

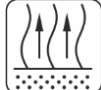










TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

<p>EPOXY 10:1 EPOXY PRIMER 10:1</p> <p>PRODUCTS</p> <p>Epoxy Primer 10:1. Hardener 1:10 for Epoxy Primer. Thinner for epoxy systems.</p> <p>PRODUCT DESCRIPTION</p> <p>2K epoxy primer for fast car repairs.</p> <ul style="list-style-type: none"> • Very high adhesion to various surfaces. • Easy to mix and apply. • Short hardening time. 	
	<p>COLOUR: lightgrey</p> <p>GLOSS GRADE: matt</p>

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	
Epoxy primers can be applied over: <ul style="list-style-type: none"> • 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. • Polyester and epoxy putties. • Old finishes in good condition after flattening and degreasing. 	Good surface preparation is necessary for achieving best results. Following sandpaper gradations are recommended: <ul style="list-style-type: none"> • sanding by hand (dry and wet): P280÷P320 (GRP P400). • sanding by machine (dry): P180÷P220.

APPLICATION PROCESS			
	USE		
	For car repairs.		EVAPORATION TIME Between layers: approx. 10 minutes Before baking: approx. 15 minutes Evaporating time depends on temperature and layer thickness.
	MIXING RATIO	by weight by volume Primer 10 parts 10 parts Hardener 1 part 1.5 parts Thinner: 20÷30% 20÷30%	
	Stir thoroughly until achieving homogenous mixture.		HARDENING TIME Depending on the layer thickness: <ul style="list-style-type: none"> • at 20°C - approx. 8 hours • at 60°C - approx. 45 minutes Temperature below 20°C significantly increases the hardening time.
	SPRAYING VISCOSITY		
	30÷50 seconds at 20°C/DIN4		IR DRYING 10÷15 minutes of short waves for the thickness of 150÷250 µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	POT LIFE		
	approx. 1.5 hours at 20°C		
	NUMBER OF LAYERS AND GUN PARAMETERS		
	2÷3 layers. RP gun parameters Nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP gun parameters Nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.		DRY SANDING Machine sanding: P360÷P500. Hand sanding: P280÷P320.
			
			WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000.

FURTHER WORK

2K epoxy primers can be directly over coated with:

- 2K top coats.
- 1K base coats.
- 2K acrylic primers
- 2K polyester putties
- 2K epoxy putties

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.

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

Epoxy Primer 10:1.	– 12 months from the date of production
Hardener 1:10 for Epoxy Primer.	– 12 months from the date of production
Thinner for epoxy systems.	– 12 months from the date of production

PRODUCTS	ART. No.
Epoxy 10:1 1 kg + 100 g (Epoxy primer with the hardener)	4786
Thinner for epoxy systems 1 l.	1152

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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