

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

ANTICORROSION Epoxy Primer 4:1



PRODUCTS

Anticorrosion Epoxy Primer 4:1
Hardener 1:4 for Anticorrosion Epoxy Primer
Thinner for epoxy products

PRODUCT DESCRIPTION

2K epoxy primer with anti-corrosion additives. Perfectly protects steel surfaces from corrosion during car repairs. When thinned well may be applied wet on wet.

- ✓ Excellent protection of steel surfaces.
- ✓ Very good adhesion to various surfaces.
- ✓ Easy to mix and apply.
- ✓ Exceptional vertical stability.

Color - Light grey.
Gloss Grade – Matt.

VOLATILE ORGANIC COMPOUNDS

V.O.C.= 382 [g/l] (4:1+10%)

V.O.C.= 430 [g/l] (4:1+25%)

V.O.C.= 498 [g/l] (4:1+50%)

The share of VOC is below 540 g/l. These products meet the EU directive (2004/42/EC) that sets the VOC value for its category (IIB), at 540 g/l.

SURFACE PREPARATION

Anticorrosion Epoxy Primer can be applied over:

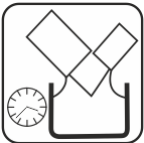

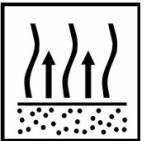



- ✓ Bare steel and aluminum after flatting and degreasing.
- ✓ Zinc coated steel, galvanized steel after flatting and degreasing.
- ✓ Glass polyester laminates (GFK/GRP).
- ✓ 2K polyester putties.
- ✓ 2K epoxy fillers.
- ✓ Old finishes in good condition after flatting and degreasing.


Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended:

- by hand (dry or wet): P280÷P320 (GRP P400),
- by machine (dry): P180÷P220.

APPLICATION PROCESS

	<p>USE For car repairs as a filling primer or isolation primer, for sending or wet wet.</p>
	<p>Mixing ratio by volume</p> <p>Primer 4 parts Hardener 1 part Thinner 15÷25%</p> <p>Stir thoroughly until achieving homogenous mixture.</p>
	<p>Spraying viscosity 55÷60 seconds at 20°C with 15% of thinner. 30÷35 seconds at 20 with 25% of thinner.</p>

	<p>Pot life approx. 3 hours at 20°C</p>
	<p>Number of layers 2÷3 layers; Recommended layer thickness for isolation primer: 50÷70µm dry film. Recommended layer thickness for filling primer, for sending: 200÷250µm dry film.</p> <p>Parameters for RP spray gun Nozzle: 1,6÷2,0 mm; Pressure : 2,0-2,2 bar.</p> <p>Parameters for HVLP spray gun Nozzle: 1,5÷1,9 mm; pressure inside the nozzle: 2,0 bar.</p>
	<p>Evaporation time Between layers: 5÷10 minutes Before baking: approx.10 minutes Before applying clear coat (wet on wet)): 60÷120 min.</p> <p>Evaporation time depends on temperature and film thickness.</p>
	<p>Hardening time Approx. 8 hours at 20°C (depending on the layer thickness) Approx. 45 minutes at 60°C (depending on the layer thickness)</p> <p>Temperature below 20°C significantly increases the hardening time.</p>
	<p>IR Drying 17÷22 minutes under short wave for thickness 150÷200µm</p> <p>Drying time may change depending on the type of heater.</p>
	<p>Dry Sanding: Machine sanding: P360÷P500. Hand sanding: P280÷P320.</p>

	Wet Sanding: Hand Sanding: P600÷P800.
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FURTHER WORK

2K epoxy primers can be directly over coated with:

- ✓ 2K polyester body fillers
- ✓ 2K epoxy body fillers.
- ✓ 2K acrylic fillers.
- ✓ 2K acryl top coats.
- ✓ 1K base coats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- ✓ Clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.
- ✓ The product cannot be applied over wash primers and 1K primers

Note: After each use the container with products should be immediately closed! Protect the hardener against freeze and humidity!

STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: After each use the container with products should be immediately closed! Protect the hardener against frost and humidity!

WARRANTY PERIOD

Anticorrosion Epoxy Primer 4:1- 12 months from the date of Manufacture.

Hardener 1:4 for Anticorrosion Epoxy Primer – 12 months from the date of Manufacture.

Important Information:

The information contained in this document corresponds to our present knowledge and is a guide to our products and their uses.

Read all directions and warnings prior to using Troton products - Safety Data Sheets can be found online at www.troton.com.pl or will be sent according to your request: troton@troton.com.pl

Technical Information: The technical information, recommendations and other statements contained in this document are based upon tests or experience that Troton believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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If used as instructed, this product is designed to comply with the European Volatile Organic Compound (VOC) Emission Standard for Automotive Refinish Coatings. Confirm compliance with your country, state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Troton assumes no obligation or liability for use of this information.