

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

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

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 Primer 10:1 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"> • Hand sanding (dry or wet): P280÷P320 (GRP P400). • Machine sanding (dry): P180÷P220.

APPLICATION PROCESS															
	USE		HARDENING TIME												
	For car repairs.		Depending on the coat thickness: <ul style="list-style-type: none"> • approx. 8 hours at 20°C • approx. 45 minutes at 60°C w 60°C Temperature below 20°C significantly increases the hardening time.												
	MIXING RATIO		NUMBER OF LAYERS AND RP GUN PARAMETERS												
	<table border="1"> <thead> <tr> <th></th> <th>by weight</th> <th>by volume</th> </tr> </thead> <tbody> <tr> <td>Primer:</td> <td>10 parts</td> <td>10 parts</td> </tr> <tr> <td>Hardener:</td> <td>1 part</td> <td>1.5 parts</td> </tr> <tr> <td>Thinner:</td> <td>20÷30%</td> <td>20÷30%</td> </tr> </tbody> </table> Stir thoroughly until achieving homogenous mixture.		by weight	by volume	Primer:	10 parts	10 parts	Hardener:	1 part	1.5 parts	Thinner:	20÷30%	20÷30%		Number of layers 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.
	by weight	by volume													
Primer:	10 parts	10 parts													
Hardener:	1 part	1.5 parts													
Thinner:	20÷30%	20÷30%													
	SPRAYING VISCOSITY		IR DRYING												
	Approx. 30÷50 seconds at 20°C/DIN4.		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 h at 20°C.														
	EVAPORATION TIME		DRY SANDING												
	<table border="1"> <tbody> <tr> <td>Between layers:</td> <td>approx. 10 minutes</td> </tr> <tr> <td>Before banking:</td> <td>approx. 15 minutes</td> </tr> </tbody> </table> Evaporation time depends on the temperature and the number of layers.	Between layers:	approx. 10 minutes	Before banking:	approx. 15 minutes		Machine sanding: P360÷P500. Hand sanding: P280÷P320.								
Between layers:	approx. 10 minutes														
Before banking:	approx. 15 minutes														
			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 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

PRODUCT	ART. No.
Epoxy Primer 10:1	4785 (1 kg + 100g)
Hardener 1:10 for Epoxy Primer	
Thinner for epoxy systems	2282 (1l)

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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