

TECHNICAL DATA SHEET

Item number: 0103-282-0XXX

Product name: ANTI-CORROSION EPOXY PRIMER 3+1

ANTI-CORROSION EPOXY PRIMER 3+1

Description: Two-component epoxy primer-filler that provides very good durability and superb anti-corrosion and insulating properties. This flexible coating exhibits very good adhesion to various surfaces as well as mechanical resistance. It is resistant to scratches, fairly aggressive chemical splashes (alkali and salt solutions, petroleum and diesel oil) and different weather conditions. It is a perfect primer for all well known automotive coatings.

RECOMMENDED USE

- ▲ active anti-corrosion protection of cars, buses and trucks
- ▲ very good adhesion to steel, galvanized steel, aluminum, polyester laminates
- ▲ for car restoration
- ▲ for precise coating of surfaces
- ▲ superb protection with durable and aesthetic effect of the surface
- ▲ wherever a high anti-corrosion resistance is required

TECHNICAL PROPERTIES

• Density, (approx) kg/dm ³	1,4
• Recommended film thickness per one coat, dry, µm	60
• Recommended film thickness per one coat, wet, µm	100
• Cure time at 20°C, h	24
• Cure time at 60°C, h	1
• Theoretical coverage at film thickness 60 µm dm ³ /m ²	0,09
• Pot life at 20°C, h	8
• Non-volatile ingredients (approx),% by volume	70
• VOC (category B/5) permitted, g/l	540
• VOC in a ready-to-use product, depending from amount of thinner g/l	420-510
• Recommended number of coats	2-3

GLOSS: matte

COLOR: 0710 – light gray

0760 – dark gray

PRODUCT APPLICATION

Contents should be stirred after opening the cans

PREPARATION OF MIXTURE – precisely mix part I with part II (part II number - 0504-500-0000) in the following ratio:

	by volume	by weight
• part I	3	5
• part II	1	1

Apply with a conventional sprayer after mixing and thinning to spraying viscosity. After 10 minutes (in 20°C) the product is ready-to-use

Application tools

Airless sprayer, brush, conventional sprayer – after adding 10%– viscosity DINØ4: 35-40 sec

Conventional spraying parameters:

- ⤴ tip size 1,6 – 2,2 mm
- ⤴ spraying pressure 3,0 – 4,0 atm
- ⤴ number of coats 2-3
- ⤴ time for evaporation of solvent between coats: 25 min
- ⤴ it is possible to redry the primer in a higher temperature – after approx. 25 minutes after last coat application (time required to achieve appropriate flow rate and initial evaporation of solvents)

SOLVENT: item number 8040

Recommended amount of solvent for the mixture – 10% by volume

Hardware cleaning: 8040

APPLICATION

Surfaces – Degreased surface – free from oils, grease, dust, flaking coatings, mill scales, rust and any other contaminants. The surface should be sanded with 120-220 grid paper – free from dust, corrosion and dry.

- ⤴ Dry steel surface, free from any contaminants, degreased – cleaned to at least **Sa 2** (stream treated) cleanliness degree for exterior surfaces. It is allowed to clean exterior surfaces to **Sa 3** cleanliness degree (manual cleaning or with mechanical tools according to PN-ISO 12944-4)
- ⤴ Old coatings must be degreased and sanded with 220-360 grid paper
- ⤴ Non-weathered hot-dip galvanized steel and dry aluminum surfaces should be tarnished with fine abrasive fabric.
- ⤴ Galvanized surfaces should be free from any contaminants and zinc corrosion products. The contamination should be cleaned with hot water, pressure cleaned, steam cleaned, abrasive cleaned or thoroughly cleaned manually using mechanical hand tools
- ⤴ Properly prepared surface should be dry, free from salts, oil, grease, dust and any other contaminants.
- ⤴ In order to achieve a proper anti-corrosion resistance – recommended coat thickness should be above 80µm

Additional information

- ✦ VOC content in ALMA-COLOR products complies to Minister of Economy Regulation from 16.02.2007 and UE Directive 2004/42/CE from 24.04.2004.

Painting and curing conditions

- surface temperature higher than 5°C
- surface temperature above dew point (avoiding condensation)
- relative humidity less than 85%
- good ventilation

SHELF LIFE: 2 months from the production date in original unsealed container in temperature 5-35°C. 6 months for part II.

WARNING! This product is designed for professional use in the given industry. Detailed information regarding product safety can be found in the MSDS.