

CARAPAX PI

Moisture hardening polyurethane primer, heavy-metal free

Product code	SIS CP 20 102BC 00	Updated	03.04.2014
TDS code	TDS CP 102-EN	Issued by	OS
TDS date	FEB. 2003		

PRODUCT DESCRIPTION

Carapax PI is a single-component, moisture-hardening polyurethane primer for the short-term corrosion protection of steel parts, swept pot galvanizing and constructions that are to be welded.

Advantages: no toxic steams narrow consumption zone no impact on the quality of the weld seam

BINDING AGENT

Moisture hardening polyisocyanate

PIGMENTS

Organic- and anorganic colour pigmentation, phosphates, filling materials

SOLVENTS

Aromatic hydrocarbons and acetates

FIELDS OF APPLICATION

Steel construction, construction of vehicles, apparatus engineering etc.

SURFACE PRE-TREATMENT

1. Removal of contaminations before sand blasting; Remove oil and grease residues with solvent or emulsifying agent solutions.
 - Remove salt residues with a brush or by steam vapour.
2. Mechanical roughening; preparation by sand blasting (Sa 2 ½)

COATING RECOMMENDATIONS

For Coropur PI the following intermediate or cover coatings are suitable:

- Carapax Ferro
- Carapax Cover RAL
- Carapax Non Abrasiv
- Carapax TAR 21

APPLICATION METHODS

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

APPLICATION CONDITIONS

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

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 m Pas

THINNER

Thinner A-851 Rolling
Thinner T 1900 Spraying
Quantity of admixture of thinners depends on ambient temperature and type of processing.

AIR SPRAYING

Pressure: 3 - 4 bar
Nozzle: 1,5 - 2,0 mm
Thinner: 10 - 15 % T 1900

AIRLESS SPRAYING

Pressure: 120 - 150 bar
Nozzle: 0,4 - 0,5 mm
Thinner: 0 - 5 % T 1900

CLEANING OF EQUIPMENT

Thinner A 851 or Thinner T 1900

DRYING

- | | | |
|---------------------------|----------------------|---------------------|
| » 60 µm DFT | 20°C/75 % r.H | 5°C/75 % r.H |
| » dust dry after: | 15 minutes | 20 minutes |
| » fast to handling after: | 25 minutes | 40 minutes |
| » overcoat able 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 Carapax PI

2 x 120 µm Carapax 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

1,43 g/cm³

SOLIDS

72 % weight

56 % volume

MATERIAL CONSUMPTION

- | | | |
|------------------|----------------------|----------------------|
| » Carapax PI | 60 µm DFT | 120 µm DFT |
| » Theoretically: | 153 g/m ² | 306 g/m ² |
| » Practically: | 306 g/m ² | 612 g/m ² |

AVAILABLE IN CANS OF

1,2 / 6 / 12 kg net

COLOUR

grey

V.O.C.

396 g/l

UN-NO.

1263

RID/ADR/SDR/ ZIFFERN

No product of class 3

FLASH POINT

+ 28°C

Please pass this data sheet on to the person in charge of the coating. 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 any changes in the meantime. In case of further questions, please contact one of our technical advisors for detailed information.