



## TECHNICAL DATA SHEET

# EPOXY PRIMER

Two-component epoxy primer that provides excellent protection of metal surfaces against corrosion. In renovation work, it can be used as an insulating layer and/or as a coating to increase the adhesion between the primer and the next coat of paint. The product offers very good adhesion to various types of substrates and is characterized by high resistance to chemicals and weather conditions.

### PHYSICAL AND CHEMICAL PROPERTIES

- Graycolour liquid with elevated viscosity and an aromatic, sweet smell
- Volatile organic compounds content in readytouse product < 540 g/L

CODE	DESCRIPTION	COLOUR	PIECES PER BOX	BOXES PER PALLET
EP750	2:1 Epoxy primer 750 ml	Grey	12	576
EH375	Hardener for epoxy primer 375 ml	Grey	12	576

### APPLICATIONS

#### SUBSTRATE

- Steel,
- Galvanized steel,
- Stainless steel,
- Cast iron,
- Aluminium,
- Laminates,
- Primer paints,
- Polyester putties,
- Plastics,
- Cured varnish coatings,
- Concrete,
- Wood and wood derivatives.

#### SUBSTRATE PREPARATION



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**Twocomponent acrylic and epoxy primers** - Use silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 P320 abrasive paper. Dust off with compressed air and then degrease again.

**Onecomponent acrylic and epoxy primers** - Read and follow the technical specification of onecomponent primers. If in doubt, perform a test spray. Reactive primers read and follow the technical specification of the reactive primer. If in doubt, perform a test spray.

**Cured varnish coatings** - Use silicone remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 P320 abrasive paper. Dust off with compressed air and then degrease again.

**Concrete** - The surface must be free from all kinds of dirt and impurities; it does not require sanding.

**Wood, furniture boards or the like** - The surface must be free from all kinds of impurities. Sand manually or mechanically with P180 P320 abrasive paper. Dust off with compressed air.

### PRIMER PREPARATION

INGREDIENTS		MIXING PROPORTIONS BY VOLUME
	Primer	2
	Hardener	1

Mix thoroughly **2** parts by volume of the primer with **1** part by volume of the hardener until a uniform consistency. The product does not require the use of a thinner where necessary, use a thinner for epoxy products in the ratio of up to 5% of the readytouse mixture.

**Do not exceed the recommended amounts of thinner and hardener.**

**The use of Nitro thinner or a product other than recommended will void the guarantee.**

### HARDENER USED

GERKO hardener for epoxy primer sold together with the primer

### APPLICATION



Apply with a spray gun equipped with a 1.6 1.8 mm diameter nozzle at the pressure recommended by the equipment manufacturer (usually 2 2.5 bar).

Number of layers: 1 – 2

Single layer thickness: 40 – 50 µm.



Evaporation time between layers: 5 – 10 minutes at 20°C.

The spread rate of a readytouse mixture: depends on the form of the part processed, roughness of the substrate, application methods and conditions, and the layer thickness. Apply at a minimum temperature of 15°C and relative humidity not higher than 80%.



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### DRYING TIME



Dust dry: 10 – 15 minutes  
Touch dry: 1.5 – 2.5 h / 20°C  
Full cure: 12 – 24 h / 20°C

Epoxy primer, after full dry and sanding, can be coated with:

- Acrylic and epoxy primers 2K, 1K
- Putties
- Spray putties
- Solventborne basecoats
- Waterborne basecoats
- Generally available topcoat systems.

In the “wetonwet”

system, next layers should be applied after 4 - 5 hours and not later than 24 hours from the application of the last Epoxy Primer layer. The times given above are for unforced drying at 20°C. Temperatures above 20°C can reduce the open time of the primer for the wetonwet system

### SANDING

Manual or mechanical sanding.



#### Dry

Manual sanding with P400 P600 abrasive paper.  
Mechanical sanding with P320 P500 abrasive paper.



#### Wet

Manual sanding with P500 P800 abrasive paper.  
Mechanical sanding with P400 P600 abrasive paper.

### STORAGE

Store in original, tightly closed containers, in a dry, cool place, away from sources of heat and ignition, at a temperature 5 to 20°C. Do not expose to direct sunlight.

### WARRANTY PERIOD

The guarantee period is given on the product label.

### HEALTH & SAFETY RECOMMENDATIONS

Product safety data sheet and applicable health and safety regulations for working with chemical agents.