TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

ANTICORROSION
Epoxy Primer 1:1

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.

- ✓ Excellent protection of steel surfaces.
- ✓ Very good adhesion to various surfaces.
- ✓ Easy to mix and apply.
- ✓ Exceptional vertical stability.

Color - Light grey.
Gloss Grade – Matt.

VOLATILE ORGANIC COMPOUNDS

V.O.C.= 540 [g/l]

The share of VOC is below 540 g/l. These products meet the EU directive (2004/42/EC/II B) that sets the VOC value for its category (C), at 540 g/l

SURFACE PREPARATION

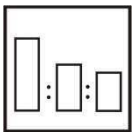
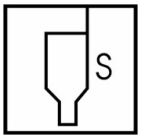
Anticorrosion Epoxy Primer can be applied over:

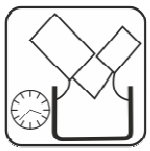
- ✓ Bare steel and aluminum after flatting and degreasing.
- ✓ Zinc coated steel, galvanized steel after flatting and degreasing.
- ✓ Glass polyester laminates (GFK/GRP).
- ✓ 2K polyester putties.
- ✓ 2K epoxy fillers.
- ✓ Old finishes in good condition after flatting and degreasing.

Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended:

- by hand (dry or wet): P280÷P320 (GRP P400),
- by machine (dry): P180÷P220.

APPLICATION PROCESS

	**USE:** For car repairs as an isolation primer for sending, or wet on wet technique
	**Mixing ratio** **by volume** Primer 1 parts Hardener 1 part Thinner Not required Stir thoroughly until achieving homogenous mixture.
	**Spraying viscosity** 18÷20 seconds at 20°C

	**Pot life** approx. 3 hours at 20^{0}C
	**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. **RP gun parameters:** Nozzle: 1,2÷1,6 mm, Pressure: 2,0÷2,5 bar **HVLP gun parameters:** Nozzle: 1,3÷1,5 mm; Pressure: 2,0 bar
	**Evaporation time** Between layers: approx. 5÷10 minutes Before baking: approx.10 minutes Before applying clear coat (wet on wet)): 45÷60 min. Evaporation time depends on temperature and film thickness.
	**Hardening time** Approx. 5 hours at 20^{0}C (depending on the layer thickness) Approx. 35 minutes at 60^{0}C (depending on the layer thickness) Temperature below 20°C significantly increases the hardening time.
	**IR Drying** 8÷10 minutes under short wave for thickness 100÷140µm Do not exceed 60^{o}C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	**Dry Sanding:** Machine sanding: P400÷P500. Wet on wet does not require sanding

	**Wet Sanding:** Machine sanding: P600÷P1000. Hand Sanding: P800÷P1000. Wet on wet does not require sanding

FURTHER WORK

2K epoxy primers can be directly over coated with:

- ✓ 2K polyester body fillers
- ✓ 2K epoxy body fillers.
- ✓ 2K acrylic fillers.
- ✓ 2K acrylic top coats.
- ✓ 1K base coats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- ✓ Clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.
- ✓ The product cannot be applied over wash primers and 1K primers

Note: *After each use the container with products should be immediately closed! Protect the hardener against freeze and humidity!*

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. *Close the container after use.*

2. *Protect the hardener from frost and dampness*

WARRANTY PERIOD

Anticorrosion Epoxy Primer 1:1- 12 months from the date of Manufacture.
Hardener 1:1 for Anticorrosion Epoxy Primer – 12 months from the date of Manufacture.

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 is based on meticulous laboratory tests and many years of experience. An established position on the market does not release us from continuous quality control of our products. However, we are not responsible for the final effects of improper storage or use of our products, and for work that is not in line with good craftsmanship.

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