Technical Data Sheet Primers

LUXOL 2K EPOXY PRIMER



FOR PROFESSIONAL USE ONLY

Description:

Quick drying, Two-pack, Chromate-free Anticorrosive Epoxy Primer for BUS BODY, CHASSIS, etc. Developed for new work and repairs. It is easy to apply, sand and offers excellent adhesion to a variety of substrates, corrosion resistance, Film built and Gloss hold out.

Product and Additives:

2K Epoxy Primers
2K Epoxy Hardener
Plus Reducer/Thinner – Fast Thinner up to 25 deg C,
Slow Thinner above 25 deg C

Basic Raw Materials:

Base paint: Epoxy resins Hardener: Polyamide resins

Colour : Light Grey Finish: Matt (2- 10 at 60 deg gloss head.)

Suitable Substrates:

- ✓ Aluminium surfaces
- ✓ Mild Steel surfaces
- ✓ Zinc-coated Galvanised surfaces
- √ FRP laminates

Surface Preparation:

Aluminium Surface & Galvanised steel surface: Degrease and Dry sand with P220-P300. Then clean with solvent. Aluminium and galvanised steel must be etch primed before applying.

Bare Mild Steel: Degrease and Dry sand with P220-P300. Then clean with solvent.

FRP: Degrease and Dry sand with P220-P300. Then clean with solvent.

Application Process:

Apply 2-3single coats, allowing a flash -off time of 5 -10 minutes between coats.

Dry Film Thickness:

Recommended D.F.T - 35-45 micron. D.F.T Build per coat- 15 micron

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	PROCESS
CLEANING	CLEANING WITH BERGER GP THINNER
DRY SANDING	DRY SANDING WITH EMERY P220-P320
WET SANDING	WET SANDING WITH EMERY P 400-P 600
MIXING RATIO	BASE : HARDENER : THINNER
	:: 4: 1: 40 %
MIXING	MIXING OF BASE, HARDENER & THINNER WITH
	MIXING ROD
APPL VISC	APPLICATION VISCOSITY – 16-19 SECONDS B4FC AT 30
s	DEG C
GUN P	GUN PRESSURE: 3-5 BAR (CONVENTIONAL)
	2 BAR (HVLP)
FLASH OFF	APPLY 2-3 COATS, ALLOWING A FLASH OFF TIME OF 5
<u>/1/1/</u>	TO 10 MINUTES BETWEEN COATS
DRYING TIME	Air Drying At 30 Deg C Dust Free: 15 Mins
(->-)	Tack Free: 45 Mins
	Hard Dry: 8 Hours Baking Temp: 70 -80 Deg C EMT / 30 Mins
POT LIFE	MINIMUM 6 HOURS
> /	
RECOATS	Luxol 2K Epoxy primer can be recoated with Luxol 2K Primer Surfacer system. 2K Epoxy Primer must be Flatted (Sanded) before recoat.
TESTING	All Testing must be done after 72 -96 Hours of Maturation

Material usage:

Taking into account a transfer efficiency of 100%, the theoretical material usage (Coverage) for 40 micron D.F.T is 10.9 m²/l ready to spray mixture thinned paint.

Note: The practical material usage depends on many factors i.e. shape of the object, temperature, roughness of the surface, application method and application circumstances.

Cleanliness of the Equipment:

With Luxol 2K Epoxy Thinner.

Shelf life:

Luxol 2K Epoxy primer - 1 year Hardener for Luxol 2K Epoxy Primer - 1year

Packaging: 4 lts/1lt pack

HEALTH & SAFETY DATA concerning Luxol 2K Epoxy Primer and Hardener: For professional use only.(See Material Safety Data Sheet).