

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### ANTICORROSION Epoxy Primer 1:1

#### PRODUCTS

Anticorrosion Epoxy Primer 1:1  
Hardener 1:1 for Anticorrosion Epoxy Primer

#### PRODUCT DESCRIPTION

2K epoxy primer with anti-corrosion additives. Works perfectly as an isolation grounding for car repairs. Especially recommended for use with the wet on wet technique.

- ✓ Excellent protection of steel surfaces.
- ✓ Very good adhesion to various surfaces.
- ✓ Easy to mix and apply.
- ✓ Exceptional vertical stability.

Color - Light grey.  
Gloss Grade – Matt.

#### VOLATILE ORGANIC COMPOUNDS

V.O.C.= 540 [g/l]

The share of VOC is below 540 g/l. These products meet the EU directive (2004/42/EC) that sets the VOC value for its category (IIB), at 540 g/l.

#### SURFACE PREPARATION


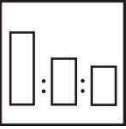
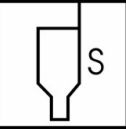
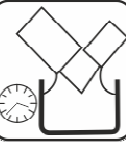

Anticorrosion Epoxy Primer can be applied over:

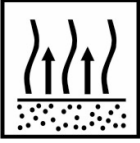




- ✓ Bare steel and aluminum after flatting and degreasing.
- ✓ Zinc coated steel, galvanized steel after flatting and degreasing.
- ✓ Glass polyester laminates (GFK/GRP).
- ✓ 2K polyester putties.
- ✓ 2K epoxy fillers.
- ✓ Old finishes in good condition after flatting and degreasing.

Good preparation is necessary for achieving best results. Following sandpaper gradations are recommended:

- by hand (dry or wet): P280÷P320 (GRP P400),
- by machine (dry): P180÷P220.

## APPLICATION PROCESS

	<p><b>USE:</b> For car repairs as an isolation primer for sanding, or wet on wet technique</p>
	<p><b>Mixing ratio</b>                      <b>by volume</b></p> <p>Primer                                      1 parts Hardener                                    1 part Thinner                                        Not required</p> <p>Stir thoroughly until achieving homogenous mixture.</p>
	<p><b>Spraying viscosity</b> 18÷20 seconds at 20°C</p>
	<p><b>Pot life</b> approx. 3 hours at 20°C</p>
	<p><b>Number of layers</b> For wet on wet 1,5÷2 layers; approx. 25÷50µm dry film for sanding: 2÷3 layers 100÷140µm dry film.</p> <p><b>RP gun parameters:</b> Nozzle: 1,2÷1,6 mm, Pressure: 2,0÷2,5 bar</p> <p><b>HVLP gun parameters:</b> Nozzle: 1,3÷1,5 mm; Pressure: 2,0 bar</p>

	<p><b>Evaporation time</b>                  Between layers: approx. 5÷10 minutes                  Before baking: approx. 10 minutes                  Before applying clear coat (wet on wet): 45÷60 min.</p> <p>Evaporation time depends on temperature and film thickness.</p>
	<p><b>Hardening time</b>                  Approx. 5 hours at 20°C ( depending on the layer thickness)                  Approx. 35 minutes at 60°C ( depending on the layer thickness)</p> <p>Temperature below 20°C significantly increases the hardening time.</p>
	<p><b>IR Drying</b></p> <p>15÷20 minutes under short wave for thickness 100÷140µm</p> <p>Drying time may change depending on the type of heater.</p>
	<p><b>Dry Sanding:</b></p> <p>Machine sanding: P400÷P500.                  Wet on wet does not require sanding</p>
	<p><b>Wet Sanding:</b></p> <p>Hand Sanding: P800÷P1000.                  Wet on wet does not require sanding</p>

## FURTHER WORK

2K epoxy primers can be directly over coated with:

- ✓ 2K polyester body fillers
- ✓ 2K epoxy body fillers.
- ✓ 2K acrylic fillers.
- ✓ 2K acrylic top coats.
- ✓ 1K base coats.

**GENERAL NOTES**

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results can be achieved at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- ✓ Clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.
- ✓ The product cannot be applied over wash primers and 1K primers

**Note:** *After each use the container with products should be immediately closed! Protect the hardener against freeze and humidity!*

**STORAGE**

Store the product components between 15 to 25 °C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Note:**

1. *Close the container after use.*
2. *Protect the hardener from frost and dampness*

**WARRANTY PERIOD**

Anticorrosion Epoxy Primer 1:1- 12 months from the date of Manufacture.

Hardener 1:1 for Anticorrosion Epoxy Primer – 12 months from the date of Manufacture.

**Important Information:**

The information contained in this document corresponds to our present knowledge and is a guide to our products and their uses.

Read all directions and warnings prior to using Troton products - Safety Data Sheets can be found online at [www.troton.com.pl](http://www.troton.com.pl) or will be sent according to your request: [troton@troton.com.pl](mailto:troton@troton.com.pl)

**Technical Information:** The technical information, recommendations and other statements contained in this document are based upon tests or experience that Troton believes are reliable, but the accuracy or completeness of such information is not guaranteed.

Many factors beyond Troton's control and uniquely within user's knowledge and control can affect the use and performance of a Troton product in a particular application. Given the variety of factors that can affect the use and performance of a Troton product, user is solely responsible for evaluating the Troton product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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If used as instructed, this product is designed to comply with the European Volatile Organic Compound (VOC) Emission Standard for Automotive Refinish Coatings. Confirm compliance with your country, state and local air quality rules before use. The data on this sheet represent typical values.

Since application variables are a major factor in product performance, this information should serve only as a general guide. Troton assumes no obligation or liability for use of this information.