

# ORART480

## OROPAL 2K EPOXY HB PRIMER

Catalyzed at 4:1 ratio by volume with **ORART780HARD**

A fast dry two component epoxy primer specially formulated with antioxidant pigments (dicalcium phosphate) for painting all types of metal structures requiring high resistance against oxidation. Ideal as a primer in epoxy – polyurethane systems.

Physical parameters	Base ORART350	Catalyst ORART347HARD
Viscosity	8000-12000 cPoise (Brookfield sp6 10rpm)	180 – 300" (Ford cup #4)
Specific gravity	1,45 – 1,50 g/cc	0,89 – 0,92 g/cc
Solids content	65 – 70%	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 (ORART480:ORART780HARD)
Viscosity of the mixture	-"
Specific gravity of the mixture	1,34 – 1,40 g/cc
Solids content	65 – 69%
Colour	Grey
Dry film appearance	Matt finish with good hiding power and leveling
Spreading rate	7 – 10 m <sup>2</sup> / L (135 – 200 g/m <sup>2</sup> )
Gloss	<5%
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

Product	Product code	Brand	Author	Date	Version	Replaces	Page	Language
ORART480GREY	ORART480GREY/Y	OROPAL	IKI COATINGS – IRURENA GROUP	12.12.19	1	Any previous version	1/2	EN

### Product use information

Surface	Iron, steel
Surface preparation	Substrate must be prepared to a standard of Sa 2½ blast or, failing that, deoxidized by mechanical brushing, free of fat and moisture and preferably prepared to ST 2½
Product preparation	Stir thoroughly the contents of the container with a spatula. <u>Mixing ratio (by volume)</u> ORART480 (Base): 4 parts ORART780HARD (Catalyst): 1 part
Application method	Brush, Roller, All types of spray equipment
Dilution	Up to 10% with ORART725
Application	Apply 1 coat of 45 – 65 µm dry film thickness
Drying	Touch drying time: 1 – 2 hours Forced drying time: 20 – 30 min. at T = 70 – 80°C Drying time is very influenced by the dry film weight, type and state of the substrate and weather conditions.
Recoat able	12 – 48 hours
Cleaning	ORART725

### Application process

Application process	Primer	Top coat
Iron, steel	ORART480	ORART604

### Additional information

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

This technical data sheet aims to inform our customers about the properties of our product. Although the data contained here is based on our knowledge and technical reports carried out according to the mentioned standards, the suitability for purpose of use should be confirmed under customer practical conditions.



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