














1/2	Category	Epoxy primer 2K			
	TDS number	NO-21-13	Registration number	000024104	
	SDS number	SDS_NO_2_04	Date of issue	10.08.2023	

EPO PRIMER 3000

MULTIFUNCTIONAL EPOXY PRIMER

PROPERTIES	TYPE ANTICORROSIVE ISOLATING WET-ON-WET	DESCRIPTION: Multifunctional epoxy primer dedicated for anticorrosive protection of steel, galvanized steel and aluminum body parts. It can be used for isolating substrates before applying polyester putties, as well as wet on wet primer before next layers. Due to special resins, primer is ready to sand in short time. There is possibility to apply polyester putties over one layer of epoxy primer in very short time. It is allowed to apply three layers without flash-off.
	HARDENER HARD 90-300	
SUBSTRATES	GENERAL RULE	Before sanding degrease with silicone remover PLUS 780/PLUS 70-780 After sanding blow out dust with compressed air Degrease again with silicone remover PLUS 780/PLUS 70-780
	OLD PAINT COATINGS	Dry sanding P220 – P360
	POLYESTER PUTTIES	Dry sanding. Final sanding P240 – P320
	POLYESTER LAMINATES	Dry sanding P280
	STEEL	Dry sanding P120
	GALVANIZED STEEL	Dry sanding P280-P360 or mat with an abrasive finishing pad
	ALUMINUM	Dry sanding P280-P360 or mat with an abrasive finishing pad
	OEM CATAPHORETIC PRIMER	Degrease with PLUS 780/PLUS 70-780
	PLASTICS	See instruction „Type of plastics and technology of painting plastics”
COATABILITY		Polyester putty 2K acrylic filler SPECTRAL 2K SPECTRAL WAVE 2.0 SPECTRAL BASE 2.0 2K polyurethane topcoat 2k acrylic topcoat Waterborne basecoat Solventborne basecoat

1/2		ISOLATING VERSION		WET ON WET VERSION		
		VOLUME	WEIGHT	VOLUME	WEIGHT	
		EPO PRIMER 3000	1	100 g	1	100 g
		HARD 90-300	1	56 g	1	56 g
VOC	VOC II/B/c limit * = 540 g/l * for ready to use mixture acc. to UE Directive 2004/42/CE		VOC content: 539 g/l		VOC content: 539 g/l	
APPLICATION		Viscosity DIN 4 at 20°C	14 - 15 s		14 - 15 s	
	 Follow the equipment manufacture's guidelines	Nozzle	Ø 1.2 - 1.4 mm		Ø 1.2 - 1.4 mm	
		Pressure	1.7 - 2.2 bar		1.7 - 2.2 bar	
		No of coats	1 - 3		1	
		Flash off time depends on spray booth	0 - 10 min / 20°C		-	
		Potlife at 20°C	6 hours		6 hours	
		Applying putty on one layer of EPO PRIMER 3000	SLEEK 100 DART 500	60 min		-
HYBRYD 200 CARBON 300			90 min		-	
	Single dry coat thickness		20 - 25 µm Min. 60µm of dry film thickness for optimal anticorrosive properties.		20 - 25 µm	
	Theoretical yield for one layer		13 - 16 m²/l		13 - 16 m²/l	
SANDING		Dry sanding	P360-P500		WITHOUT SANDING	
		Wet sanding	P600-P1000			
DRYING TIME	At 60 µm layer		20°C	60°C	20-25 min / 20°C Flash off time before basecoat/topcoat	
		HARD 90-300	3 hours	25 min		
		10 - 15 min SHORT WAVES	Heating 10 min after final layer distance 50 - 70 cm temp. max. 90°C		Non sanding application up to 12 hours / 20°C	
CAUTION		USE PERSONAL SAFETY EQUIPMENT	SEE SAFETY DATA SHEED SEE GENERAL CONDITIONS FOR PROFESSIONAL USE		SHELF LIFE	
					EPO PRIMER 3000 24 months /20°C	HARD 90-300 24 months /20°C