

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

## ANTICORROSIVE EPOXY PRIMER 10:1

## PRODUCTS

SPEC Anticorrosive Epoxy Primer 10:1.  
SPEC Hardener 1:10 for Anticorrosive Epoxy Primer.  
SPEC EPOXY THINNER 10.1 Thinner for epoxy primer 10:1

## PRODUCT DESCRIPTION

2K high build epoxy primer with anti-corrosion additives. Intended for anti-corrosion protection of various types of steel surfaces, including commercial vehicles, means of transport, agricultural machinery, and steel structures.

- Excellent anti-corrosion protection for steel surfaces.
- Allows for thick layer application
- Very high adhesion to various substrates.
- Easy mixing and application process.
- High durability.
- Excellent coverage and flow.



COLOUR: light grey

GLOSS GRADE: matt

## VOLATILE ORGANIC COMPOUNDS

VOC = 539 [g/l]

This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l.

## SURFACE PREPARATION

SPEC Anticorrosion Epoxy Primer 4:1 can be applied over:

- Steel after matting and degreasing.  
*The steel surface should be dry, free of foreign contaminants, degreased, and cleaned to cleanliness level Sa 2 ½ (blast cleaning) or St3 (manual or power tool cleaning) according to PN-ISO 12944-4. After treatment, the surface should be free of oil, grease, dust, loose old paint coatings, rust, and foreign contaminants. The surface should exhibit the gloss of the metal substrate.*
- Galvanized steel and aluminum after matting and degreasing.  
*To achieve a coarse surface, apply light abrasive blasting using non-metallic spherical materials, abrasive fabrics, or sand with sandpaper, and then degrease.*
- Sanded polyester-glass laminates (GFK/GRP) as well as epoxy-glass laminates.
- 2K polyester putties and 2K epoxy body fillers.
- Old finishes in good condition after flatting and degreasing.

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



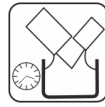


- Sanding by hand (dry):  
P180÷P320.
- Sanding by machine (dry):  
P240÷P320.

## METHOD OF APPLICATION

- pneumatic spraying
- airless spraying

## APPLICATION PROCESS

USE		HARDENING TIME	
	Product designed for anti-corrosion protection of various types of steel surfaces, including commercial vehicles, means of transport, agricultural machinery, and steel structures.		Depending on the layer thickness: <ul style="list-style-type: none"><li>• at 20°C – approx. 24h</li><li>• at 60°C - approx. 45 minutes</li></ul> Temperature below 20°C significantly increases the hardening time.
	<b>MIXING RATIO</b> by weight by volume		<b>NUMBER OF LAYERS AND SPRAYING PARAMETERS</b>
	Primer 10 10 Hardener 1 1,5		<b>Number of layers:</b> 1÷3 layers Recommended coating thickness: 150÷300 µm dry (200÷450 µm wet)
	Thinner*: 30÷35% 30÷35% Stir thoroughly until achieving homogenous mixture. <b>*SPEC EPOXY THINNER 10.1</b>		<b>Pneumatic spraying</b> <b>Gun parameters RP/HVLP</b> Nozzle: 1,6÷2,2 mm; Inlet pressure: 2,0÷2,2 bar. <b>Airless spraying with air jacket*</b> Nozzle: 0,38÷0,43 mm; Pressure: 100÷160 bar; air jacket: 2 bar <i>*depending of the recommendations of the equipment manufacturer</i>

	<b>SPRAYING VISCOSITY</b>			<b>IR DRYING</b>	
	30÷50 seconds at 20°C DIN4.			10÷15 minutes of short waves for the thickness of 150÷200µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.	
	<b>POT LIFE</b>			<b>DRY SANDING</b>	
	approx. 1,5h at 20°C.			Hand sanding: P280÷P320. Machine sanding: P320÷P400.	
	<b>EVAPORATION TIME</b>				
	Between layers:	approx. 10 minutes			
	Before baking:	approx. 15 minutes			
	Evaporation time depends on the temperature and the layer thickness.				

**FURTHER WORK**

2K epoxy primers can be directly over coated with following Troton products:

- 2K topcoats.
- 1K basecoats.
- 2K acrylic primers.
- 2K polyester body fillers.
- 2K epoxy body fillers.

**GENERAL NOTES**

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

**Caution:** *To maintain safety, always follow the instructions given in the MSDS for the products.*

**STORAGE**

Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Note:**

1. After each use the container with product should be immediately closed.
2. Protect the hardener from frost and dampness!

**WARRANTY PERIOD**

SPEC ANTICORROSIVE EPOXY PRIMER 10:1	– 12 months from the date of production
SPEC HARDENER ANTICORROSIVE EPOXY PRIMER 1:10	– 12 months from the date of production
SPEC EPOXY THINNER 10.1	– 24 months from the date of production

PRODUCT	Art. No.
SPEC ANTICORROSIVE EPOXY PRIMER 10:1	16089 (set 10+1kg), 16532 (5 kg)
SPEC HARDENER ANTICORROSIVE EPOXY PRIMER 1:10	300010569 (0,5 kg)
SPEC EPOXY THINNER 10.1	16527 (5l)

**LIMITATION OF LIABILITY**

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

TROTON Sp. z o.o.  
Ząbrowo, Poland.