

Description

Epoxy based primer with high filling power, excellent adhearance and high resistance to chemicals.

Features & Benefits

- suitable for application over old paint or polyester putties
- polyester putty could be applied over it
- easy to spray, easy to sand wet or dry
- suitable for wet-on-wet application

Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner.

Epo-Prime may be applied directly to properly prepared bare steel, zinc coated, galvanised steel, aluminium, sanded old coatings and polyester body fillers.

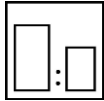
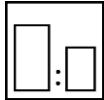


Bare steel sand with grid P80 – P120/dry. Aluminium sand with Scuffing – Cleaning Pad.

Galvanised steel sand with grid P400/dry. Zinc coated steel sand with Scuffing – Cleaning Pad.

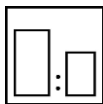
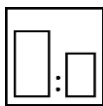


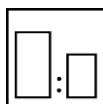
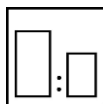
GRP or Fiberglass sand with grit P320/dry or P800/wet. Old coatings sand with grid P320/dry or P800/wet. Polyester Fillers sand with grit P120-P220/dry.







Application data

Sanding application

 <p>Standard 2120</p>	Mixing ratio (standard hardener)		<u>By volume</u>	<u>By weight</u>
	2110 Epo-Prime		3	1000
	2120 Epoxy Hardener		1	185
	2115 Epoxy thinner / 7050 Thinner		10 – 30 % *	60 – 170 *
	Flash-off:	10 – 20 min		
 <p>Fast 2130</p>	Mixing ratio (fast hardener)		<u>By volume</u>	<u>By weight</u>
	2110 Epo-Prime		2	1000
	2130 Fast Epoxy Hardener		1	260
	2115 Epoxy Thinner		20 – 40 % *	110 – 220 *
	Flash-off:	5 – 10 min		
	Spray gun set /air inlet			
	Gravity feed 1.4 - 1.8 mm		1.5 - 2.0 bar	
	Suction feed		Verify manufacturer's info	
	Application			
	Number of coats		1 – 3 coats	
	Total dry film build		50 – 150 microns	
<p>For normal corrosion protection at least 150 microns of epoxy primer is needed. Because of different surface preparation and different edges/corners on the substrate, it is recommended to apply more than 150 microns of dry film thickness.</p>				

Wet-on-wet application

 Standard 2120	Mixing ratio (standard hardener)	<u>By volume</u>	<u>By weight</u>
	2110 Epo-Prime	3	1000
	2120 Epoxy Hardener	1	185
	2115 Epoxy thinner / 7050 Thinner	20 – 30 % *	110 – 170 *
	Overcoating time:	Minimum 30 minutes (or until the whole surface is matt) Maximum 24 hours (scuff the surface after 24 hours)	
 Fast 2130	Mixing ratio (fast hardener)	<u>By volume</u>	<u>By weight</u>
	2110 Epo-Prime	2	1000
	2130 Fast Epoxy Hardener	1	260
	2115 Epoxy Thinner	20 – 40 % *	110 – 220 *
	Overcoating time:	Minimum 20 minutes (or until the whole surface is matt) Maximum 24 hours (scuff the surface after 24 hours)	
	Spray gun set /air inlet		
	Gravity feed 1.2 - 1.4 mm	1.5 - 2.0 bar	
	Suction feed	Verify manufacturer's info	
	Application		
	Number of coats	1 coats	
	Total dry film build	35 – 50 microns	
Application on plastic parts			
 Standard 2120	Mixing ratio (standard hardener)	<u>By volume</u>	<u>By weight</u>
	2110 Epo-Prime	3 (vol.)	1000
	2120 Epoxy Hardener	1 (vol.)	185
	7035 4Plastic	10 %	60
	2115 Epoxy thinner / 7050 Thinner	5 – 15 % *	25 – 100 *
	Flash-off:	10 – 20 min	
	Overcoating time:	Min 30 minutes (or until the whole surface is matt) Max 24 hours (sanding needed after 24 hours)	
 Fast 2130	Mixing ratio (fast hardener)	<u>By volume</u>	<u>By weight</u>
	2110 Epo-Prime	2 (vol.)	1000
	2130 Fast Epoxy Hardener	1 (vol.)	260
	7035 4Plastic	10 %	60
	2115 Epoxy Thinner	10 – 30 % *	50 – 150 *
	Flash-off:	5 – 10 min	
	Overcoating time:	Min 20 minutes (or until the whole surface is matt) Max 24 hours (sanding needed after 24 hours)	

	Spray gun set /air inlet Gravity feed 1.4 - 1.8 mm 1.5 – 2.0 bar Suction feed Verify manufacturer's info		
	Application Number of coats 1 – 3 coats Total dry film build 50 – 150 microns		
Drying time			
	Drying (20 °C/68 °F) 2120 Epoxy Hardener 16 – 24 h 2130 Fast Epoxy Hardener 90 – 120 min		
	Drying (60 °C/140 °F) 2120 Epoxy Hardener 30 – 60 min 2130 Fast Epoxy Hardener 20 min		
	Potlife (20 °C/68 °F) 2120 Epoxy Hardener 8 – 12 h 2130 Fast Epoxy Hardener 90 min		
	Recoatable with: All topcoats Primer/Fillers Putties		
Complementary products			
2120 Epoxy Hardener 2130 Fast Epoxy Hardener 2115 Epoxy Thinner 7050 Acrylic Thinner			
Prod. Nr.	Description	Volume	Packaging Box
2110-1	Grey	1 L	6
2110-5	Grey	5 kg	2
2110-20	Grey	20 kg	1
VOC			
2004/42/IIB(c) (540) 475 g/L			
* In case more thinner is needed in order to achieve lower viscosity the product is no longer VOC compliant.			
Shelf life			
Min. 24 months from the production date under normal storage conditions and unopened can.			

STANDARD SANDING APPLICATION

Table 1.1 – Mixing ratio 3:1 by weight with 2120 Epoxy Hardener + 20 % Thinner

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
100	109	123	136
250	271	307	339
330	358	405	447
500	543	614	678
750	814	920	1017
1000	1086	1227	1356

Table 1.2 – Mixing ratio 2:1 by weight with 2130 Fast Epoxy Hardener + 20 % Thinner

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
100	106	29	12
250	265	74	29
330	349	97	39
500	529	147	59
750	794	221	88
1000	1059	294	118

APPLICATION ON PLASTIC

**Table 2.1 – Mixing ratio 3:1 by weight with 2120 Epoxy Hardener + 20% Thinner
+10% 7035 Additive + 10% Thinner**

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Plastic primer	Weight Primer + Hardener + Plastic primer + Thinner
100	117	139	143	148
250	293	348	359	370
330	387	459	473	488
500	587	696	717	739
750	880	1043	1076	1109
1000	1174	1391	1435	1478

**Table 2.2 – Mixing ratio 2:1 by weight with 2130 Fast Epoxy Hardener
+10% 7035 Additive + 10% Thinner**

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Plastic primer	Weight Primer + Hardener + Plastic primer + Thinner
100	106	135	141	147
250	265	338	353	368
330	349	446	466	485
500	529	676	706	735
750	794	1015	1059	1103
1000	1059	1353	1412	1471

Additional Information

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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