

Technical Data Sheet

EPOXY PRIMER

Anti-Corrosion Epoxy Primer

PROPERTIES

- Designed and dedicated for the refinishing of classic cars
- High solids content
- Suitable for application in thick layers
- Suitable for application on very coarse substrates, e.g. abrasive-blasted steel
- Excellent adhesion to suitably pretreated metal substrates
- Provides very good anti-corrosion protection and chemical resistance



RELATED PRODUCTS

EPOXY PRIMER
HARDENER

Hardener for the epoxy primer

EPOXY THINNER

Epoxy thinner

DESCRIPTION

A latest-generation VHS primer based on high-quality epoxy resin with corrosion inhibitors. The product provides anti-corrosion barrier and protection (from the epoxy resin and the inhibitors, respectively) essential for the refinishing of classic cars. A specially selected composition of epoxy resins and ball-ground mineral fillers provides a very smooth surface in cream beige with a subdued gloss to improve the identification of locations which require sculpting.

The EPOXY PRIMER guarantees correct protection of substrates left highly porous by sanding or power cleaning, with a texture resulting in different layer builds, where a barrier formula might not be sufficient.

SUBSTRATES	
Steel	<p>ABRASIVE BLASTING Clean the steel to Sa 2^{1/2}. The surface should be dry and free of oils, grease, dust, loose old coatings, milling scale, rust and foreign bodies. The surface should exhibit a bare metallic gloss. Following this cleaning method, use a rotary or eccentric grinder with P80 - P120 grit paper. Blow off all dust from the clean steel surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p> <p>POWER CLEANING Use a rotary or eccentric grinder with P80 - P120 grit paper. Blow off all dust from the clean steel surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p> <p>HIGH-PRESSURE WATER CLEANING OF COATINGS After this pretreatment, the substrate should be completely dry, free from oil, grease, loose old coatings, milling scale, rust and foreign bodies. Following the high-pressure water cleaning, use a rotary or eccentric grinder with P80 - P120 grit paper. Blow off all dust from the clean steel surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p>
E-coated workpieces	<p>Verify that the e-coat is present on the substrate by doing a solvent effect test. Degrease twice with the SILICONE REMOVER.</p>
BODYWORK PRIMER	<p>The cured BODYWORK PRIMER (72h at 20°C after the last layer application) needs to be degreased twice with the SILICONE REMOVER.</p>
Aluminium – new parts and body panelling	<p>Degrease with the SILICONE REMOVER and matt with red abrasive cloth. Blow off all dust and degrease again.</p>
Aluminium – body parts for refinishing	<p>POWER CLEANING Use a rotary or eccentric grinder with the following paper grit size: - rough: P80 - P180 - finish: P220 - P240 Blow off all dust from the clean aluminium surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p> <p>HIGH-PRESSURE WATER CLEANING OF COATINGS The substrate should be completely dry, free from oil, grease, loose old coatings, milling scale, rust and foreign bodies. Following this cleaning method, use an eccentric grinder with P220 - P240 grit paper or red abrasive cloth. Blow off all dust from the clean aluminium surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p>
All NfCC polyester fillers/putties	<p>Finish by dry sanding with P220 - P320 grit paper. Follow by blowing off all dust, degrease with the SILICONE REMOVER and blow off all dust again.</p>
Old polyester laminates	<p>Verify that the surface is free of cracks. Sand with P180 ÷ P240 paper, degrease with the SILICONE REMOVER and blow off all dust again.</p>

Existing coatings	Finish by dry sanding with P220 - P320 grit paper.		
MIXING RATIO			
	EPOXY PRIMER HARDENER EPOXY THINNER	Volume ratio	Weight ratio [g]
		3 1 20%	100 20 11
<p>Apply the thinner at the ratio calculated for Component A (the EPOXY PRIMER).</p> <p>It is very important to precisely dose each component to obtain a primer with suitable performance parameters. It is good practice to mix the primer with the hardener, followed by addition of the thinner and mixing all three components again. Having finished dosing, seal the filler, hardener and epoxy thinner containers tight.</p>			
SPRAY VISCOSITY			
	DIN 4/20°C	28 - 33 s	
APPLICATION			
	Spray nozzle	1.8 mm	
	Follow the tool manufacturer's guidelines.	Spray tool input pressure	1.7 - 2.2 bar
	Number of layers	2 - 3	
	Single layer application method	Outward surfaces: apply partially (80÷90% of the full layer). Inward and confined locations: apply in full layer.	
	Single dry layer thickness	40 - 60 µm	
	The actual yield depends on the surface shape, roughness and application parameters.	Ready for use (RFU) mixture yield for 80 µm dry film thickness	approx. 8.0 m ² /l

	Mixture life at 20°C	2 h	
	Flash-off time between layers at 20°C	15 - 20 min	
	Use of the correct PPE is recommended!		
CURING TIME			
	Time to sand for 130 µm dry film thickness	20°C	60°C
		24 h	45 min + 3 h/20°C
The curing time is specified for the body workpiece temperature and not the air temperature!			
IR DRYING			
	15 - 25 min		
A short-wave IR lamp is recommended. Follow the recommendations of the equipment manufacturer! Start IR heating after at least 25 min after applying the last layer.			
SANDING			
	Dry sanding	Before application of fillers/putties:	Claret abrasive cloth
		Before application of acrylic primer/fillers:	P240 - P320
VOC CONTENT			
VOC II/B/c limit*	540 g/l		
Actual VOC	360 g/l		
* For a ready for use (RFU) mixture acc. to EU Directive 2004/42/CE.			
APPLICATION CONDITIONS			
It is recommended to apply the filler over 15°C and at a humidity of 80%. The substrate temperature during application of the EPOXY PRIMER must be at least 3°C higher than the dew point.			



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COLOUR	
Beige.	
EQUIPMENT CLEANING	
EPOXY THINNER. NC solvent.	
STORAGE CONDITIONS	
Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
EPOXY PRIMER	24 months/20°C
EPOXY PRIMER HARDENER	24 months/20°C
EPOXY THINNER	24 months/20°C
SAFETY	
See the Safety Data Sheet.	
OTHER INFORMATION	
<p>The effectiveness of our systems results from research in the laboratory and many years of experience. The data contained here meets the current knowledge about our products and their application potential.</p> <p>We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potential for varying reactions with different materials.</p> <p>We cannot be held liable for defects where the final results were affected by factors beyond our control.</p> <p>This TDS supersedes all its previous issues.</p> <p>Registration number: 000024104.</p>	



RFU	EPOXY PRIMER	EPOXY PRIMER HARDENER	EPOXY THINNER
0.10 L	106 g	21 g	11 g
0.15 L	159 g	32 g	17 g
0.20 L	211 g	42 g	22 g
0.25 L	264 g	53 g	28 g
0.30 L	317 g	63 g	33 g
0.40 L	423 g	84 g	44 g
0.50 L	529 g	106 g	56 g
0.75 L	793 g	159 g	83 g
1.00 L	1057 g	211 g	111 g
2.00 L	2114 g	422 g	222 g