

# ORION PRIMER

700.664

## Description

One component, chromate free propeller primer for good adhesion on propellers, shafts and stern drives.

## Use

Recommend for use on bronze, stainless steel and light alloy propellers, shafts and drives.

## Informations

Finish	Matt	
Colours	.071 Green	
Pack	0,25 l	
Solids by Volume	20 ± 2%	ISO 3233-2
Specific Gravity	1,12 - 1,16 g/cm <sup>3</sup>	ISO 2811-1
Flash Point	1 °C	ISO 3679
VOC	703 g/l	Calculated
Shelf Life	36 months	

## Application

### SURFACE PREPARATION

Remove all trace of contamination, grease and oil by high pressure freshwater cleaning. Proceed with degreasing using a suitable detergent or solvent cleaning if necessary and repeat freshwater cleaning. All surfaces must be clean, dry and free of contaminants before application of recommended products. Supplied air for surface preparation and cleaning must be dry and clean.

### NEW BUILD

**Aluminium:** mechanically cleaning with suitable abrasive disks grain P24 - P80 until achieving a uniform rugosity. Apply the first coat over the treated surface as soon as possible to not lose the required standard.

**Bronze:** mechanically cleaning with suitable abrasive disks grain P80 until achieving a uniform rugosity, taking care to not exceed the base material abrasion. Apply the first coat over the treated surface as soon as possible to not lose the required standard.

**Stainless Steel:** mechanically cleaning with suitable abrasive disks grain P24 - P36 until achieving a uniform rugosity. Apply the first coat over the treated surface as soon as possible to not lose the required standard.

### MAINTENANCE

**Aluminium:** remove all existing paint and provide rugosity to the perfectly bare substrate by mechanically cleaning with suitable abrasive disks grain P24 - P80 until achieving a uniform rugosity. Apply the first coat over the treated surface as soon as possible to not lose the required standard.



**Bronze:** remove all existing paint and provide rugosity to the perfectly bare substrate by mechanically cleaning with suitable abrasive disks grain P80 until achieving a uniform rugosity, taking care to not exceed the base material abrasion. Apply the first coat over the treated surface as soon as possible to not lose the required standard.

**Stainless Steel:** remove all existing paint and provide rugosity to the perfectly bare substrate by mechanically cleaning with suitable abrasive disks grain P24 - P36 until achieving a uniform rugosity. Apply the first coat over the treated surface as soon as possible to not lose the required standard.

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## How to Apply

Standard		Brush and roller
Conventional Spray		Pressure 3,5 bar Nozzle 1,2 – 1.4 mm

## Film Thickness per Coat

DFT	Recommended: 10 µm Standard application range: 10 - 20 µm
WFT	Recommended: 50 µm Standard application range: 50 - 100 µm

## Additional Application Information

Theoretical spreading rate	Application range at the recommended thickness: 10 µm – 20 m <sup>2</sup> /l
Thinner	693 - Roller/Brush (3% max) 693 – Conventional spray: (3% max)

## Compatibility

### Previous Coat

N.A.

### Proceeding Coat

Orion Extra

## Drying Time

	10 °C		15 °C		20 °C		30 °C	
	Min	Max	Min	Max	Min	Max	Min	Max
Overcoating interval	2 h	8 h	2 h	5 h	2 h	5 h	1 h	2 h
Sanding	7 h	7 h	5 h	5 h	5 h	5 h	4 h	4 h
Complete curing	10 days	10 days	7 days	7 days	7 days	7 days	5 days	5 days

N.B. The drying times and the overcoating intervals increase with higher thickness of the applied film. Always check that the existing painting film is perfectly dry before applying a further product coat. The surface must be superficially sanded if the overcoating interval is exceeded.

## Conditions during application

During application and curing:

Ambient temperature: minimum 10°C, maximum 35 °C.

Minimum substrate temperature 10 °C (if during the curing the temperature drops below 10 °C, overcoating will take additional time).

Avoid the formation of condensation, the surface temperature should be at least 3 °C above dew point.

Maximum relative humidity 85%.

Painting area should be well ventilated, during application and drying/curing.

## Storage

It is recommended to avoid exposure to air and extreme temperatures. To maximize the shelf life in the can, check that the container is closed during the storage and the temperature is between 5 °C and 35 °C.

Avoid exposure to direct sunlight.



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## Safety Rules

Comply with the provisions set by the local health and safety at work regulations. Avoid contact with the skin, operate in well-ventilated places and, if in closed areas, use vacuum cleaners, fans and air conveyors. During the application use appropriate PPE - Personal Protections Equipment (masks, gloves, glasses, etc.). Before using, read sections 7-8 of the SDS

### INSTRUCTIONS FOR THE DISPOSAL OF THE BIOCIDAL PRODUCTS AND PACKAGING

Empty packaging containing biocidal products: disposal of empty packaging according to the requirements of the waste disposal law, for example by taking them to the recycling centre. Packages containing the unused biocidal product: Dispose of the product not used in accordance with the law of disposal of such waste, for example by taking it to a recycling centre, recycling of packaging is prohibited in this case. Do not empty into drains or watercourses.

### INSTRUCTIONS FOR THE SAFETY SECURITY OF THE BIOCIDAL PRODUCTS AND PACKAGING

Empty containers and containers still containing the biocidal product: Packaging must be disposed of as hazardous waste under the full responsibility of the holder of such waste. Do not empty into drains or watercourses.

## Disclaimer

The values indicated in the present technical sheet can have slight variations from one batch to another. The applied product must not come in contact with water, chemicals or subjected to mechanical stress before the curing is complete. The wet film thickness refers to the undiluted product. In case of dilution, this value increases. The above information is the result of accurate laboratory tests and practical experience, however, since the product is predominantly used outside the manufacturer's control, Boero Bartolomeo S.p.A. can only guarantee their quality. The information contained in this sheet may be subject to revision by the Company. For clarification, updates or further information, it is recommended to contact Boero Bartolomeo S.p.A. directly. The present datasheet annuls and replaces every other precedent to this one.