



# ALPHAGAM

## TECHNICAL DATA SHEET

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PRIMER

### APP10030 2K EPOXY PRIMER RAL 7033

## **2K EPOXY PRIMER RAL 7033**

Product Code: APP10030

### **PRODUCT INFO**

**2K Epoxy Primer** to coat cast iron, galvanized sheet, aluminium and FRP. Thanks to its excellent filling properties and resistance to solvents and chemicals, the product is especially suited for high-quality coatings of particularly highly-stressed facilities and machines. Also a very fast recoatability after only 30 minutes drying at room temperature is provided.

**Approximate Coverage: 5 - 6 m<sup>2</sup>/l at 60 - 80 µm DFT**

### **FEATURES**

- fast recoatability
- excellent corrosion protection
- contains zinc phosphate
- superior filling properties
- overcoatable wet-in-wet
- very good spray mist absorption
- highly elastic film
- good impact resistance
- excellent resistance to solvents and chemicals
- short-term temperature exposure: 60°C (30min)
- adhesion (DIN EN ISO 2409):  
Cast Iron, steel, zinc, aluminium and FRP (very good)

### **RECOMMENDED USE**

#### **Cast Iron, zinc steel, and FRP:**

Priming coat : 2K Epoxy Primer RAL 7033 (coat thickness: 70 - 110 µm)  
Finishing coat : 2K PU or any RAL shades  
(Coat thickness: 50 - 60 µm)

#### **Aluminium:**

Priming coat : 2K Epoxy Primer (coat thickness: 40 - 60 µm)  
Finishing coat : 2K PU or any RAL shades  
(Coat thickness: 50 - 60 µm)

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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### SURFACE PREPARATION

**Steel:** clean, eventually sand (remove oil, grease, rust, oxides, etc.) and degrease with ATN10007 Silicon Remover Degreaser.

**Zinc & Aluminium:** sand with P-180 and degrease with ATN10007 Silicon Remover Degreaser.

**Cast Iron:** clean and degrease with ATN10007 Silicon Remover Degreaser.

**FRP:** clean (mould releasing agents have to be removed completely, if necessary sand with P-180 and degrease with ATN10007 Silicon Remover Degreaser.



### Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Air / flow jar spray gun	4	1.5 - 1.8	2 - 3	20 - 30
HVLP	2.5 - 3	1.5 - 1.8	2 - 3	20 - 30
Airless	120 - 150	0.28 - 0.33	1 - 2	10 - 15



**Pot life :**  
2.5 - 3 hrs @ 30°C



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



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

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**Drying time :**

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatable
30°C	20 - 30	60 - 90 min	8 h	6 h	20 min
60°C (30 min)	-	After 15 min	After 1 h	30 min	-

**Technical Information**

	<b>Colour :</b> RAL 7033
	<b>Mixing Ratio :</b> 4 : 1 (by Volume)
	<b>Spraying Viscosity :</b> 22 – 25 sec 4 mm DIN
	<b>Flash Off Time :</b> 5 - 8 min. between coats 10 - 15 min. before oven drying
	<b>Dry Coat Thickness :</b> 60 - 80 µm (primer filler)

<b>Storage :</b>	1year from the date of manufacturing at 30° C, if stored in a dark / dry place in a tightly closed container
<b>VOC Regulation :</b>	EU limiting value for the product (cat. B/c): 540 g/l This product contains max. 490 g/l VOC.
<b>Processing Conditions :</b>	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.

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