

Product Data Sheet

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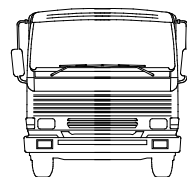
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Chromate Free Epoxy Primer P580-2100

<i>Product</i>	<i>Description</i>
P580-2100	Chromate Free Epoxy primer beige
P210-833	Activator
P850-1391	Turbo Plus™ Slow thinner
P850-1392	Turbo Plus™ Medium thinner

Product Description

P580-2100 is an isocyanate cured epoxy primer with excellent adhesion properties and corrosion resistance over a variety of substrates. It is ideal as a multipurpose primer and as a high buildprimer for use over structural steel components such as chassis.



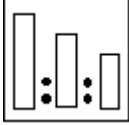






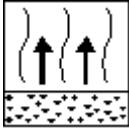
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Process



	Airless Spray	Conventional Spray and HVLP	Pressure Pot and HVLP
	P580-2100 8 parts P210-833 1 part P850-1391/1392 0.5 part	P580-2100 8 parts P210-833 1 part P850-1391/1392 2 part	P580-2100 8 parts P210-833 1 part P850-1391/1392 2 part
	Pot Life at 20°C : 6-8 hours Clean gun immediately after use	Pot Life at 20°C : 6-8 hours Clean gun immediately after use	Pot Life at 20°C : 6-8 hours Clean gun immediately after use
	50-60 secs DIN4 at 20°C	33-40 secs DIN4 at 20°C	33-40 secs DIN4 at 20°C
		1.3 -1.8 mm 4.0-6.0 bar (60-90 psi)	
	0.28-0.33 mm (11-13 thou) 40-60° angle Paint pressure : 100-200 bar (1500-3000 psi)		1.1 mm Air Pressure : 4.0-6.0 bar (60-90 psi) Paint pressure : 1 bar (15 psi)
		1.0-1.4 mm Air cap pressure : 0.675 bar (10 psi) maximum	
	2 single coats 60-80 microns (2.5-3.0 thou) For optimum protection of steel the primer dry film thickness should be a minimum of 50 microns (2 thou). On blast cleaned steel this should be 50 microns (2 thou) as measured above the blast cleaned peaks. Additional coats may be necessary depending on application equipment used, spraying technique, substrate profile and chosen thinning ratio.		
	10-20 mins between coats, depending on film thickness and drying conditions Flash off 15-3 0 minutes before stoving.		

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	<p>Air dry (20°C) Recoat : 30 minutes for wet-on-wet use Hard dry : 12 hours overnight Stoving at metal temperature of : 60°C 30 minutes</p>
	<p>Normally P580-2100 does not require flattening and should be directly recoated. It may be flattened when hard dry (12 hours at 20°C or 30 minutes at 60°C) using P320-400 dry or P500-600 wet paper. If left for more than 3 days P580-2100 must be flattened before recoating.</p>

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General Process Notes

SUBSTRATES	PREPARATION	NOTES
Steel	Blast cleaning is the preferred surface treatment for maximum durability and optimum paint usage. Alternatively flat thoroughly using P120-P220 wet and dry paper or P80-P180 dry sanding machine discs, then clean with P850-1378	Surface must be free from oil/grease, millscale and rust.
Stainless Steel	Degrease with P850-1367 and scuff with P400 wet and dry paper or P420 dry sanding machine discs, then clean with P850-1378.	
Sound Factory Finishes Sound Works Primer Sound old finishes (2-pack) Sound electrocoat	Flat thoroughly using P280-P400 wet and dry paper or P240-P320 dry sanding machine discs, then clean with P850-1378	Old synthetic finishes must be well cured and non-bleeding
Aluminium	Degrease with P850-1367 and abrade the surface using P240-P320 dry sanding machine discs, P400-P600 wet and dry paper.	
Weathered galvanised steel Zintec	Clean with P273-901; degrease with P850-1367 and sand using P240-P320 dry sanding machine discs.	Surface must be free from oxidation residues.
Hot dipped galvanised steel	Thoroughly degrease with P850-1367, scuff with Scotchbrite™ Fine or P400 wet and dry paper, then clean with P850-1378.	

P580-2100 is NOT recommended for use over thermo-plastic substrates.

For more detailed information on the preparation of specific substrates, see "Preparation and Pre-treatment" PDS.

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

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