

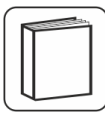
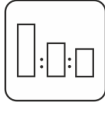
TECHNICAL DATA SHEET

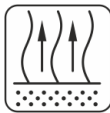
FOR PROFESSIONAL USE ONLY

EPOXY PRIMER 4:1 2K ANTICORROSIVE EPOXY PRIMER 4:1		
PRODUCTS		
2K Anticorrosive Epoxy Primer 4:1 Hardener 1:4 for 2K Anticorrosive Epoxy Primer Epoxy Reducer MASTER		
PRODUCT DESCRIPTION		
2K high performance epoxy primer with anticorrosive additives for car body repair. Can be applied directly to metal effectively protecting steel surfaces against corrosion. Offers very strong adhesion to various substrates and great sealing properties. Suitable for application wet on-wet (no sanding required). Guarantees excellent protection of steel surfaces, very strong adhesion to various substrates and easy application. • Excellent protection of steel surfaces. • Very good adhesion to various surfaces. • Easy to mix and apply. • Exceptional vertical stability.	COLORS: white, grey, black	
	GLOSS GRADE: matt	

VOLATILE ORGANIC COMPOUNDS
VOC = 382 [g/l] (4:1+15%) – 3,187 [lb/gal] VOC = 430 [g/l] (4:1+25%) – 3,589 [lb/gal] VOC = 498 [g/l] (4:1+50%) – 4,156 [lb/gal] 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: • Bare 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. • 2K polyester putties / body fillers and 2K epoxy fillers. • Old finishes in good condition after flatting and degreasing.	Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended: • Sanding by hand (dry or wet): P280÷P320 (GRP P400). • Sanding by machine (dry): P180÷P220.

APPLICATION PROCESS			
	USE For car repairs as an isolation primer for sending, or wet-on-wet technique.		NUMBER OF COATS & SPRAY GUN SETTINGS Number of coats: 2÷3 Recommended coat thickness: - isolation primer: 50÷70µm (2.0÷2.8 mils) of dry film. - filling primer for sanding: 200÷250µm (7.9 ÷9.8 mils) of dry film Compliant (RP) spray gun: 1.6÷2.0 mm; Pressure of input: 29÷32 psi (2.0÷2.2 bar) HVLP spray gun: 1.5÷1.9 mm; Inlet pressure: 26÷29 psi (1.8÷2.0 bar), Air cap pressure: 9÷10 psi (0.6÷0.7 bar).
	MIXING RATIO by volume Primer 4 parts Hardener 1 part Reducer 15÷50% Stir thoroughly until achieving homogenous mixture.		HARDENING TIME Depending on the coat thickness: - at 20°C (68°F) - approx. 8 h - at 60°C (140°F) - approx. 45 minutes Temperature below 20°C (68°F) significantly increases the hardening time.
	SPRAYING VISCOSITY at 20°C (68°F) 55÷60 seconds with 15% of reducer. 35÷40 seconds with 25% of reducer. 18÷20 seconds with 50% of reducer.		
	POT LIFE Approx. 3 h at 20°C (68°F)		

	EVAPORATION TIME			IR DRYING	
	Between coats:	5 ÷10 minutes		10÷15 minutes of short waves for the thickness of 150÷200µm (5.9÷7.9 mils). Do not exceed 60°C (140°F). Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.	
	Before baking:	approx. 10 minutes			
	Before applying clear coat (wet-on-wet):	60÷120 minutes			
	Evaporation time depends on the temperature and the number of layers.				
	DRY SANDING			WET SANDING	
	Machine sanding:	P360÷P500.		Machine sanding: P600÷P1000	
	Hand sanding:	P280÷P320.		Hand sanding: P800÷P1000.	

FURTHER WORK

2K epoxy primers can be directly over coated with:

- 2K top coats.
- 1K basecoats.
- 2K urethane basecoats.
- 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 (59 to 77°F) 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

2K Anticorrosive Epoxy Primer 4:1	– 12 months from the date of production
Hardener 1:4 for 2K Anticorrosive Epoxy Primer	– 12 months from the date of production
Epoxy Reducer MASTER	– 24 months from the date of production

PRODUCT	ART No.
2K Anticorrosive Epoxy Primer 4:1	(0.8l + 0.2l): 15627, 15628, 15629 (4l): 14851, 14852, 11693
Hardener 1:4 for 2K Anticorrosive Epoxy Primer	11694 (1l)
Epoxy Reducer MASTER	15607 (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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