



EPOXY PRIMER 2:1

Product intended for professional use.

PRODUCT RANGE:

43 225	Epoxy primer 2:1, 375 mL
43 238	Hardener for epoxy primer, 188 mL
43 226	Epoxy primer 2:1, 750 mL
43 239	Hardener for epoxy primer, 375 mL

CHARACTERISTICS:

A high-quality two-component epoxy primer providing excellent protection of metal surfaces against corrosion. It is characterized by a very high adhesion to various types of surfaces. For vehicle body renovation and other repair work, it provides an insulating layer or an adhesion-promoting layer between a substrate and the next coat layer. It offers a high resistance to chemical agents and weather conditions. It can be sanded manually and mechanically, in a dry or a wet process. Works well with various topcoat systems.

PHYSICAL AND CHEMICAL PROPERTIES:

Gray-colour liquid with elevated viscosity and an aromatic, sweet smell.
Volatile organic compounds content in ready-to-use product < 540 g/L.

APPLICATIONS:

SUBSTRATE:

- steel,
- galvanized steel,
- stainless steel,
- cast iron,
- aluminium,
- laminates,
- primer paints,
- polyester putties,
- plastics,
- cured varnish coatings,
- concrete,
- wood and wood derivatives.

SUBSTRATE PREPARATION:

Steel, galvanized steel – Use Polfill AUTOMOTIVE or PRO silicone Remover to remove dirt and impurities. Sand the surface manually or mechanically with P120 - P180 abrasive paper. Dust off with compressed air and then degrease again.

Aluminium – Use Polfill AUTOMOTIVE or PRO silicone Remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P400 abrasive paper. Dust off with compressed air and then degrease again.



Putties and laminates – Use Polfill AUTOMOTIVE or PRO silicone Remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again.

Plastics - Use Polfill AUTOMOTIVE or PRO silicone Remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again. Before applying the Epoxy Primer, use Polfill Primer for PLASTICS.

Two-component acrylic and epoxy primers – Use Polfill AUTOMOTIVE or PRO silicone Remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again.

One-component acrylic and epoxy primers - Read and follow the technical specification of one-component primers. If in doubt, perform a test spray.

Reactive primers - Read and follow the technical specification of the reactive primer. If in doubt, perform a test spray.

Cured varnish coatings – Use Polfill AUTOMOTIVE or PRO silicone Remover to remove dirt and impurities. Sand the surface manually or mechanically with P240 - P320 abrasive paper. Dust off with compressed air and then degrease again.

Concrete – The surface must be free from all kinds of dirt and impurities; it does not require sanding.

Wood, furniture boards or the like – The surface must be free from all kinds of impurities. Sand manually or mechanically with P180 - P320 abrasive paper. Dust off with compressed air.

PRIMER PREPARATION:

INGREDIENTS:		MIXING PROPORTIONS BY VOLUME	
	Primer	2	
	Hardener	1	

Mix thoroughly **2** parts by volume of the primer with **1** part by volume of the hardener until a uniform consistency.

The product does not require the use of a thinner - where necessary, use a thinner for epoxy products in the ratio of up to 5% of the ready-to-use mixture.

Do not exceed the recommended amounts of thinner and hardener.



The use of Nitro thinner or a product other than recommended will void the guarantee.

HARDENER USED:

POLFILL hardener for epoxy primer sold together with the primer..



APPLICATION:

	<p>Apply with a spray gun equipped with a 1.6 - 1.8 mm diameter nozzle at the pressure recommended by the equipment manufacturer (usually 2 - 2.5 bar).</p> <p>Number of layers: 1 – 2</p> <p>Single layer thickness: 40 – 50 µm.</p>
	<p>Evaporation time between layers: 5 – 10 minutes at 20°C.</p>

The spread rate of a ready-to-use mixture: depends on the form of the part processed, roughness of the substrate, application methods and conditions, and the layer thickness.

Apply at a minimum temperature of 15°C and relative humidity not higher than 80%.

DRYING TIME:



Dust dry:	10 – 15 minutes
Touch dry:	1.5 – 2.5 h / 20°C
Full cure:	12 – 24 h / 20°C

Epoxy primer, after full dry and sanding, can be coated with:

- acrylic and epoxy primers 2K, 1K
- putties
- spray putties
- solvent-borne basecoats
- water-borne basecoats
- generally available topcoat systems.

In the “wet-on-wet” system, next layers should be applied after 4 - 5 hours and not later than 24 hours from the application of the last Epoxy Primer layer. The times given above are for unforced drying at 20°C. Temperatures above 20°C can reduce the open time of the primer for the wet-on-wet system.

SANDING:

Manual or mechanical sanding.



Dry:

Manual sanding with P400 - P600 abrasive paper.
Mechanical sanding with P320 - P500 abrasive paper.



Wet:

Manual sanding with P500 - P800 abrasive paper.
Mechanical sanding with P400 - P600 abrasive paper.



CLEANING THE EQUIPMENT:

Clean the equipment immediately after work, using:

POLFILL NITRO thinner
POLFILL thinner for ACRYLIC PRODUCTS

STORAGE:

Store in original, tightly closed containers, in a dry, cool place, away from sources of heat and ignition, at a temperature 5 to 20°C. Do not expose to direct sunlight.

WARRANTY PERIOD:

The guarantee period is given on the product label.

HEALTH & SAFETY RECOMMENDATIONS:

Product safety data sheet and applicable health and safety regulations for working with chemical agents.

The information contained in this sheet has been developed based on our knowledge and practice. However, no individual product properties can be guaranteed under different conditions of use beyond our control. Therefore, we cannot accept full responsibility for the results obtained in specific conditions of use. It is necessary to test the application of the product on a small area, due to the potential differences in the product performance depending on the substrate on which it is applied. We guarantee proper quality when used in accordance with the instructions contained in this Technical Data Sheet.