

Technical Data Sheet

HYBRID EPOXY PRIMER – ANTI-CORROSION

Multifunctional Epoxy Primer – Anti-Corrosion Version

PROPERTIES

- A primer designed for anti-corrosion protection of vehicle bodies
- Long chemical activity life for overcoating with putties/fillers without matting for up to 7 days
- Very smooth surface

RELATED PRODUCTS

HYBRID ANTI-CORROSION
HARDENER

Hybrid anti-corrosion hardener for the
HYBRID EPOXY PRIMER

EPOXY THINNER

Epoxy thinner

DESCRIPTION

The latest generation epoxy primer, which can be an anti-corrosion primer, an insulating primer or a filler, depending on the hardener used. Excellent anti-corrosion protection is ensured by the high barrier properties of the epoxy resin and the protective effect of corrosion inhibitors. The HYBRID EPOXY PRIMER with the HYBRID ANTI-CORROSION HARDENER are intended for the preservation of metal substrates, on which the combination forms a sealed coating with high anti-corrosive performance. This primer provides proper protection of steel surfaces with galvanic zinc residues left from cleaning with power tools. The HYBRID EPOXY PRIMER – ANTI-CORROSION features an olive colour and a long chemical activity which allows overcoating with putties or fillers up to 7 days at 20°C without any need for matting.





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





SUBSTRATES	
Steel – new parts and body panelling	Degrease and dry sand with P120 grit paper. Degrease again.
Electrogalvanized steel – new parts and body panelling	Degrease, matt with red abrasive needled cloth, and degrease again.
Bare and electrogalvanized steel – body parts for refinishing	<p>ABRASIVE BLASTING</p> <p>Clean the steel to Sa 2^{1/2}. The surface shall be dry and free of oils, grease, dust, loose old coatings, milling scale, rust and foreign bodies. The surface should exhibit a bare metallic gloss. Following this cleaning method, use a rotary or eccentric grinder with P80 - P120 grit paper. Blow off all dust from the clean steel surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p> <p>POWER CLEANING</p> <p>Use a rotary or eccentric grinder with P80 - P120 grit paper. Blow off all dust from the clean steel surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p> <p>HIGH-PRESSURE WATER CLEANING OF COATINGS</p> <p>After this pretreatment, the substrate should be completely dry, free from oil, grease, loose old coatings, milling scale, rust and foreign bodies. Following the high-pressure water cleaning, use a rotary or eccentric grinder with P80 - P120 grit paper. Blow off all dust from the clean steel surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p>
Aluminium – new parts and body panelling	Degrease, matt with red abrasive needled cloth, and degrease again.
Aluminium – body parts for refinishing	<p>POWER CLEANING</p> <p>Use a rotary or eccentric grinder with the following paper grit size: - rough: P80 - P180 - finish: P220 - P240</p> <p>Blow off all dust from the clean aluminium surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p> <p>HIGH-PRESSURE WATER CLEANING OF COATINGS</p> <p>The substrate should be completely dry, free from oil, grease, loose old coatings, milling scale, rust and foreign bodies. Following this cleaning method, use an eccentric grinder with P220 - P240 grit paper or red abrasive cloth. Blow off all dust from the clean aluminium surface and degrease twice with the SILICONE REMOVER and blow off all dust again.</p>






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E-coated workpieces	<p>E-coated workpieces do not require sanding prior to the application of the HYBRID EPOXY PRIMER – ANTI-CORROSION.</p> <p>Degrease twice with the SILICONE REMOVER.</p> <p>Verify that the e-coat is present on the substrate by doing a solvent effect test.</p>
BODYWORK PRIMER	<p>From 72h/20°C to 6 months/20°C – degrease with the SILICONE REMOVER; no sanding is required.</p> <p>More than 6 months/20°C – degrease with the SILICONE REMOVER, matt with red abrasive needled cloth and degrease again.</p>
All NfCC polyester fillers/putties	<p>Finish by dry sanding with P220 - P320 grit paper.</p> <p>Follow by blowing off all dust, degrease with the SILICONE REMOVER and blow off all dust again.</p>
Existing coatings	<p>Finish by dry sanding with P220 - P320 grit paper.</p>
Old polyester laminates	<p>Verify that the surface is free of cracks.</p> <p>Sand with P180 - P240 paper, degrease with the SILICONE REMOVER and blow off all dust again.</p>

MIXING RATIO			
		Volume ratio	Weight ratio
	HYBRID EPOXY PRIMER	4	100
	HYBRID ANTI-CORROSION HARDENER	1	16.8
	EPOXY THINNER	20%	12.5
SPRAY VISCOSITY			
	DIN 4/20°C	20 - 30 s	
VOC CONTENT			
VOC II/B/c limit*		540 g/l	
Actual VOC for mixing ratio 4:1+20%		485 g/l	
* For a ready for use (RFU) mixture acc. to EU Directive 2004/42/CE.			
APPLICATION			
	Spray nozzle	1.6 - 1.8 mm	
	Follow the tool manufacturer's guidelines	Spray tool input pressure	1.8 - 2.2 bar
	Number of layers	2 - 3	
	Single dry layer thickness	35 - 50 µm	
	Ready for use mixture yield for 100 µm dry film thickness	approx. 4.2 m ² /l	
	The actual yield depends on the surface shape, roughness and application parameters.		
	Mixture life at 20°C	4 h	
	Flash-off time between layers at 20°C	10 min	

CURING TIMES		
	20°C	60°C
	24 h	1 h
The curing times apply to the temperature of the individual body parts.		
IR DRYING		
	10 - 20 min	
<p>A short-wave IR lamp is recommended.</p> <p>Follow the recommendations of the equipment manufacturer!</p> <p>Start IR heating after at least 20 min after applying the last layer.</p>		
SANDING		
	Dry sanding	P220 - P500
COLOUR		
<p>Grey – Component A</p> <p>Olive – as mixed with the hardener.</p>		
EQUIPMENT CLEANING		
EPOXY THINNER or NC solvent.		
STORAGE CONDITIONS		
<p>Store in a dry and cool room, away from sources of fire and heat.</p> <p>Avoid direct exposure to sunlight.</p>		
SHELF LIFE		
HYBRID EPOXY PRIMER	24 months/20°C	
HYBRID ANTI-CORROSION HARDENER	24 months/20°C	
EPOXY THINNER	24 months/20°C	
SAFETY		
See the Safety Data Sheet.		



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OTHER INFORMATION
<p>It is very important to precisely dose each component to obtain a primer with suitable performance parameters. It is good practice to mix the primer with the hardener, followed by addition of the thinner and mixing all three components again.</p>
<p>Having finished dosing, seal the primer, hardener and thinner containers tight.</p>
<p>The effectiveness of our systems results from research in the laboratory and many years of experience. The data contained here meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potential for varying reactions with different materials. We cannot be held liable for defects where the final results were affected by factors beyond our control.</p> <p>Registration number: 000024104.</p>



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RFU	HYBRID EPOXY PRIMER	HYBRID ANTI-CORROSION HARDENER	EPOXY THINNER 20%
0.10 L	94 g	16 g	12 g
0.15 L	141 g	24 g	18 g
0.20 L	188 g	32 g	24 g
0.25 L	235 g	39 g	29 g
0.30 L	282 g	47 g	35 g
0.40 L	375 g	63 g	47 g
0.50 L	469 g	79 g	59 g
0.75 L	704 g	118 g	88 g
1.00 L	939 g	158 g	117 g
2.00 L	1877 g	315 g	235 g