PRODUCT INFORMATION

COROPUR PI PRIMER

moisture curing polyurethane primer, heavy metal free

Product Description

Coropur PI is a single-component, moisture-curing polyurethane primer for blasted or power brush prepared derusted steel. High polyurethane content enabling considerable adhesion strength. It can be used as a shop primer for short-term corrosion protection of steel parts, dip galvanizing and steel constructions to be welded. Advantages: no toxic steams created near consumption zone and no impact on weld seam quality.

Binding Agent

Moisture hardening polyisocyanate

Pigments

Organic- and anorganic colour pigmentation, phosphates, filling materials

Solvents

Aromatic hydrocarbons and acetates

Fields of Application

Steel construction, marine ballast tanks, construction of vehicles, apparatus engineering etc.

Surface Preparation

1. Removal of contaminations before sand blasting:

Remove oil and grease residues with solvent or detergent.
Remove salt residues by brush or steam vapour.

2. Mechanical roughening; preparation by sand blasting (Sa 2 ½)

Coating Suggestion

The following intermediate- or cover coatings are suitable for Coropur PI primer:

- Coropur Ferro
- Coropur Non Abrasive
- Coropur Alu
- Coropur Cover Colour RAL ....
- Coropur TAR
- Coropur TAR 21

Application Methods

Brush-, roller-, air- and airless-spray application

Application Conditions

Relative air humidity 30 - 95 %
Object temperature - 5℃ (ice-free) up to + 50℃.

Layer Thickness

60 µm - 120 µm DFT

Welding Parameters

- Velocity 0,33 m/Min
- Protection gas CO

Ask for our certificate if required.

Viscosity

40 DIN 6, 800 - 1000 mPas

Thinner

Thinner A-851 Roller Application
Thinner T 1900 Spray Application
Quantity of admixture of thinners depends on ambient temperature and type of processing.

Air Spray	Pressure 3 - 4 bar Nozzle 1,5-2,0 mm Thinner 10-15% T-1900
Airless Spray	Pressure 120-150 bar Nozzle 0,4-0,5 mm Thinner 0-5% T-1900
Equipment Cleaning	Thinner A-851 or Thinner T-1900

Curing Time

at 60 µm DFT	**20°C/75 % rH**	**5°C/75% rH**
dust dry after	15 minutes	20 minutes
dry to touch after	25 minutes	40 minutes
overcoatable after	45 minutes	60 minutes

Temp. Corrosion Protection	6 months without cover coating at 60 µm DFT
Corrosion Protection Tests	1000 hours salt spray test acc. to DIN 53167 1000 hours humid chamber test acc. to DIN 50017 1 x 60 µm Coropur PI 2 x 120 µm Coropur Ferro
Temperature Resistance	+ 140°C (dry)
Shelf Life	12 months in unopened original can under cool and dry storing conditions. Cover opened cans with thinner A-851 or T-1900 and close tightly.
Density	1,34 g/cm³
Solids Content	72 % weight solids 55 % volume solids

Material Consumption

Coropur PI	**Theoretical**	**Practical**
60 µm DFT	150 g/m²	300 g/m²
120 µm DFT	300 g/m²	600 g/m²

Can sizes	1,2 / 6 / 12 kgs net
Colour	grey
V.O.C.	396 g/l
UN-No.	1263
RID/ADR/SDR/ Ziffern	No product of class 3
Flash Point	+ 30°C
Date	April 2003 / EH

Please pass this data sheet to the person in charge of coating application. Above data and recommendations are based on extensive tests and are to be considered only as guidelines without any obligations. As we are continuously developing and improving our products we recommend to consider the date of this data sheet and, if necessary, to ask if there were changes in the meantime. In case of further questions please contact one of our technical advisors for detailed information at:

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