

Technical Data Sheet

EPOXY PRIMER SPRAY 2K

Anti-Corrosion Epoxy Primer

PROPERTIES


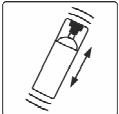
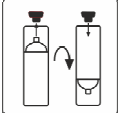
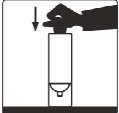
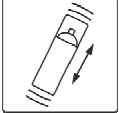
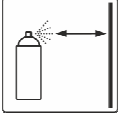

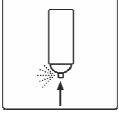
- A product developed and dedicated for spot anti-corrosion protection
- Ensures constant spray pressure until emptying the can and professional application of protection
- Suitable for very rough surfaces such as abrasively blasted steel
- Excellent adhesion to suitably pretreated metal surfaces
- Very good anti-corrosion protection chemical resistance






DESCRIPTION

A latest-generation two-component VHS primer based on high-quality epoxy resin with corrosion inhibitors in a 2K spray can. The product provides an anti-corrosion barrier and protection (from the epoxy resin and the inhibitors, respectively) essential for spot refinishing of classic cars and motorcycles. A specially selected composition of epoxy resins and ball-ground mineral fillers provides a very smooth surface in creamy beige with a subdued gloss to improve the identification of locations which require sculpting. The EPOXY PRIMER SPRAY 2K ensures constant spray pressure until emptying the can and professional application of protection on 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. If needed, sand with a rotary or eccentric sander and P80 to P120 grit sandpaper. 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 sander with P80 to 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 sander with P80 to 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	Determine if the workpiece surface is e-coated by performing a solvent test. Degrease twice with the SILICONE REMOVER.
BODYWORK PRIMER	The cured BODYWORK PRIMER (72h at 20°C after the last layer application) needs to be degreased twice with the SILICONE REMOVER.
Aluminium – new parts and body panelling	Degrease with the SILICONE REMOVER and matt with red abrasive cloth. Blow off all dust and degrease again.
Aluminium – body parts for refinishing	<p>POWER CLEANING Use a rotary or eccentric sander with the following paper grit size: - rough: P80 to P180 - finish: P220 to P240 Blow off dust from the clean aluminium, 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 sander with P220 to P240 grit paper or red abrasive cloth. Blow off all dust from the clean aluminium surface, degrease twice with the SILICONE REMOVER and blow off all dust again.</p>
All NfCC polyester fillers/putties	Finish by dry sanding with P220 to P320 grit paper. Follow by blowing off all dust, degrease with the SILICONE REMOVER, and blow off all dust again.

Old polyester laminates	Verify that the surface is free of cracks. Sand with P180 ÷ P240 paper, degrease with the SILICONE REMOVER and blow off all dust again.
Existing coatings	Finish by dry sanding with P220 to P320 grit paper.
PROCEDURE	
	Degrease and sand the surface prepared as directed to above.
	Shake the can for 2 min.
	Remove the button from the cap, turn the can upside down and install the removed button in the can base.
	To activate, do not remove the cap. Place the can on a firm surface and press the installed button down to release the hardener into the spray can.
	Shake the can for 2 min to mix the components. The pot life of the resulting mixture in the can is 6 h maximum at 20°C.
	Application: keep a distance of 15–20 cm.
	Number of layers: 2 to 3 The flash-off time between layers at 20°C is 5 – 10 min. Single layer DFT: 25÷50 µm maximum.
	Turn the can bottom up and press the spray valve for 5 s to purge clean.
Single container yield for 100 µm of film thickness: approx. 0.75 m ² .	

CURING TIME			
	Time to sand for 100 µm DFT	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/e limit*	840 g/l		
Actual VOC	706 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 SPRAY 2K must be at least 3°C higher than the dew point.			
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.			



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Technical Data Sheet
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SHELF LIFE	
EPOXY PRIMER SPRAY 2K	18 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>	