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## PRODUCT DATA SHEET

**PRODUCT:** **ISOACRIL PF SL**  
**Acrylic-polyurethane primer-topcoat**

**CODE:** **COMP. A 162**  
**COMP. B 9100005 - CAT. POLIURETANICO ALIFATICO 05**

**PRODUCT DESCRIPTION:**

Two component anticorrosive primer-finishing of fully acrylic nature (100% acrylic). It has excellent adhesion to all metal substrates, hot dip galvanized surfaces, aluminum or other light alloys. It possesses high chemical resistance, hardness and flexibility, excellent wettability of the substrate, tolerates not optimal application conditions. The presence of zinc phosphate and corrosion inhibitors pigments allows a high protection against the anodic dissolution and the formation of rust. It is also used as an intermediate or tie coat on inorganic zinc in three- or more layer cycles and is also overcoatable after long period of time. Not suitable for contact with solvents. Being a one-coat product, also applicable at high thickness, it allows to considerably shorten the production time. With this product we limit the inconveniences caused by adverse climatic conditions, not properly prepared surfaces and speeds up time between coats. A layer of 80-100 microns ISOACRIL PF resists more than 500 hours in salt spray test; If this cycle is applied on zinc epoxy or inorganic test resistance goes up to 2000 hours.

**SURFACE PREPARATION:**

The better the preparation of the substrate, better and longer lasting will be the result. Completely remove everything that is not tight and compact, such as rust, old paint, contamination from dirt, grease etc. The product must be applied strictly on dry surfaces, clean, perfectly free of oil, grease, dust, moisture or other contaminants.

**APPLICATION METHODS:**

Spray, brush or roll. Preferred application is airless spray. Brush or roller don't grant an uniform coverage, use these techniques only on retouch or small surfaces.

**APPLICATION INSTRUCTIONS:**

	CONVENTIONAL SPRAY LOW PRESSURE PUMP	AIRLESS AIRMIX	
Nozzle diameter (mm)	<b>1,8÷2,2</b>	Pressure ratio	<b>15:1</b>
Product pressure (Atm)	<b>1,0÷1,7</b>	Nozzle diameter (inch)	<b>0,011÷0,019</b>
Air pressure	<b>2,5÷3,5</b>	Product pressure (Atm)	<b>60,0÷150,0</b>



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## TECHNICAL DATA:

	<b>Evaporation of the solvent and chemical reaction</b>
Mechanism of hardening	
Specific weight (kg / l) *	<b>1,24 (±8%)</b>
Volume solids (%) *	<b>52,6 (±1%)</b>
Medium dry film thickness (microns)	<b>80</b>
Correspondence wet film thickness (microns)	<b>152</b>
Yield to the average or recommended thickness (m <sup>2</sup> / kg) *	<b>5,5</b>
Consumption at the average or recommended thickness (Kg / m <sup>2</sup> ) *	<b>0,183</b>
Touch dry at 25 ° C (min)	<b>60</b>
Recoat time min. recommended 25 ° C (hours)	<b>n.p.</b>
Recoat time max. recommended 25 ° C (days)	<b>n.p.</b>
Hard dry at 25 ° C (days)	<b>1</b>
Recommended application temperature (° C)	<b>+5 ~ +40</b>
Maximum operating temperature (° C)	<b>105</b>
Pot life at 25 ° (hours)	<b>6</b>
Mixing ratio by weight	<b>20%</b>
Thinner	<b>6060020 6060010</b>
Aspect of the film	<b>semigloss</b>
Color	<b>On request</b>
Storage in suitable conditions (months)	<b>12</b>

N.B.

\* Data referred to colour white. The solid content values, specific weight and yield were calculated with theoretical method. Thickness and performance are indicative, in fact vary greatly depending condition of substrate, absorption, porosity, surface irregularities and application method. Data referred to the mixture of component A + 20% by weight of Comp.B



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#### **ADDITIONAL INFORMATION:**

This is a two-component product. Before mixing the two components it is recommended to homogenize the component possibly with agitator and shake vigorously, possibly without opening, the packaging of component b. After mixing and addition of appropriate thinner, agitation should be continued until it became homogeneous. In order to use the correct mix ratio, necessary to obtain the best results, we recommend to catalyse only entire packs. In case you want to use only a portion of the pack, you should equip with adequate precision scale for catalysis by weight and appropriate sized containers for catalysis by volume. The pot life (time of use after catalysis) is significantly reduced by increase of temperature. The ideal temperature for application is between 5° C and 30° c. The temperature of the surface to be treated must be at least 3° C higher than dew point. If this condition is not met the resulting condensation, not always visible, may easily lead to phenomena of non-adherence. The coating requires a period of 7-8 days at 25° C for complete curing. The product is recoatable at any time with itself or with acrylic products, while after drying is overcoated with most of the coating products. Carefully remove any accumulated roughness prior to the application of subsequent coats. It is recommended to implement all necessary measures (development of equipment for painting, using any thinner retardant-wetting thinner, position yourself upwind, proper progression of the surfaces to be painted) to prevent the accumulation of dust coating, which often causes inhomogeneity of the film.

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#### **IMPORTANT NOTE**

All information contained in this form are the result of laboratory tests carried out under controlled conditions and well-defined and / or correspond to our most advanced and current technical and practical knowledge. this does not exempt the customer, given the variability of environmental conditions and personal systems of application, from carrying out their own investigations and to make their own eligibility checks. Mondial Color assumes no responsibility for any damage caused by improper use of the product. The values of specific weight, solids by volume and yields were calculated by theoretical methods. This sheet supersedes the previous editions.

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