

# ALPHAGAM

## TECHNICAL DATA SHEET

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PRIMER

### APP10001 2K ETCH PRIMER TDS

## **2K ETCH PRIMER**

Product Code: APP10001

### **PRODUCT INFO**

**2K ETCH PRIMER** is an acid-curing, 2K primer designed especially for aluminium substrates providing active corrosion protection and excellent adhesion on iron, steel and galvanized substrates. **2K ETCH PRIMER** can be over coated with all 1K and 2K systems (except for epoxy coating systems and waterborne basecoats). It can also be used in a three-layer-application (etch primer/ filler/ topcoat).

**Approximate Coverage: 8 - 10 m<sup>2</sup>/l at 10 - 15 µm DFT**

### **FEATURES**

- ☑ It is an acid-curing primer, designed especially for ferrous and non-ferrous substrates.
- ☑ It has an excellent adhesion to iron, steel and galvanized substrates.
- ☑ It can be over-coated with all 1K and 2K primer surfacer (except for epoxy coating).
- ☑ It can be used in three layer application (Etch Primer/Primer surfacer/Topcoat).
- ☑ It is Easy to use and dries rapidly.
- ☑ It is suitable for spot repairs. (use 2:1)
- ☑ For large surfaces (use 1:1)

### **SURFACE PREPARATION**

Do not apply on thermoplastic substrates. Do not overcoat with polyester-based products. The substrate must be clean, dry and free from grease. Sand surfaces slightly. Remove non cured old paint works and priming coats. Zinc substrates must be pre-treated with the Alphasbond Adhesion promoter. Test beforehand the adhesion on stainless steel and difficult metals. 2K Etch Primer must be over coated within 8 hours. Protect parts primed with **2K Etch Primer** from humidity. Do not keep balance unused etch primer in metal container.

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## Application Method

Application method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Gravity spray gun (high pressure)	1.6 - 2	1.3 - 1.5	1 - 2	-
HVLP (low pressure)	1.6 - 2	1.3 - 1.8	1 - 2	-
Airmix / Airless	100 - 120	0.23 - 0.33	1 - 2	-
Brushing, Rolling	-	-	-	-



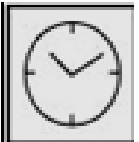
**Pot life :**  
2 - 3 hrs @ 30 °C



**Hardener:**  
AHD10005 1-UP 2K Etch Primer Hardener



**Thinner:**  
NA



**Drying time :**


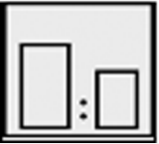

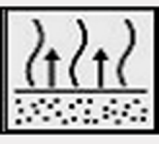

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatible
30°C	4 - 6 min	10 - 15 min	NA	NA	30 min up to max.8h

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</b>
	<b>Mixing Ratio :</b> <b>2 : 1</b> <b>1 : 1 (for large surfaces)</b>
	<b>Spraying Viscosity :</b> <b>16 - 18 sec 4 mm DIN</b>
	<b>Flash Off Time :</b> <b>10 - 15 min</b>
	<b>Dry Coat Thickness :</b> <b>10 - 15 µm</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 container.</b>
<b>VOC Regulation :</b>	EU limit value for this product (category B/c): 780g/l This product contains max. 704 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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