

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### ANTICORROSION Epoxy Primer 4:1



#### PRODUCTS

Anticorrosion Epoxy Primer 4:1  
Hardener 1:4 for Anticorrosion Epoxy Primer  
Thinner for epoxy products

#### PRODUCT DESCRIPTION

2-pack epoxy primer with anti-corrosion additives for car repairs.  
It can be applied with wet-on-wet technique.

- ✓ Excellent protection of steel surfaces.
- ✓ Very strong adhesion to various substrates.
- ✓ Easy to mixing and apply.
- ✓ Exceptional vertical stability.

Color - Light grey.  
Gloss Grade – Matt.  
Density – 1,57 kg/l.

#### VOLATILE ORGANIC COMPOUNDS

V.O.C.= 382 [g/l] (4:1+10%)  
V.O.C.= 430 [g/l] (4:1+25%)  
V.O.C.= 498 [g/l] (4:1+50%)

The share of VOC is below 540 g/l. Due to that these products fulfill the EU directive (2004/42/EC) that sets the VOC value for this product category (B/3), as 540 g/l.

#### SUBSTRATES AND PREPARATION

Anticorrosion Epoxy Primer can be applied over:

- ✓ Bare steel and aluminum.
- ✓ Zinc coated, galvanized steel.
- ✓ Polyester laminates (GFK/GRP).
- ✓ 2-pack polyester putties.
- ✓ 2-pack epoxy fillers.
- ✓ Old finishes in good condition.

Steel surface should be first degreased, dry sanded and degreased again.


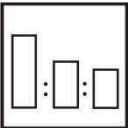
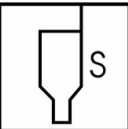
The aluminum and galvanized steel should be degreased, dulled with the abrasive cloth and degreased again.





The old coatings should be degreased, dry sanded and degreased again.

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

	<p><b>USE</b> For car repairs as a filling or grounding primer.</p>
	<p><b>Mixing ratio</b>                      <b>by volume</b></p> <p>Primer                                      4 parts  Hardener                                    1 part  Thinner                                        15% (filling primer)      30% (grounding primer)      50% (wet on wet primer)</p> <p>Stir well the mixture.</p>
	<p><b>Spraying viscosity</b>  approx. 60 seconds at 20°C for filling primer.  approx. 30 seconds at 20°C for grounding primer.  20÷22 seconds at 20°C for wet on wet primer.</p> <p><b>Pot life</b>  approx. 3 hours at 20°C</p>

	<p><b>Nozzle</b></p> <p>Gravity: 1,6÷1,8 mm.          Pressure: According to gun`s producer recommendations.          Number of layers: 2÷3 layers.</p> <p>Total layer thickness should not be less than 50 µm.</p>						
	<p><b>Evaporation time</b></p> <p>Between layers:                      approx.10 minutes          Before baking:                      approx.15 minutes</p>						
	<p><b>Hardening time</b></p> <p>Specific dryness at 20°C:    after 8 hours          Specific dryness at 60°C:    after 45 minutes</p> <p>Temperature below 20°C significantly increases the hardening time.</p>						
	<table border="0"> <tr> <td><b>Hand sanding</b></td> <td><b>Machine sanding</b></td> </tr> <tr> <td>P280÷P320 (dry)</td> <td>P360÷P500 (dry)</td> </tr> <tr> <td>P600÷P800 (wet)</td> <td>P600÷P1000 (wet)</td> </tr> </table> <p>In case of “wet on wet” primer sanding is needed if the time after applying the last layer is longer than 12 hours.</p>	<b>Hand sanding</b>	<b>Machine sanding</b>	P280÷P320 (dry)	P360÷P500 (dry)	P600÷P800 (wet)	P600÷P1000 (wet)
<b>Hand sanding</b>	<b>Machine sanding</b>						
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P600÷P800 (wet)	P600÷P1000 (wet)						

**FURTHER WORKS**

2K epoxy primers can be directly over coated with:

- ✓ 2-pack polyester putties.
- ✓ 2-pack polyester fillers.
- ✓ 2-pack acryl fillers.
- ✓ 2-pack acryl topcoats.
- ✓ 1-pack basecoats.

**GENERAL NOTES**

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results you can achieve at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.

**Caution:** *To maintain safety, always follow the instructions given in the MSDS for the products.*

<b>STORAGE</b>
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Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

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

<b>WARRANTY PERIOD</b>
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Anticorrosion Epoxy Primer 4:1- 12 months from the date of Manufacture.

Hardener 1:4 for Anticorrosion Epoxy Primer – 12 months from the date of Manufacture.

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.

TROTON Sp. z o.o.  
Ząbrowo, Poland.