

ALPHAGAM

TECHNICAL DATA SHEET

PRIMER

**APP10038 2K EPOXY
ANTI CORROSIVE PRIMER RAL 7034**

2K HS EPOXY ANTI CORROSIVE PRIMER SURFACER RAL 7034

APP10038

PRODUCT INFO

2K Epoxy Anti Corrosive Primer Surfacer 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 20 minutes drying at room temperature is provided.

Approx. Coverage: 5 - 6 m²/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 7034 (coat thickness : 70 - 110 µm)
finishing coat : 2K PU orany RAL shades (coat thickness : 50 - 60 µm)

Aluminium:

priming coat : 2K Epoxy Primer (coat thickness: 40 - 60 µm)
finishing coat : 2K PU orany 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 (separating substance 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

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Pot life :
2.5 - 3 h @ 30 °C



Hardener:
1-UP 2K PU Epoxy Hardener



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






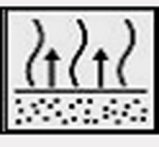

Drying time :

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

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Technical Information

	Colour : RAL 7034
	Mixing Ratio : 4 : 1 (by Volume)
	Spraying Viscosity : 22 – 25 sec 4 mm DIN
	Flash Off Time : 5 - 8 min. between coats 10 - 15 min. before oven drying
	Dry Coat Thickness : 60 - 80 µm (primer filler)

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

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