

OROPRIMER 494

EPOXY PRIMER

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

Extraordinary quality two-component zinc-based polyamide adduct and epoxy resin primer. Excellent anti-corrosion power thanks to its zinc content. Acts like galvanised steel. Suitable for welding. Chromate- and lead-free. Validated by CIDETEC for C3-C5 systems according to Standard EN ISO 12944.

Physical parameters	Base OROPRIMER 494	Catalyst OROCAT 744
Viscosity	3000-5000 (Brookfield sp6 10 rpm)	180 – 300" (Ford cup n° 4)
Specific weight	1.89 g/ml	0.89 – 0.92 g/cc
Solids	75 – 80%	65 – 67%
Appearance in the container	Viscous liquid	Viscous liquid
Stability (unopened)	12 months at 10 - 25°C	12 months

Mixing characteristics

Mixing ratio	4:1 by volume (OROPRIMER 494 : OROCAT 744)	
Viscosity of the mixture	-	
Specific weight of the mixture	1.65 – 1.70 g/ml	
Mix solids	75 – 80%	
Colour	Grey	
Dry film appearance	Matt film with high anti-corrosion power	
Coverage	5 – 10 m ² /l	(410 – 205 g/m ²)
Gloss	<5%	
Adhesion	100% (Max: GT0)	
Pot life of the mixture	2 – 3 hours	
COV	<500 g/l	Limit value (2010) according to Directive 2004/42/EC for this product (sub. cat. A/j): 500 g/l

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Product	Item code.	Brand	By	Date	Version	Replaces	Page	Language
OROPRIMER 494	04R494600ZZZ	OROPAL	IRURENA GROUP	03.01.24	1	All of the above	1/2	EN

Using the product

Substrate	Iron, steel
Preparing the substrate	The iron surface must be deoxidised (sanded or sandblasted), degreased and dry.
Preparing the product	The high specific weight of zinc powder and its tendency to settle mean it is necessary to mix thoroughly with a spatula before each use. Once consistent, mix 4 parts OROPRIMER 495 (base) to 1 part OROCAT 744 (Catalyst). The mixture by weight would be 7.6 parts OROPRIMER 495 (Base) to 1 part OROCAT 744 (catalyst).
How to apply	Brush, pneumatic gun
Diluting	ORODIS 718
Application	1 coat of 50 - 100 µm dry Before use: Mix the product and temper it. Do not apply at temperatures below 14°C.
Drying/curing	Forced drying: 10 – 15 min. at ambient temp. and 20-30 min. at temp = 70 – 80°C Drying time is highly influenced by weight, type and condition of the substrate, and environmental conditions.
Repainting	12 – 24 hours
Cleaning	ORODIS 718

Recommended system

Primer

Finish

Iron, steel

OROPRIMER 494

OROMEL 614
OROMEL 623
OROMEL 644

Further information

Safety	See package labelling. Ask for the Material Safety Datasheet for more information.
Shelf life	1 year

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