

## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### ANTICORROSIVE EPOXY PRIMER 4:1

#### PRODUCTS

SPEC Anticorrosive Epoxy Primer 4:1  
 SPEC Hardener 1:4 for Anticorrosive Epoxy Primer  
 SPEC EPOXY THINNER 4.1 Thinner for epoxy primer 4:1

#### PRODUCT DESCRIPTION

High-quality 2K epoxy primer with anti-corrosion additives designed for anti-corrosion protection of commercial vehicles, transportation means, and agricultural machinery. It excellently protects steel substrates against corrosion by creating a tight protective coating. It can be used as a filling or insulating primer for sanding. When highly diluted it can be applied using „wet on wet” technique.

- Excellent protection of steel surfaces.
- Very high adhesion to various substrates.
- Easy mixing and application process.
- Exceptionally smooth flow.
- Good insulation and filling properties.



**COLOUR:** light grey

**GLOSS GRADE:** matt

#### VOLATILE ORGANIC COMPOUNDS

VOC = 449 [g/l] (4:1+25%)  
 VOC = 484 [g/l] (4:1+35%)  
 VOC = 538 [g/l] (4:1+50%)

This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l.

#### SURFACE PREPARATION

SPEC Anticorrosion Epoxy Primer 4:1 can be applied over:

- Steel after matting and degreasing.  
*The steel surface should be dry, free of foreign contaminants, degreased, and cleaned to cleanliness level Sa 2 ½ (blast cleaning) or St3 (manual or power tool cleaning) according to PN-ISO 12944-4. After treatment, the surface should be free of oil, grease, dust, loose old paint coatings, rust, and foreign contaminants. The surface should exhibit the gloss of the metal substrate.*
- Galvanized steel and aluminum after matting and degreasing.  
*To achieve a coarse surface, apply light abrasive blasting using non-metallic spherical materials, abrasive fabrics, or sand with sandpaper, and then degrease.*
- Sanded polyester-glass laminates (GFK/GRP) as well as epoxy-glass laminates.
- 2K polyester putties and 2K epoxy body fillers.
- Old finishes in good condition after flatting and degreasing.

Good surface preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

- Sanding by hand (dry): P180÷P320.
- Sanding by machine (dry): P240÷P320.

#### METHOD OF APPLICATION

- pneumatic spraying
- airless spraying

APPLICATION PROCESS							
	<b>USE</b>			<b>NUMBER OF LAYERS AND SPRAYING PARAMETERS</b>			
	Product designed for anti-corrosion protection of commercial vehicles, transportation means, and agricultural machinery as an filling or insulating primer for sanding or to be applied with „wet-on-wet” technique.			<b>Number of layers:</b> 1÷2 layers. Recommended coating thickness: <ul style="list-style-type: none"> <li>wet on wet: 35÷50 µm dry (50÷80 µm wet)</li> <li>filling primer for sanding: 150÷180 µm dry (200÷300 µm wet)</li> </ul> <b>Pneumatic spraying</b> <b>Gun parameters RP/HVLP</b> <b>Thinning 20-35%</b> Nozzle: 1,6÷2,2 mm; Inlet pressure: 2,0÷2,2 bar <b>Thinning 45-50%</b> Nozzle: 1,2÷1,5 mm; Inlet pressure: 2,0÷2,2 bar <b>Airless spraying with air jacket*</b> Nozzle: 0,33÷0,38 mm; Pressure: 100÷140 bar; air jacket: 2 bar *depending of the recommendations of the equipment manufacturer			
	<b>MIXING RATIO</b> by volume			<b>HARDENING TIME</b>  Depending on the layer thickness: <ul style="list-style-type: none"> <li>at 20°C – filling and insulating (grounding) versions approx. 24h</li> <li>at 60°C - approx. 45 minutes</li> </ul> Temperature below 20°C significantly increases the hardening time.			
	Primer 4 parts Hardener 1 part Thinner* 20÷50% Stir thoroughly until achieving homogenous mixture  <u>*SPEC EPOXY THINNER 4.1</u>						
	<b>SPRAYING VISCOSITY</b>			<b>HARDENING TIME</b>  Depending on the layer thickness: <ul style="list-style-type: none"> <li>at 20°C – filling and insulating (grounding) versions approx. 24h</li> <li>at 60°C - approx. 45 minutes</li> </ul> Temperature below 20°C significantly increases the hardening time.			
	<b>Filling / thinning 20-25%:</b> 30÷40 sec at 20°C/DIN4 <b>Grounding / thinning 30-35%:</b> 20÷25 sec at 20°C/DIN4 <b>Wet on wet / thinning 45-50%:</b> 16÷20 sec at 20°C/DIN4						
	<b>POT LIFE</b>			<b>IR DRYING</b>  10÷15 minutes of short waves for the thickness of 150÷200µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.			
	<b>Thinning 20-25%:</b> 5h at 20°C <b>Thinning 30-35%:</b> 5h at 20°C <b>Thinning 45-50%:</b> 6h at 20°C						
	<b>EVAPORATION TIME</b>			<b>IR DRYING</b>  10÷15 minutes of short waves for the thickness of 150÷200µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.			
	<table border="1"> <tr> <td>Between layers:</td> <td>5 ÷10 minutes</td> </tr> <tr> <td>Before baking:</td> <td>approx. 10 minutes</td> </tr> <tr> <td>Before coating (wet-on-wet):</td> <td>60÷120 minutes</td> </tr> </table> Evaporation time depends on the temperature and the layer thickness.				Between layers:	5 ÷10 minutes	Before baking:
Between layers:	5 ÷10 minutes						
Before baking:	approx. 10 minutes						
Before coating (wet-on-wet):	60÷120 minutes						
	<b>DRY SANDING</b>						
	Hand sanding: P280÷P320. Machine sanding: P320÷P400.						

**FURTHER WORK**

2K epoxy primers can be directly over coated with following Troton products:

- 2K topcoats.
- 1K basecoats.
- 2K acrylic primers.
- 2K polyester body fillers.
- 2K epoxy body fillers.

**GENERAL NOTES**

- Do not exceed recommended doses of the hardener!
- The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar.
- When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system.
- The rooms should be well ventilated.
- Clean the guns and equipment immediately after use.
- The product cannot be applied over wash primers and 1K primers.

**Caution:** To maintain safety, always follow the instructions given in the MSDS for the products.

**STORAGE**

Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

**Note:**

1. After each use the container with product should be immediately closed.
2. Protect the hardener from frost and dampness!

**WARRANTY PERIOD**

SPEC ANTICORROSIVE EPOXY PRIMER 4:1	- 12 months from the date of production
SPEC HARDENER ANTICORROSIVE EPOXY PRIMER 1:4	- 12 months from the date of production
SPEC EPOXY THINNER 4.1	- 12 months from the date of production

**PRODUCT**

**Art. No.**

SPEC ANTICORROSIVE EPOXY PRIMER 4:1	16528 (3,6 l)
SPEC HARDENER ANTICORROSIVE EPOXY PRIMER 1:4	16529 (0,9 l)
SPEC EPOXY THINNER 4.1	16567 (5 l)

**LIMITATION OF LIABILITY**

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However, we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

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