

Technical Data Sheet

# **HYBRID EPOXY PRIMER – FILLER**

Multifunctional Epoxy Primer – Filling Version

## **PROPERTIES**

- Designed and dedicated for the refinishing of classic cars
- Excellent dry hand and machine sanding
- Very smooth surface



## **RELATED PRODUCTS**

HYBRID FILLER HARDENER

Filler hardener for the HYBRID EPOXY PRIMER

EPOXY THINNER







Epoxy thinner





## **DESCRIPTION**

The latest generation epoxy primer, which can be an anti-corrosion primer, an isolating primer or a filler depending on the hardener used. Anti-corrosion protection is ensured by the high barrier properties of the epoxy resin and the protective effect of corrosion inhibitors.

The HYBRID EPOXY PRIMER with the HYBRID FILLER HARDENER is intended for the final stage of substrate preparation for the application of decorative coatings. The filler does not clog sandpaper, which makes it very easy to dry sand for a high quality finish.

<b>SUBSTRATES</b>	
Steel – new parts and body panelling	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Electrogalvanized steel – new parts and body panelling	Pretreat as specified in the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Bare and electrogalvanized steel – body parts for refinishing	Pretreat as specified in the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Aluminium – new parts and body panelling	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
Aluminium – body parts for refinishing	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
E-coated workpieces	E-coated workpieces do not require sanding prior to the application of the primer. Degrease twice with the SILICONE REMOVER. Verify that the e-coat is present on the substrate by doing a solvent effect test.
BODYWORK PRIMER	Pretreat as specified in the EPOXY PRIMER TDS or the HYBRID EPOXY PRIMER – ANTI-CORROSION TDS. Coat with the EPOXY PRIMER or the HYBRID EPOXY PRIMER – ANTI-CORROSION.
HYBRID EPOXY PRIMER – ANTI-CORROSION	The chemical activity life is up to 7 days at 20°C without matting. The recommended time to recoating is 24h at 20°C If necessary, dry sand with a red abrasive needled cloth or P220 - P320 grit paper. Blow off all dust and degrease with the SILICONE REMOVER.
EPOXY PRIMER	After 24 h at 20°C, dry sand with a red abrasive needled cloth or P220 - P320 grit paper. Blow off all dust and degrease with the SILICONE REMOVER.
All NfCC polyester fillers/putties	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.
Existing coatings	Finish by dry sanding with P220 - P320 grit paper.
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.

MIXING RATIO			
		Volume ratio	Weight ratio
	HYBRID EPOXY PRIMER	4	100
	HYBRID FILLER HARDENER EPOXY THINNER	1 0 - 10%	16.5 0 - 6.5
SPRAY VISCOSITY			
	DIN 4/20°C	20 - 30 s	
VOC CONTENT			
VOC II/B/c limit*		540 g/l	
Actual VOC for mixing ratio 4:1+10%		485 g/l	
* For a ready for use (RFU) mixture acc. to EU Directive 2004/42/CE.			
APPLICATION			
	Spray nozzle	1.6 - 1.8 mm	
	Follow the tool manufacturer's guidelines	Spray tool input pressure	1.8 - 2.2 bar
	Number of layers	2 - 3	
	Single dry layer thickness	30 - 70 µm	
	Ready for use mixture yield for 100 µm dry film thickness	approx. 4.2 m <sup>2</sup> /l	
	The actual yield depends on the surface shape, roughness and application parameters.		
	Mixture life at 20°C	2 h	
	Flash-off time between layers at 20°C	10 min	

CURING TIMES		
	20°C	60°C
	6 h	30 min
The curing times apply to the temperature of the individual body parts.		
IR DRYING		
	10 - 20 min	
<p>A short-wave IR lamp is recommended.</p> <p>Follow the recommendations of the equipment manufacturer!</p> <p>Start IR heating after at least 20 min after applying the last layer.</p> <p>NOTE: Do not use IR lamps if the preceding layers have not been cured properly or additionally cured with an IR lamp.</p>		
SANDING		
	<p>Step 1: Apply the Control Powder or CONTROL SPRAY</p> <p>Step 2: Rough sand with a hand sanding block or an orbital/eccentric sander and P280 - P320 grit paper</p>	
	<p>Step 3: Blow off all dust and apply the Control Powder or CONTROL SPRAY</p> <p>Step 4: Finish sanding (process the edges by hand) using an orbital/eccentric sander and P400 - P500 grit paper</p>	
APPLICATION CONDITIONS		
<p>It is recommended to apply the filler over 15°C and at a humidity of 80%. The substrate temperature during application of the filler must be at least 3°C higher than the dew point to avoid condensation and its absorption by the polyester material.</p>		
COLOUR		
Grey		
EQUIPMENT CLEANING		
EPOXY THINNER or NC solvent.		
STORAGE CONDITIONS		
<p>Store in a dry and cool room, away from sources of fire and heat.</p> <p>Avoid direct exposure to sunlight.</p>		



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<b>SHELF LIFE</b>	
HYBRID EPOXY PRIMER	24 months/20°C
HYBRID FILLER HARDENER	24 months/20°C
EPOXY THINNER	24 months/20°C
<b>SAFETY</b>	
See the Safety Data Sheet.	
<b>OTHER INFORMATION</b>	
<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.</p>	
<p>Having finished dosing, seal the primer, hardener and thinner containers tight.</p>	
<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. 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. We cannot be held liable for defects where the final results were affected by factors beyond our control. Registration number: 000024104.</p>	



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HYBRID EPOXY PRIMER – FILLER – thinner-free version		
RFU	HYBRID EPOXY PRIMER	HYBRID FILLER HARDENER
0.10 L	109 g	18 g
0.15 L	163 g	27 g
0.20 L	218 g	36 g
0.25 L	272 g	45 g
0.30 L	327 g	54 g
0.40 L	436 g	72 g
0.50 L	544 g	90 g
0.75 L	817 g	135 g
1.00 L	1089 g	180 g
2.00 L	2178 g	359 g



# HYBRID EPOXY PRIMER – FILLER

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HYBRID EPOXY PRIMER – FILLER – added thinner version			
RFU	HYBRID EPOXY PRIMER	HYBRID FILLER HARDENER	EPOXY THINNER 10%
0.10 L	101 g	17 g	6 g
0.15 L	151 g	25 g	10 g
0.20 L	202 g	33 g	13 g
0.25 L	252 g	42 g	16 g
0.30 L	302 g	50 g	19 g
0.40 L	403 g	66 g	25 g
0.50 L	504 g	83 g	32 g
0.75 L	756 g	125 g	47 g
1.00 L	1008 g	166 g	63 g
2.00 L	2016 g	333 g	126 g