



April 2008

Product Information



EPOXY PRIMER FILLER

Epoxy Primer Filler
Hardener

D8095
D8295

PRODUCT DESCRIPTION

Epoxy Primer Filler is a low VOC, sandable, 2K epoxy primer filler. Easy to use and sand, this primer has excellent adhesion properties over a wide range of substrates.

Epoxy Primer Filler may be applied directly to properly prepared bare steel, zinc coated steels, galvanised steel, aluminium, sound original paintwork, and polyester bodyfillers. It may be directly overcoated with any Deltron GRS topcoat or Envirobase.

PREPARATION OF SUBSTRATE - SANDING



Substrate

Bare steel
Galvanised steel
Zintec
Aluminium and alloys
Electropaint
Aged painted surfaces
GRP , Fibre-Glass
Polyester filler

Preparation

P80 – 120 (dry)
P400 (dry)
Scotchbrite
P280-320(dry)
P280/320 (dry) / P600 (wet)
P280/320 (dry) / P280 - 320 (wet)
P320 (dry)
P80 - P120 (dry) finish with P180 (dry)

PREPARATION OF SUBSTRATE – DEGREASING



Before any preparation work, wash all surfaces to be painted with soap and water. Rinse and allow to dry before degreasing with a suitable PPG substrate cleaner: Ensure all substrates are thoroughly cleaned and dried before and after each stage of the preparation work. Always wipe substrate cleaner off the panel surface immediately, using a clean, dry cloth.

Please see **Deltron Cleaners (RLD63V)** Technical Data Sheet for appropriate substrate cleaning and degreasing products.

MIXING RATIOS

1. Mixing Ratios by volume:

D8095	3 vol
D8295	1 vol
Thinner	0.6 - 0.9 vols

2. Mixing Ratios by weight:

D8095	100 g
D8295	20 g
Thinner	12 - 18 g

Notes: Mix primer and hardener until homogeneous, before addition of Thinner. After adding Thinner, mix again. An induction period of 10 minutes after mixing is necessary before use. Any PPG 2K Thinner may be used with this Primer. The choice of thinner depending upon application temperature.

MIXED PRODUCT DETAILS

Potlife at 20°C: 3 hours.
Note: Material does not gel, but must not be used more than 3 hours after mixing.

Spray viscosity at 20°C: 20 - 30 seconds DIN4

APPLICATION AND FLASH-OFF

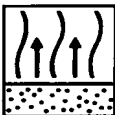


Spraygun set-up

1.3 - 1.6 mm Fluid Tip

Number of coats:

2 maximum



Flash-off between coats at 20°C:

10 minutes or until matt

DRYING TIMES



- *Dust free* 20 minutes or when matt
- *Dry to sand at 20°C* 16 hours
- *Dry to sand at 60°C* 30 minutes
- *Dry with IR* 20 minutes

Total dry film build: 60 - 80 microns

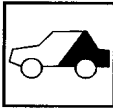


REPAIR AND RECOATING



Sanding: Essential before recoating to ensure good adhesion.

Start with P360 (dry) P600 (wet)
Finish with P400 (dry) P800 (wet)



Overcoat / Re-coat time:
- After Force drying

After cooling

Overcoat with:

GRS Deltron Topcoats, Envirobase

PERFORMANCE AND LIMITATIONS



Use only the D8295 hardener recommended on this datasheet.

The pot life of this product is about 3 hours. Be aware that this product does not gel, therefore care should be taken NOT to use after 3 hours.

Storage: Between +5°C and 35°C

EQUIPMENT CLEANING

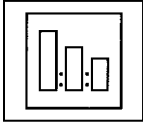
After use, clean all equipment thoroughly with cleaning solvent or thinner.



Global at a Glance

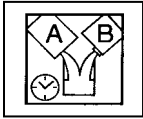
D8095

EPOXY PRIMER FILLER



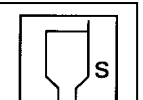
Mixing by volume

With D8295 Hardener and Thinner - 3 : 1 : 0.6 - 0.9

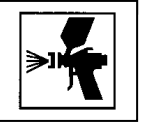


Mixing by Weight

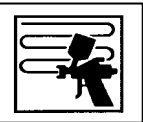
D8095 - 100g : D8295 - 17g : Thinner - 5 - 10g



Pot Life at 20°C - 3 hours maximum.



Application viscosity 20 - 30 seconds DIN4



Spraygun Sizes 1.3 - 1.6 mm Fluid Tip



Number of Coats 2 maximum

Drying Times

Dust Free -	20 minutes or until matt
Through dry at 20°C -	16 hours
Through dry at 60°C	30 minutes.



VOC INFORMATION

The EU limit value for this product (product category: IIB.c) in ready to use form is max. 540g/litre of VOC.

The VOC content of this product in ready to use form is max.540g/litre.

Depending on the chosen mode of use, the actual ready to use VOC of this product may be lower than that specified by the EU Directive code.

HEALTH AND SAFETY

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/PPG MSDS](http://www.ppg.com/PPG_MSDS)

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