



EPOXY PRIMER 1/1

GENERAL

CODE	DESCRIPTION
EP750	Epoxy primer 1/1 grey 800 ml
EH750	Hardener for epoxy primer 800ml



DESCRIPTION

Epoxy Primer is a fast-drying, multipurpose primer designed for anti-corrosion protection. It can be used to isolate the substrate before applying polyester putty and as a wet-on-wet primer for topcoats. Thanks to the use of special resins, the primer offers excellent anti-corrosion resistance and excellent flow properties.

SUBSTRATES

Old Paint Coatings	Degrease and dry sand with P220–P360 grit paper
Polyester Fillers	Dry sand with P240–P320 grit paper
Steel	Degrease and dry sand with P120 grit paper
Original E-Coated Components	Degrease; no sanding required
Etch Primers (Wash Primers)	Do not apply
Polyester Laminates	Degrease and dry sand with P280 grit paper

MIXING RATIO



	Isolating version		Wet on wet version	
	By volume	By weight	By volume	By weight
Epoxy primer	1	100g	1	100g
Hardener	1	54g	1	54g

VISCOSITY



	Isolating version	Wet on wet version
DIN 4 (20°C)	14 – 15s	14 – 15s



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APPLICATION METHOD



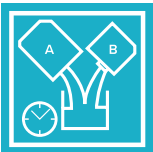
	Isolating version			Wet on wet version		
	Nozzle	Pressure	Distance	Nozzle	Pressure	Distance
Conventional spray gun	1,2 – 1,4 mm	Follow the equipment manufacturer's guidelines		1,2 – 1,4 mm	Follow the equipment manufacturer's guidelines	



	Isolating version		Wet on wet version	
	Number of layers	1 - 3		1
Per Single Layer	20 – 30 µm			
Coverage of Ready-to-Use Mixture	13 m ² /L at a dry film thickness of 30 µm			



Flash-Off Time Between Layers	5 min	5 min
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Pot life at 20°C	4 hours	4 hours
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DRYING TIMES



Isolating version		Wet on wet version	
At 20°C		At 20°C	
1 layer	1 hour	20 minutes before applying acrylic primer layers or decorative coatings. 30 minutes before applying polyester filler.	
2 layers	2 hours		
3 layers	4 hours		
At 60°C		At 60°C	
40 minutes for 3 full layers		-	

Drying times refer to the temperature of the individual components. Drying times may vary depending on the thinner used and the thickness of the applied layers.



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SANDING



Dry sanding

Wet sanding

P360 – P500

P600 – P1000

VOLATILE ORGANIC COMPOUNDS (VOC)



VOC II/B/b limit (*)

540 g/l

VOC in the Mixture for the Priming Version

540 g/l

* For the ready-to-use mixture according to the Directive UE 2004/42/CE

SAFETY



It is recommended to use personal protective equipment, such as a paint mask, protective gloves, and a paint suit, during application to prevent irritation to the eyes, skin, or respiratory system. For more information, refer to the product's safety data sheet.

ADDITIONAL INFORMATION

Practical material consumption depends on several factors, such as the geometry of the object, surface shape, application method, spray gun settings, inlet pressure, etc. The material must be stored at room temperature (18–25°C) before use. Additional time should be considered for heating the material to match the temperature of the component. Unused ready-to-use material should not be poured back into the original container.