



Technical Data Sheet:


07.2022




Product Details:

Product Name:	AUTO INDUSTRIAL EPOXY PRIMER
Product Description:	<p>Germa-Tech Auto Industrial Epoxy Primer gives excellent rust proofing for bare metal, good adhesion power to iron, steel, aluminum and galvanized steel.</p> <p>Specifically designed for very large surface areas, commonly used in coatings of bus, trains and large equipment.</p>

Substrates:

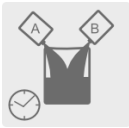
	<p>Sanded and dried existing finishes. Sanded steel, iron, galvanized steel, aluminum, and fiberglass.</p> <p>Plastic automotive parts require plastic primer application.</p>
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Surface Preparation:

	<p>Remove Wax, Silicon and other contaminants with Germa-Tech Prepsol</p>
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Directions For Use:
Mixing Ratio:


Mixing Ratio	Epoxy Primer +	Hardener +	Thinner
By Weight	4	1	1.5 (37.5%)
>30 °C	GP-AI-201	GP-AI-202	GP-AI-203

Pot Life:

Pot-Life at 25 °C

4 hours with Hardener and reducer

Shelf Life:

2 Years in the original sealed can in a cool and dry place at 20°C

Spray Gun Set Up:

 Gravity Feed: 1.6-1.7mm Suction Feed: 1.6-2.0mm
 Conventional: 3-4 bar RP: 2.0-2.5 bar HVLP: 2.0 bar

Coats And Thickness:

 Spray viscosity: DIN4 cup 22-24 seconds s/30°C
 2-3 coats, total 50-60um

Drying Time:

Drying Times

Flash Off Time	At 20°C 15-20 minutes between coats.
Air Drying Time	At 20°C 18+hrs dry time
Force Drying Time	At 60°C 1 hour dry time

Sanding Grit:

 Dry Sanding with P240 - P400
 Wet Sanding with P600 - P800

Re-Coat:

Can recoat with primer after flash-off time of 15-20 minutes

Additional Information**Package:**

5kgs

Notes:

1. For oxidized iron and cast iron, shot blasted sa2.5 class with roughness of 30-75um, or acid wash the oxidized parts
2. It is recommended to bake at 60-70 for 60 minutes when temperature is below 10°C for better curing of the paint film.
3. Choose the right hardener and thinner to avoid poor curing paint film.
4. Product must be cured before application of 2k Primer or Wet on Wet Primer
5. Cured product must be sanded immediately before application of primer
6. Top coat colour can be applied directly to cured and sanded Epoxy Primer, this process is recommended only for industrial applications and not automotive applications. For automotive applications a 2k primer or wet on wet should be applied prior to top coat.

The information contained in this file is presented in good faith based on thorough laboratory and field testing but without warranty. As we have no control over the conditions under which these products are used, it is recommended that all products be tested by the end user to ensure the suitability of the product for the particular application and conditions.