

Technical data sheet

# **ARMORPRIMER EP 2000-20**

**Epoxy primer**

Thick epoxy anti-corrosion primer hardened with amine adduct

## **RELATED PRODUCTS**

**ARMORHARDENER EP 200-20**





Hardener for epoxy primer

**ARMORTHIN EP 20-01**

Thinner for epoxy primer





- **USE:**

- Military vehicles
- Military equipment

SUBSTRATES				
Steel	Clean steel surfaces until reaching Sa 21/2 (wet blasting) or St3 (manual cleaning or using a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free from oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.			
Old paint coatings	Degrease and dry sand paper P220 – 360.			
Polyester putties	Dry sand, for final sanding P240 ÷ P320.			
Galvanised steel, Aluminium	In order to produce a coarse substrate, use light abrasive blasting with round non-metallic abrasive grains or sand with P240 to P320 and then degrease.			
Stainless steel	Degrease and mat with sand paper P240 – 320. Degrease again.			
Polyester laminates	Dry sand P280, degrease again.			
MIXING RATIO				
	ARMORPRIMER EP 2000-20 ARMORHARDENER EP 200-20 ARMORTHIN EP 20-01	Volume ratio	Weight ratio	
		4	100	
		1	16	
	15%	8		
Apply the thinner in the amount calculated for the primer.				
VISCOSITY				
	DIN 4/20°C	30 ÷ 60 s		
APPLICATION				
 <p><b>CAUTION:</b> Instructions of the equipment manufacturer must be followed.</p>		Nozzle	Pressure	Distance
	Pneumatic spraying	1.8 ÷ 2.2 mm	3 ÷ 4 bar	15 ÷ 20 cm
	Airless spraying in air jacket	0.38 ÷ 0.43 mm (0.015" ÷ 0.017 ")	100 ÷ 160 bar Air jacket 2 bar,	10 ÷ 15 cm
	Brush, roller	Acceptable for spot repairs and painting small areas.		
	Number of layers	1 - 2		
	CAUTION: The minimum epoxy primer thickness is 80 µm on steel substrates and the maximum thickness should not be greater than 160 µm.			
	Single dry layer thickness.	80 µm		
	Yield of the ready to apply mixture for a dry layer thickness in the provided range	approx 7.3 m <sup>2</sup> /l 0.14 l/ m <sup>2</sup> at 80 µm ARMORPRIMER EP2000-20 + ARMORHARDENER EP200-20 (4+1)		
	The actual yield depends on the surface shape, roughness and application parameters.			

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	Mixture life at 20°C	4 hours		
	Flash off between layers, time to apply the next layer of primer	Pneumatic, airless spraying	Brush, roller	
		15 ÷ 20 min	2 hours	
<b>CURING TIME</b>				
	Time to sand. For the max. dry coating thickness of 120 µm.	10°C	20°C	60°C
		48 hours	24 hours	1 hour
<b>SANDING</b>				
	Dry sanding	P240 ÷ P500		
<b>COATABILITY</b>				
Topcoat application time at primer thickness:	10°C	20°C	60°C	
80µm	18 hours	3 hours	45 min.	
160µm	24 hours	5 hours	60 min.	
Coatable by ARMORTOPCOAT PU 1000-10 topcoat: green 6031, brown 8027, black 9021. The maximum coating time without mating is 48 hours.				
<b>TECHNICAL DATA</b>				
Product	Solids content by weight	Solids content by volume	Density	Fineness of grind
ARMORPRIMER EP 2000-20	≈ 76 %	≈ 58 %	≈ 1.57 g/cm <sup>3</sup>	< 25µm
ARMORHARDENER EP 200-20	≈ 68%	≈ 65%	≈ 0.92 g/cm <sup>3</sup>	—
ARMORPRIMER EP 2000-20 + ARMORHARDENER EP 200-20 (4+1)	≈ 74%	≈ 59%	≈ 1.44 g/cm <sup>3</sup>	< 25µm
<b>CONTENT OF VOLATILE ORGANIC COMPOUNDS</b>				
VOC II/B/c limit*		540 g/l		
Actual VOC content		460 g/l (for 4+1+15%)		
* For the ready to apply mixture compliant with Directive UE 2004/42/CE				
<b>COLOUR MATCHING</b>				
Not recommended.				

<b>APPLICATION OF PRIMER ON EXISTING SINGLE-COMPONENT COATINGS *</b>	
It is recommended to apply ARMORPRIMER EP 2000-20 primer in a thin layer and then heat the coating for 30 min at 60°C or extend the application time between successive layers.	
* Single-component coatings: alkyd, acrylic, polyvinyl, chlorinated rubber.	
<b>APPLICATION CONDITIONS</b>	
The coated surface should be dry. The temperature of the coat, coated surface and environment should be between +10°C and +35°C at a maximum relative humidity of 80%. The coated surface temperature should exceed the dew point by a minimum of 3°C.	
<b>TEMPERATURE RESISTANCE</b>	
The operating temperature of the applied primer is between -60°C and +80°C. Transient temperatures up to +120°C maximum are permitted.	
<b>COLOR</b>	
Grey	
<b>EQUIPMENT CLEANING</b>	
Thinner for epoxy primer: ARMORTHIN EP 20-01.	
<b>STORAGE CONDITIONS</b>	
Store in a dry room, away from sources of flame and heat. Avoid direct exposure to sunlight. Recommended storage temperature: +5°C to +35°C.	
<b>SHELF LIFE *</b>	
ARMORPRIMER EP 2000-20	24 months/20 °C
ARMORHARDENER EP 200-20	24 months/20 °C
ARMORTHIN EP 20-01	24 months/20 °C
* In original sealed packaging	
<b>SAFETY</b>	
See Safety Data Sheet.	
<b>OTHER INFORMATIONS</b>	
Registration number: 000024104.	
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein 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 do a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.	