

TECHNICAL DATA SHEET

**Epoxy primer EPOXIDE
1+1**



Epoxy primer 1+1 perfectly protects steel surfaces thanks to high quality resins and active anti corrosion additives. It is designated for renovating passenger cars as well as for intensely utilized trucks or buses. This primer has excellent adhesion to various ground types and perfect isolation properties. It can be directly covered with top coats.

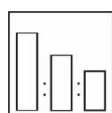
GROUND TYPES

- ◆ old paint coats including thermoplastic paints,
- ◆ polyester putties,
- ◆ steel,
- ◆ aluminium,
- ◆ galvanized steel,
- ◆ stainless steel,
- ◆ polyester laminates.

SURFACE PREPARATION

- ◆ old paint coats should be degreased and sanded with P220 - P360 paper,
- ◆ polyester putties should be dry sanded for final smoothing with P240 – P320 paper,
- ◆ steel surfaces should be degreased and sanded with P120 - P240 paper,
- ◆ aluminium surfaces should be degreased and matted with abrasive needled cloth, and degreased again,
- ◆ galvanized surfaces should be degreased, matted with very fine abrasive needled cloth and degreased again,
- ◆ stainless steel should be degreased,
- ◆ polyester laminates should be degreased and sanded with P280 paper.

MIXING RATIO



Primer
Hardener
Thinner

By volume

1
1

By weight

100
56

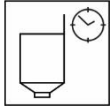
ATTENTION! Pot life when mixed with hardener is about 4 hours/20°C.

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INSTRUCTION FOR USE:

Apply two or three single wet layers leaving them for evaporation for 5-10 minutes after each application. Evaporation time depends on temperature and thickness of the layer. 10 minutes after the application of the last layer the coat can be cured in higher temperature.

SPRAYING VISCOSITY



DIN 4/20°C about 18÷20 s

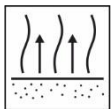
NOZZLE, WORKING PRESSURE



Ø 1,2÷1,5 mm, 3÷4 bar

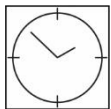
ATTENTION! Single layer thickness about 50 – 60 µm.

EVAPORATION TIME



5 – 10 min.

DRYING TIME



12h in the temperature of 20°C
45 min. in the temperature of 60°C

SANDING



Mechanical dry sanding: P360 – P500
Hand dry sanding: P400 – P500



Mechanical wet sanding: P600 – P1000
Hand wet sanding: P800 – P1000

CONTENT OF VOLATILE ORGANIC COMPOUNDS

VOC II/B/c = 540 g/L, VOC = 540 g/L

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grey

THEORETICAL EFFICIENCY1 litre of the primer allows obtaining about 4,2 m² of a dry coat 100um thick.**TOOLS CLEANING**

Thinner for epoxy products.

STORAGE CONDITIONS

Store in a dark and dry place away from sources of fire and heat. The shelf life in original package in temperature 20°C is 24 months for the filler and 24 months for the hardener.

HEALTH AND SAFETY RECOMMENDATIONS

According to Safety Data Sheet of Dangerous Substance for particular product.

PACKAGING

Art. No	Capacity	Package, pieces.	Package weight, kg
10599	0,4L + 0,4L hard.	6	8,20
10601-2	0,8L + 0,8L hard.	3	8,20
10602-1	10L	1	18,20
10604	1L hard	1	6,80

This information is based on careful, laboratory research and our long-standing experience. Strong market position does not absolve us from constant control of the quality of our products. However, we are not responsible for the final results after incorrect use of the product.