

# ALPHAGAM

## TECHNICAL DATA SHEET

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PRIMER

APP10024 2K EPOXY PRIMER BEIGE 7032

## **2K EPOXY PRIMER - BEIGE (4:1)**

Product Code: APP10024

### **PRODUCT INFO**

**2K Epoxy Primer Beige** is a chromate-free 2K primer filler for an economic car and large vehicle coating. The product combines the properties of filler and adhesion primer. The high corrosion protection and the very good adhesion also on non-ferrous metals make this product perfectly suitable for composite substrates. Very good filling capacity and adherence to steel, aluminium, zinc steel and FRP. Shock and scratch-resistant. **2K Epoxy Primer Beige** provides high protection against corrosion and resistance to weathering, very good resistance to chemical and mechanical strain. Recoatable with polyester-based body fillers after forced drying (30 minutes/ 60°C) for a dry film thickness up to max. 120 µm.

**Approx Coverage: 5,0 - 6,0 m<sup>2</sup>/l (for 50 - 70 µm DFT)**

### **FEATURES**

- High corrosion protection and chemical resistance.
- Easy application and Sand ability.
- Good isolation properties.
- Suitable for composite substrates.

### **SURFACE PREPARATION**

The substrate must be clean, dry and free from grease. All substrates must be cleaned beforehand with Silicon Remover Degreaser. Zinc substrates must be pre-treated with Sanding paper on aluminium with P 220, steel with P 180. After sanding clean again thoroughly with Silicon Remover Degreaser. In case of one-layer topcoat use sanding paper P 320 for dry sanding or P 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper 600/800 for wet sanding. After having mixed the two components wait for 15 minutes before applying.

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### Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Gravity spray gun (high pressure)	2.5 - 3	1.6 - 1.8	2 - 3	0 - 25
HVLP (low pressure)	2.5 - 3	1.6 - 1.8	2 - 3	0 - 25



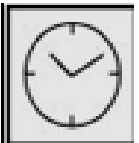
**Pot life :**  
4 h @ 30 °C



**Hardener:**  
1-UP 2K PU Epoxy Hardener



**Thinner:**  
1-UP 2K PU Epoxy Thinner @ 0 - 25 %



**Drying time :**


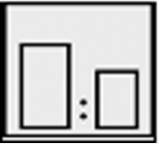

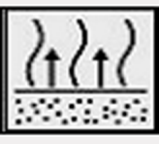

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatable
30°C	10 - 15 min	NA	NA	8 h	30 min
60°C	NA	NA	NA	30 min	NA

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.

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**Technical Information**

	<b>Colour :</b> <b>Beige (approx. RAL 7032)</b>
	<b>Mixing Ratio :</b> <b>4 : 1 (by volume)</b>
	<b>Spraying Viscosity :</b> <b>22 - 24 s 4mm DIN</b>
	<b>Flash Off Time :</b> <b>5 - 8 min between coats</b> <b>10 - 15 min before oven drying</b>
	<b>Dry Coat Thickness :</b> <b>50 - 70 µm (primer filler)</b>
<b>Storage :</b>	<b>1year from the date of manufacturing at 30° C, if stored in a dark / dry place in a tightly closed</b>
<b>VOC Regulation :</b>	EU limit value for this product (category B/c): 540 g/l This product contains max. 540 g/l of VOC.
<b>Processing Conditions :</b>	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.

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