



# **TECHNICAL INFORMATION**

FOR PROFESSIONAL USE ONLY

# ANTICORROSIVE ISOLATION PRIMER 3:1

## **PRODUCTS**

Wet on Wet Anticorrosive Isolation Acrylic Primer 3:1 Hardener 1:3 for Wet on Wet Acrylic Primer Thinner for acrylic products INTER TROTON

## **PRODUCT DESCRIPTION**

High quality 2K acrylic primer with anti-corrosion additives. It is a perfect isolating grounding for car repairs. It is also a perfect protection from corrosion for sanded bare steel. It isolates difficult surfaces and putties from topcoats and protects from mapping effects. Ideal spreading and fast curing allows to apply it with the wet on wet technique as it does not require sanding.

- Perfect anticorrosive protection of steel surfaces.
- Strong adhesion to various surfaces.
- Very good isolating properties.
- Short hardening time.
- Applicable with the wet on wet technique.



COLOUR: white, lightgrey, black

**GLOSS GRADE:** matt

## **VOLATILE ORGANIC COMPOUNDS**

VOC for mixture = 538 [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**

Wet on Wet Acrylic Primer 3:1 can be applied over:

- Steel and aluminum after flatting and degreasing.
- Zinc coated steel and galvanized steel after flatting and degreasing.
- Sanded glass polyester laminates (GFK/GRP).
- Polyester putties.
- · Epoxy primers.
- Wash primers.
- Old finishes in good conditio.

Good Surface preparation is necessary to achieve the best results of repairs.

Recommended abrasive paper with gradation as follows:

- sanding by hand (dry): P280÷P400.
- sanding by hand (wet): P400-P800.
- sanding by machine (dry): P240÷P400.

APPLICATION PROCESS					
	For car repairs as an isolation primer for sanding or wet on wet technique.		NUMBER OF LAYERS AND RP GUN PARAMETERS  Number of layers for these options:		
	Primer 3 parts Hardener 1 part Thinner: wet on wet option 35% option for standing 20% Stir thoroughly until achieving homogenous mixture.		For wet on wet: 1.5 layers; approx. 30μm of dry layer. For sanding: 1÷2 layers; approx 50μm of dry layer.  RP gun parameters: RP Nozzle: 1.2÷1.6 mm; Pressure of input: 2.0÷2.2 bars.  HVLP Nozzle 1.3÷1.5 mm; Inlet pressure: 2.0 bars.		
	POT LIFE  Approx. 40 minutes at 20°C.		Between layers: approx. 5÷10 minutes. Before applying solvent base: approx. 20 minutes. Before applying water base: approx. 30 minutes.  Evaporation time depends on the temperature and the number of layers.		



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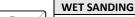
THEOREM		
	HARDENING TIME	
	Isolation primer (30÷50 μr	n)
	Hardening time at 20°C: r	eady for sanding after
	2÷3 hours.	
	Hardening time at 60°C	(facility temperature):
	ready for sanding after b	aking for about 15÷20
	minutes cooling (approx. 1	lhour).
	Temperature below 20°C	significantly increases
	the hardening time.	
	DRY SANDING	
	Machine sanding:	P360÷P500



IR DRYING				
Isolation primer (30÷50μm)	5÷7 minutes of short waves			
Primer for sending (50÷100 μm)	8÷10 minutes of			
Primer for sending (50±100 μm)	short waves			

Do not exceed 60°C.

Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.



Machine sanding: P600÷P1000
Hand sanding: P800÷P1000

Wet on wet does not require sanding!



# FURTHER WORK

2K acrylic fillers can be directly over coated with:

Hand sanding:

- K top coats.
- 1K base coats.

#### Also:

- 2K polyester putties.
- 2K acrylic primers.

## **GENERAL NOTES**

• Do not exceed recommended doses of the hardener!

Wet on wet does not require standing!

- 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.

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

P320÷P500

#### **STORAGE**

Store the product 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**

Wet on Wet Anticorrosive Isolation Acrylic Primer 3:1	– 12 months from the date of production
Hardener 1:3 for Wet on Wet Anticorrosive Isolation Acrylic Primer	<ul> <li>12 months from the date of production</li> </ul>
Thinner for acrylic products INTER TROTON	<ul> <li>24 months from the date of production</li> </ul>

PRODUCT	ART. No.
Wet on Wet Anticorrosive Isolation Acrylic Primer 3:1	(0,75l + 0,25l): 2114; 11257; 11258
Hardener 1:3 for Wet on Wet Anticorrosive Isolation Acrylic Primer	
Thinner for acrylic products INTER TROTON	300002236; 300002237 (1l; 5l)

## **LIMITATION OF LIABILITY**

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

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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.

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