Product Data Sheet

May 2006

INTERNATIONAL MASTER
FOR PROFESSIONAL USE ONLY

G0980

2K Epoxy Primer
P565-2834

Product	*Description*
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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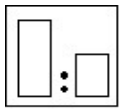
Process

Preparation of Substrate:

SUBSTRATE	SAND WITH
Bare Steel	P80-P120
Galvanised steel	P400 (dry)
Zintec	Fine sanding pad
Aluminium and alloys	P280-P320 (dry)
Electropaint	P360 (dry), P800 (wet)
Aged painted surfaces	P280/P360 (dry), P400-P500 (wet)
GRP, Fibre – glass	P320 (dry)
Polyester filler	P80-P120 (dry)

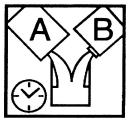
Prior to and after any sanding operation, the substrate must be thoroughly degreased.



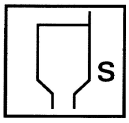
Mixing ratio:

P565-2834	1 vol
P275-2835	1 vol

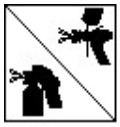
Note: To reduce the overspray edge when applying P565-2834 to small rub through area's or to reduce the viscosity to ease application, up to 0.5 part of 2K Thinner or 2K Low VOC Thinner can be added.



Pot Life 16 hours/20°C

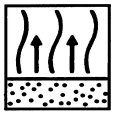


Spray viscosity: 15 secs DIN4 / 20°c



Spraygun set-up: 1.4-1.8 mm

Number of coats: 2-3



Flash-off at 20°C

Between coats:	5 -10 min
Before recoat:	20 - 30 min

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Process

	**Drying times** Dust free at 20°c: 15 min Recoatable at 20°c: 20 - 30 min
FILM BUILD	Total dry film build: 25 - 40 µm
	After use, clean all equipment thoroughly with cleaning solvent or thinner.
RECOAT	Sanding: Not necessary in normal use. Over TPA, 2K Epoxy Primer must be overcoated within 8 hours. Over other surfaces, 2K Epoxy Primer should be overcoated within 1 week. If not, follow the subsequent method: -Degrease (see technical datasheet …) -Abrade lightly (sanding pad) -Degrease (see technical datasheet …) -Apply 1 coat of 2K Epoxy primer overcoated within 45 minutes. Overcoat with: Any **Nexa Autocolor** 2K Primers. Polyester Stoppers. All **Nexa Autocolor** 2K Topcoats including - P471 HS+ , - Aquabase™ (P965) - Aquabase Plus (P989)
	2K Epoxy Primer should not be used at lower temperature than 10°c and humidity higher than 80%. 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. 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.

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

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