











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 MULTI FÜLLER</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	
<p>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.</p>	
SURFACE PREPARATION	
<p>Epoxy primers can be applied over:</p> <ul style="list-style-type: none"> • Steel and aluminum after flatting and degreasing. • Zinc coated steel galvanized steel after flatting and degreasing. • Sanded polyester-glass laminates (GFK/GRP) as well as epoxy-glass laminates. • Polyester and epoxy putties. • Old finishes in good condition after flatting and degreasing. 	<p>Good surface preparation is necessary for achieving best results.</p> <p>Following sandpaper gradations are recommended:</p> <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
			<p>Between layers: approx. 10 minutes</p> <p>Before baking: approx. 15 minutes</p> <p>Evaporating time depends on temperature and layer thickness.</p>
	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
			<p>Depending on the layer thickness:</p> <ul style="list-style-type: none"> • at 20°C - approx. 8 hours • at 60°C - approx. 45 minutes <p>Temperature below 20°C significantly increases the hardening time.</p>
	SPRAYING VISCOSITY		
	30÷50 seconds at 20°C/DIN4		IR DRYING
			<p>10÷15 minutes of short waves for the thickness of 150÷250 µm.</p> <p>Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.</p>
	POT LIFE		
	approx. 1.5 hours at 20°C		
	NUMBER OF LAYERS AND GUN PARAMETERS		
	2÷3 layers.		DRY SANDING
	RP gun parameters		Machine sanding: P360÷P500.
	Nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars.		Hand sanding: P280÷P320.
	HVLP gun parameters		WET SANDING
	Nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.		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 MULTI FÜLLER	– 24 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 MULTI FÜLLER	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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