
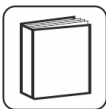

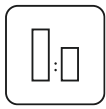







TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

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| <h3>EPOXY PRIMER</h3> <p>ANTICORROSION EPOXY PRIMER 1:1</p> | |  |
| PRODUCTS Anticorrosion Epoxy Primer 1:1 Hardener 1:1 for Anticorrosion Epoxy Primer | | |
| PRODUCT DESCRIPTION 2K epoxy primer with anti-corrosion additives. Works perfectly as an isolation grounding for car repairs. Especially recommended for use with the wet-on-wet technique. <ul style="list-style-type: none"> • Excellent protection of steel surfaces. • Very good adhesion to various surfaces. • Easy to mix and apply. • Exceptional vertical stability. | | COLOURS: white, lightgrey, black GLOSS GRADE: matt |

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| VOLATILE ORGANIC COMPOUNDS VOC = 540 [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 Anticorrosion Epoxy Primer can be applied over: <ul style="list-style-type: none"> • Bare steel and aluminum after flattening and degreasing. • Zinc coated steel, galvanized steel after flattening and degreasing. • Sanded polyester-glass laminates (GFK/GRP) as well as epoxy-glass laminates. • 2K polyester putties and 2K epoxy fillers. • Old finishes in good condition after flattening and degreasing. | |
| Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended: <ul style="list-style-type: none"> • Sanding by hand (dry or wet): P280÷P320 (GRP P400). • Sanding by machine (dry): P180÷P220. | |

| APPLICATION PROCESS | | | |
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|  | USE For car repairs as an isolation primer for sanding, or wet-on-wet technique. | |  |
| | MIXING RATIO by volume Primer 1 part Hardener 1 part Thinner not required! Stir thoroughly until achieving homogenous mixture. | | |
|  | SPRAYING VISCOSITY 18÷20 seconds at 20°C/DIN4. | |  |
| | POT LIFE Approx. 3 h at 20°C. | | |
|  | EVAPORATION TIME | |  |
| | Between layers: | approx. 5 ÷ 10 minutes | |
| | Before applying clear coat (wet-on-wet): | 45÷60 minutes | |
| Evaporation time depends on the temperature and the number of layers. | | NUMBER OF LAYERS For wet-on-wet 1.5÷2 layers; approx. 25÷50µm dry film. For sanding: 2÷3 layers 100÷140µm dry film. 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. | |
| HARDENING TIME Depending on the layer thickness: <ul style="list-style-type: none"> • at 20°C - approx. 5 h • at 60°C - approx. 35 minutes Temperature below 20°C significantly increases the hardening time. | | IR DRYING 8÷10 minutes of short waves for the thickness of 100÷140µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying. | |

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|  | <p>DRY SANDING</p> <p>Sandpaper: P400÷P500</p> <p>Wet-on-wet does not require standing!</p> |  | <p>WET SANDING</p> <p>Machine sanding: P600÷P1000</p> <p>Hand sanding: P800÷P1000</p> <p>Wet-on-wet does not require standing!</p> |
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FURTHER WORK

2K epoxy primers can be directly over coated with:

- 2K top coats.
- 1K base coats.
- 2K acrylic base coats.
- 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

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| Anticorrosion Epoxy Primer 1:1 | – 12 months from the date of production |
| Hardener 1:1 for Anticorrosion Epoxy Primer | – 12 months from the date of production |

| PRODUCTS | ART. No. |
|---|-------------|
| Anticorrosion Epoxy Primer 1:1 | 5432 (0,5l) |
| Hardener 1:1 for Anticorrosion Epoxy Primer | 5433 (0,5l) |

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.

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