


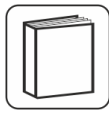

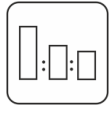



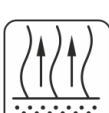

TECHNICAL INFORMATION



FOR PROFESSIONAL USE ONLY

<h3>EPOXY PRIMER 4:1</h3> <p>ANTICORROSION EPOXY PRIMER 4:1</p>	
<p>PRODUCTS</p> <p>Anticorrosion Epoxy Primer 4:1 Hardener 1:4 for Anticorrosion Epoxy Primer Thinner for epoxy products MASTER</p> <p>PRODUCT DESCRIPTION</p> <p>High quality 2K epoxy primer with anti-corrosion additives. Perfectly protects steel surfaces from corrosion during car repairs. When thinned well may be applied wet-on-wet.</p> <ul style="list-style-type: none"> • Excellent protection of steel surfaces. • Very good adhesion to various surfaces. • Easy to mix and apply. • Exceptional vertical stability. 	
<p>COLOURS: white, light grey, black</p> <p>GLOSS GRADE: matt</p>	

<p>VOLATILE ORGANIC COMPOUNDS</p> <p>VOC = 382 [g/l] (4:1+15%) VOC = 430 [g/l] (4:1+25%) VOC = 498 [g/l] (4:1+50%)</p> <p>This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l.</p>
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<p>SURFACE PREPARATION</p> <p>Anticorrosion Epoxy Primer can be applied over:</p> <ul style="list-style-type: none"> • 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 and 2K epoxy fillers. • Old finishes in good condition after flatting and degreasing. 	<p>Good preparation is necessary for achieving best results.</p> <p>Following sandpaper gradations are recommended:</p> <ul style="list-style-type: none"> • Sanding by hand (dry or wet): P280÷P320 (GRP P400). • Sanding by machine (dry): P180÷P220.
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APPLICATION PROCESS									
	<p>USE</p> <p>For car repairs as an isolation primer for sending, or wet-on-wet technique.</p>		<p>NUMBER OF LAYERS</p> <p>Number of layers: 2÷3 layers. Recommended layer thickness:</p> <ul style="list-style-type: none"> • isolation primer: 50÷70µm of dry film. • filling primer for sanding: 200÷250µm of dry film <p>Gun parameters: RP nozzle: 1.6÷2.0 mm; Pressure of input: 2.0÷2.2 bars. HVLP nozzle: 1.5÷1.9 mm; Inlet pressure: 2.0 bars.</p>						
	<p>MIXING RATIO by volume</p> <table border="1" style="width: 100%;"> <tr> <td>Primer</td> <td style="text-align: right;">4 parts</td> </tr> <tr> <td>Hardener</td> <td style="text-align: right;">1 part</td> </tr> <tr> <td>Thinner</td> <td style="text-align: right;">15÷50%</td> </tr> </table> <p>Stir thoroughly until achieving homogenous mixture.</p>		Primer	4 parts	Hardener	1 part	Thinner	15÷50%	
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	<p>SPRAYING VISCOSITY</p> <p>55÷60 seconds at 20°C with 15% of thinner. 35÷40 seconds at 20°C with 25% of thinner. 18÷20 seconds at 20°C with 50% of thinner.</p>		<p>HARDENING TIME</p> <p>Depending on the layer thickness:</p> <ul style="list-style-type: none"> • at 20°C - approx. 8 h • at 60°C - approx. 45 minutes <p>Temperature below 20°C significantly increases the hardening time.</p>						
	<p>POT LIFE</p> <p>Approx. 3 h at 20°C</p>								
	<p>EVAPORATION TIME</p> <table border="1" style="width: 100%;"> <tr> <td>Between layers:</td> <td style="text-align: right;">5 ÷10 minutes</td> </tr> <tr> <td>Before baking:</td> <td style="text-align: right;">approx. 10 minutes</td> </tr> <tr> <td>Before applying clear coat (wet-on-wet):</td> <td style="text-align: right;">60÷120 minutes</td> </tr> </table> <p>Evaporation time depends on the temperature and the number of layers.</p>	Between layers:	5 ÷10 minutes	Before baking:	approx. 10 minutes	Before applying clear coat (wet-on-wet):	60÷120 minutes		<p>IR DRYING</p> <p>10÷15 minutes of short waves for the thickness of 150÷200µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.</p>
Between layers:	5 ÷10 minutes								
Before baking:	approx. 10 minutes								
Before applying clear coat (wet-on-wet):	60÷120 minutes								

	<p>DRY SANDING</p> <p>Machine sanding: P360÷P500. Hand sanding: P280÷P320.</p>		<p>WET SANDING</p> <p>Machine sanding: P600÷P1000 Hand sanding: P800÷P1000.</p>
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FURTHER WORK

2K epoxy primers can be directly over coated with:

- 2K top coats.
- 1K base coats.
- 2K acrylic base coats.
- 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 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

Anticorrosion Epoxy Primer 4:1	– 12 months from the date of production
Hardener 1:4 for Anticorrosion Epoxy Primer	– 12 months from the date of production
Thinner for epoxy products MASTER	– 24 months from the date of production

PRODUCT	ART No.
Anticorrosion Epoxy Primer 4:1	(0,8l + 0,2l): 5429; 9882; 9880 (3,6l): 17299, 17300, 17301
Hardener 1:4 for Anticorrosion Epoxy Primer	17302 (0,9l)
Thinner for epoxy products MASTER	5515 (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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