

OROPRIMER 485

EPOXY PRIMER

Reticulate by mixing 4: 1 by volume with **OROCAT 744** catalyst

Epoxy primer with two components. Specially formulated with antioxidant pigments (Zn phosphate) for the painting of metallic structures of all kinds, which require a high resistance against oxidation. Ideal as a primer in epoxy-polyurethane systems. Ideal as a primer for epoxy-polyurethane systems. C3-C5 tests validated by CIDETEC technology centre.

Physical parameters	Primer OROPRIMER 485	Catalyst OROCAT 744
Viscosity (Brookfield sp6 10rpm)	15000 – 20000 cpoise	180 – 300" (Ford cup n°4)
Specific gravity	1,35 – 1,40 g/mL	0,89 – 0.92 g/cc
Solids	63 – 66%	65 - 67%
In-can appearance	Viscous liquid	Viscous liquid
Stability (without opening the can)	12 months at 10 – 25°C	12 months

Characteristics of the mixture

Mixture ratio	4:1 in volume (OROPRIMER 485:OROCAT 744)
Mixture viscosity	-"
Mixture specific gravity	1,26 – 1,30 g/mL
Sólidos de la mezcla	63 – 66%
Colour	White, Grey, Oxide Red, red RAL 3012
Dry film appearance	Matt film with good adhesion and leveling
Spreading rate	8 – 9 m ² / L (135 – 170 g/m ²)
Gloss	5 – 20%
Adhesion	100% (Máx: GT0)
Mixture Pot life	8 – 10 hours
COV	<500 g/L Directive 2004/42 / EC: Limit value (2010) for this product (subcategory A / i): 500 g / L

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Product	Product code	Brand	Author	Date	Version	Replaces	Page	Language
OROPRIMER 485	04R485XXXZZZ	OROPAL	IRURENA GROUP	03.01.24	1	Any previous version	1/2	EN

Product use information

Surface	Iron, Steel
Surface preparation	The metal must be blasted at SA 2 ½ or, failing that, deoxidized by mechanical brushing, without grease or moisture.
Product preparation	Do not apply at temperatures below 14°C. Before applying, homogenize the product well with a spatula. Make the mixture with the catalyst (in volume) of 4 parts of OROPRIMER 485 (Base) with 1 part of OROCAT 744 (Catalyst)
Application method	Brush, Roller, Pneumatic gun, Airless gun
Dilution	Until 10 – 15% ORODIS 718
Application	1-2 hands 50-60 µm Before use: Homogenize the product and temper it. Do not apply at temperatures below 14°C.
Drying	Touch drying time: 1 – 2 hours Forced drying: 10 - 15 min. to Ambiente and 20-30 min. at T = 70-80 °C The drying time is greatly influenced by the grammage, the type and condition of the support and the environmental conditions.
Recoatable	24 – 48 hours
Cleaning	ORODIS 718

Application process

Primer

Top coat

Iron, Steel	OROPRIMER 485	OROLUR 384 OROLUR 364
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Additional information

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

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