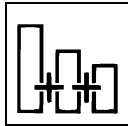
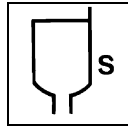


29107 – EPOXYPRIMER



1000 ml +
500 ml +
0-100 ml

Pot-life at 20° C
4 h



22-30" DIN 4
at 20° C



Ø 1,6-1,9 mm
3,5-4,5 Bar
HVLP:
Ø 1,4-1,8 mm
2,2,5 Bar
N° of coats: 2-3



Air drying at 20° C
Handling: 5 h
Sanding: 18 h
Low bake:
30 min. at 60°C
45 min. at 50°C

DESCRIPTION

Two-pack epoxy primer-sealer/filler with anticorrosion power and zinc-phosphate.

USE

Suitable in Industrial Car Refinishing and Industry in general as a primer or as a sealer-filler.

CHARACTERISTICS

- Easy to apply
- Very good adhesion to:
 - steel
 - zinc-coated steel
 - aluminium and light alloys
- Excellent anticorrosion power
- High filling power
- Fairly good sandability
- Sinkage free when overcoated
- Possible application by wet-on-wet cycles
- Chrome and lead free

SUBSTRATE PREPARATION

Black steel sheet: microsand or sand.

Steel sheet: degrease carefully with 00695 SOLVENTE ANTISILICONE SLOW and sand or sandblast.

Aluminium and light alloys: clean and degrease with 00695 SOLVENTE ANTISILICONE SLOW. Abrade or sand carefully.

Electro zinc-coated steel: degrease carefully with 00695 SOLVENTE ANTISILICONE SLOW.

Hot dip galvanized steel: degrease with 00695 SOLVENTE ANTISILICONE SLOW and sand or rub.

Fibreglass: Degrease again and again with 00695 SOLVENTE ANTISILICONE SLOW. If necessary sand.

APPLICATION

Spraying.

Mixing ratio:

	by weight	by volume
EPOXYPRIMER	1000 g	1000 ml
29370 - 29371 INDURITORE (Hardener)	300 g	500 ml
00516 EPODUR DILUENTE (Thinner)	0-50 g	0-100 ml

Pot-life at 20°C: 4 hours
Spray viscosity at 20 °C: 22 - 30" DIN4
Ø Air cap: 1.6 - 1.9 mm; HVLP: 1.4 - 1.8 mm
Air pressure: 3.5 - 4.5 bar; HVLP: 2 - 2.5 bar
Number of coats: 2 - 3
Film thickness: 70-100 µ
Theoretical coverage: 1 l mixture = 4.5 m² at 100 µ
1 kg mixture = 3.5 m² at 100 µ
V.O.C. (on average) of the product ready for use: ~ 480 g/l

DRYING TIME

Air drying at 20 °C

Dust-free: 15-20 min.
Handling: 5 h
Sanding: 18 hours
Through-drying: 48 hours

Low bake:

at 60 °C: 30 min.
at 50 °C: 45 min.

Try not to dry the product under 15 °C

SANDING

When using EPOXYPRIMER as a **primer** dry sand with P180 - 220
When using EPOXYPRIMER as a **sealer-filler** dry sand with P280 - 320

SUGGESTED OVERCOATINGS

Dry-on-dry cycle:

- After 8 to 10 hours at 20 °C from the application it can be overcoated with knifing polyester putty.
- It can be overcoated by itself if used as a sealer-filler or by other epoxy and polyurethane sealers-fillers. Generally it is used in Industrial Car Refinish in "two products" cycles, that is overcoated directly by the enamels of LECHSYS range: ISOLACK – ACRITOP.

Wet-on-wet cycle:

Wait from 1 hour to 24 hours at 20°C and overcoat directly with two-pack polyurethane enamels (ISOLACK-ACRITOP).

NOTES

The binder 29107 is chrome and lead free. By the formulations try not to add the base colours 29011, 29012 and 29026 in order to maintain the chrome and lead free characteristics of the final product.
The use of the fast hardener causes a reduction of the pot-life times.
The catalysed and thinned product is also usable with electrostatic units.
The formulations of the coloured undercoats are listed under "SOTT" on the Data Box.
Choose the colour in the relevant colour-card.

TECHNICAL DATA SHEET N° 0356-GB UP DATED 11/2004

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