3°C above

the dew point.

- . Catalysis ratio BASE X SERIE 6120 EPOTEC PRIMER: Catalyst 94100209
 3:1 by volume
 100: 20 by weight
- . Pot life 8 hours at 20°C
- . Application method Airless, spraying, brush.
- . Thinner 93100009
- . Dilution Airless 0–5 %, Spraying 5–15%, Brush 5–15%.
- . Airless application Recommended Suitable nozzles 0.011–0.017"
 Misting pressure 120–180 atm
 Compression ratio 30:1 (min)
 The data for airless spraying is purely indicative and subject
 to adjustments.
 The filters must be suited to the nozzle used.
- . Application by spraying Recommended Usable nozzles 1.5–2.5 mm
 Misting pressure 3–4 atm
 The data for spraying are purely indicative and subject
 to adjustments.
- . Brush application Suitable Only over reduced areas.
 Normally it is possible to achieve 40–50 microns.
- . Mixing This product is supplied in two different containers.
 1) Mix BASE X SERIE 6120 EPOTEC PRIMER (Part A) using a mechanical
 mixer;
 2) Add the 94100209 Catalyst (Part B) and mix together with a mechanical
 mixer;
 3) Dilute according to instructions.
 After mixing, the product must be applied within the specified pot life.

- . Hardening time

Temperature	Dry to touch	Dry in depth	Minimum overcoating time	Maximum overcoating time*
5°C	3 hours	48 hours	6 hours	4 months
20°C	1 hour	24 hours	3 hours	4 months
30°C	45 minutes	16 hours	90 minutes	4 months

Values referred to an average thickness of 75 microns DFT and 65% R.H.
Considerable thicknesses, insufficient ventilation or low temperatures require longer hardening times.

(*) May vary in relation to the type of finish to be applied.

Precautions and warnings

- make sure that no catalysed product remains inside the spray gun or in the painting system;
- once the pot life of the product is over, the product is no longer usable;
- only the specified thinners must be used: consult the "Method of use" section of the Technical Data Sheet under "Thinner". The use of other solvents, especially for recovery, may impair the chemical-physical characteristics of the varnish film;
- try to prevent condensation effects during or immediately after application (including weather conditions), to ensure that the varnish film forms correctly;
- do not apply thicknesses of more than 120 microns DFT for each coat, to enable proper handling and substrate over-painting;
- this product cures with difficulty below 5°C; for the best varnish film performance, temperatures above 10°C are recommended;
- if BASE X SERIE 6120 EPOTEC PRIMER is left exposed outdoors for a long time, make sure any dirt and/or contaminants are removed; depending on the coating cycle, sanding may be required;
- like all epoxy products, BASE X SERIE 6120 EPOTEC PRIMER tends to fade and flake when exposed to outdoor conditions. This may affect its visual appeal but not its anti-corrosive performance.

. Cleaning of equipment

Clean the equipment immediately after use with the following thinner: Diluente per Epossidici 93100009.

Surface preparation

The surface should be clean, dry and free from contaminants. Before applying any coating product, one should first assess the most appropriate treatment in accordance with ISO 8504:2000.

Oil and grease must be removed in accordance with SSPC-SP1 (cleaning with solvents).

STEEL

Sandblast with appropriate abrasives at grade Sa 2½ (ISO 8501-1:2007) or SSPC-SP10 - NACE No 2.

We suggest a roughness profile (Rz) of 35-50 µm (ISO 8503-4:2012).

For moderately aggressive environments and maintenance, brush with a machine tool to grade St3 (ISO 8501-1:2007).

HOT-DIPPED GALVANISED STEEL

Brush-off blast cleaning using suitable abrasives with a dense profile.

For moderately aggressive environments and maintenance, brush with a machine tool to grade St3 (ISO 8501-1:2007).

ELECTRO-GALVANISED STEEL

Brush-off blast cleaning using suitable abrasives with a dense profile.

For moderately aggressive environments and maintenance, brush with a machine tool to grade St3 (ISO 8501-1:2007). A preliminary test is always recommended.

ALUMINIUM

Brush-off blast cleaning using suitable abrasives with a dense profile.

For moderately aggressive environments and maintenance, brush with a machine tool to grade St3 (ISO 8501-1:2007). A preliminary test is always recommended.

Application cycle

Apply one or two coats in direct contact with the steel substrate, or as a high-quality undercoat on epoxy galvanisers.

Compatibility of cycles

BASE X SERIE 6120 EPOTEC PRIMER can be coated over with itself.

After the application of BASE X SERIE 6120 EPOTEC PRIMER, the recommended finishes are the polyurethane enamels POLITHANE PLUS, POLICRIL and POLIDUR.

For further details, contact the Colorificio Sammarinese S.p.A. Technical Support Service.

Storage

Store at +10°C to +30°C in a dry place. The product and catalyst can be stored for up to 12 months in their original packaging. After this time, you must check the condition of the product.

Warnings and safety

This product is provided only for professional use and for professional applicators.

We recommend always referring to the product Safety Data Sheets for details relating to health and safety and for the storage and disposal rules.

This information is the result of our practical experience but is purely indicative. For more detailed information, please contact our technical support service. This sheet cancels and substitutes any previous editions.
