

Product Data Sheet

May 2006

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

G0980

2K Epoxy Primer P565-2834

<i>Product</i>	<i>Description</i>
P565-2834	2K Epoxy Primer
P275-2835	Hardener
P850-1692/1693	2K Low VOC Thinner
P850-1490/1491/1492/1493	2K Thinner

Product Description

2K Epoxy Primer is a light grey in colour, chromate-free, adhesion promoting alternative to Etch Primer for use over a wide variety of substrates.

2K Epoxy Primer has good adhesion to a wide variety of suitably prepared substrates. These include bare and galvanised steel, aluminium, GRP and fibreglass, painted surfaces and fillers, and a wide range of plastic substrates.

2K Epoxy Primer can be used as a non-sand multi-substrate adhesion promoter. It may also be used on rub through areas to bare metal, where it can be directly topcoated with Nexa Autocolor 2-pack topcoat systems.

2K Epoxy Primer should not be used as an alternative to dedicated 2-pack wet on wet primers for use over large areas to be directly topcoated.

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Process

	<p>Preparation of Substrate:</p> <table border="0"> <tr> <td>SUBSTRATE</td> <td>SAND WITH</td> </tr> <tr> <td>Bare Steel P80-P120</td> <td>P400 (dry)</td> </tr> <tr> <td>Galvanised steel</td> <td>Fine sanding pad</td> </tr> <tr> <td>Zintec</td> <td>P280-P320 (dry)</td> </tr> <tr> <td>Aluminium and alloys</td> <td>P360 (dry), P800 (wet)</td> </tr> <tr> <td>Electropaint</td> <td>P280/P360 (dry), P400-P500 (wet)</td> </tr> <tr> <td>Aged painted surfaces</td> <td>P320 (dry)</td> </tr> <tr> <td>GRP, Fibre – glass</td> <td>P80-P120 (dry)</td> </tr> <tr> <td>Polyester filler</td> <td></td> </tr> </table> <p>Prior to and after any sanding operation, the substrate must be thoroughly degreased.</p>	SUBSTRATE	SAND WITH	Bare Steel P80-P120	P400 (dry)	Galvanised steel	Fine sanding pad	Zintec	P280-P320 (dry)	Aluminium and alloys	P360 (dry), P800 (wet)	Electropaint	P280/P360 (dry), P400-P500 (wet)	Aged painted surfaces	P320 (dry)	GRP, Fibre – glass	P80-P120 (dry)	Polyester filler	
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	<p>Mixing ratio:</p> <table border="0"> <tr> <td>P565-2834</td> <td>1 vol</td> </tr> <tr> <td>P275-2835</td> <td>1 vol</td> </tr> </table> <p>Note: To reduce the overspray edge when applying P565-2834 to small rub through area's or to reduce the viscosity to ease application, up to 0.5 part of 2K Thinner or 2K Low VOC Thinner can be added.</p>	P565-2834	1 vol	P275-2835	1 vol														
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	<p>Pot Life 16 hours/20°C</p>																		
	<p>Spray viscosity: 15 secs DIN4 / 20°C</p>																		
	<p>Spraygun set-up: 1.4-1.8 mm</p> <p>Number of coats: 2-3</p>																		
	<p>Flash-off at 20°C</p> <table border="0"> <tr> <td>Between coats:</td> <td>5 -10 min</td> </tr> <tr> <td>Before recoat:</td> <td>20 - 30 min</td> </tr> </table>	Between coats:	5 -10 min	Before recoat:	20 - 30 min														
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Process

	<p>Drying times</p> <p>Dust free at 20°C: 15 min Recoatable at 20°C: 20 - 30 min</p>
FILM BUILD	<p>Total dry film build: 25 - 40 µm</p>
	<p>After use, clean all equipment thoroughly with cleaning solvent or thinner.</p>
RECOAT	<p>Sanding: Not necessary in normal use.</p> <p>Over TPA, 2K Epoxy Primer must be overcoated within 8 hours.</p> <p>Over other surfaces, 2K Epoxy Primer should be overcoated within 1 week. If not, follow the subsequent method:</p> <ul style="list-style-type: none"> -Degrease (see technical datasheet ...) -Abrade lightly (sanding pad) -Degrease (see technical datasheet ...) -Apply 1 coat of 2K Epoxy primer overcoated within 45 minutes. <p>Overcoat with: Any Nexa Autocolor 2K Primers. Polyester Stoppers. All Nexa Autocolor 2K Topcoats including</p> <ul style="list-style-type: none"> - P471 HS+ - Aquabase™ (P965) - Aquabase Plus (P989)
	<p>2K Epoxy Primer should not be used at lower temperature than 10°C and humidity higher than 80%.</p> <p>2K Epoxy Primer should not be used as an alternative to dedicated 2 pack wet on wet primers for use over large areas to be directly topcoated.</p> <p>For maximum durability, over large areas of bare metal, it is recommended that 2K Epoxy Primer is recoated with a 2K Primer (Flattable Surfacer or Wet-on-Wet, see technical datasheet) prior to topcoating.</p>

These products are for professional use only and are not to be used for purposes other than those specified. The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information please refer to the material Safety Data Sheet, also available at: http://www.ppg.com/Autocolor_MSDS

For further information please contact:

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