

OROPRIMER 495

EPOXY PRIMER

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

Two-component primer based on epoxy resins and polyamide adduct, of extraordinary quality. Excellent anticorrosive power thanks to its high zinc content (75%). It acts as a galvanized. Suitable for welding. Free of chromates and lead.

Physical parameters	Primer OROPRIMER 495	Catalyst OROCAT 744
Viscosity (Brookfield sp6 10rpm)	TIXO	180 – 300" (Ford cup n°4)
Specific gravity	2,62 g/mL	0,89 – 0,92 g/cc
Solids	80 – 85%	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 495:OROCAT 744)
Mixture viscosity	-"
Mixture specific gravity	2,25 – 2,30 g/mL
Sólidos de la mezcla	80 – 82%
Colour	Grey
Dry film appearance	Matt film with high anticorrosive power
Spreading rate	8 – 10 m ² / L (230 – 280 g/m ²)
Gloss	<5 %
Adhesion	100% (Máx: GT0)
Mixture Pot life	2 – 3 hours
COV	<500 g/L Directive 2004/42 / EC: Limit value (2010) for this product (subcategory A / i): 500 g / L

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	Due to the high specific weight of the zinc powder, this product has a tendency to decant, so, before each use, it is necessary to homogenize the product well with a spatula. Once homogenized, make the mixture with the catalyst (in volume) of 4 parts of OROPRIMER 495 (Base) with 1 part of OROCAT 744 (Catalyst)
Application method	Brush, Pneumatic gun
Dilution	ORODIS 718

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OROPRIMER 495	04R495XXXZZZ	OROPAL	IRURENA GROUP	03.01.24	1	Any previous version	1/2	EN

Application	1-2 dry hands 50-60 µm Before use: Homogenize the product and temper it. Do not apply at temperatures below 14°C.
Drying	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	12 – 24 hours
Cleaning	ORODIS 718

Application process	Primer	Top coat
Iron, Steel	OROPRIMER 495	OROMEL 614 OROMEL 644 OROMEL 647

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

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