



## EPOXY HIGH BUILD – GP-EP1

GP-EP1 – GREY

GP-EP1 B – BLACK

GP-EP1 W – WHITE

### TOPCOAT IN ONE

#### PRODUCT DESCRIPTION

A two component primer which will self-level on application and will cure at room temperature, low temperature, or can be baked.

Excellent adhesion to various metal substrates, timber or concrete. Excellent water resistance, salt spray resistance, provides for high quality and convenient/efficient construction.

Suitable to be applied with top coating in a wet on wet application, or non sanding before topcoats in 24-48 hour window.

**Applied for painting in fields such as buses, trucks, special vehicles and construction machinery. Semi gloss finish in Black, White or Grey and used as a one final coat system in chassis and products not exposed to direct sunlight**

#### PRODUCT FEATURES

- Fast drying.
- Excellent adhesion.
- Excellent corrosion resistance.
- Excellent mark and abrasion resistance.
- Available in a gloss black, gloss white and Gloss grey.
- Excellent durability.

#### PRODUCT APPLICATION

- Prepare the surface by following guide.
- Apply by brush, roller or spray at the specified thickness.
- Allow to cure.
- Recoat or apply topcoat as needed

Property	Value	Standard
Color	GREY BLACK WHITE	
Solids % Content	≥65%	GB/T 1725
Drying & Cure times at 20°C (68°F)		
Pot Life	3 hours	
Touch dry	30 min	
Hard dry	16 hours	
Dry to recoat	10-20 min	Flash Off
Fineness	≤40	GB/T 1724
Viscosity (cP/25°C)	1500-2500	GB/T 1723
Adhesion (1mm, grade)	≤1	GB/T 9286
Flexibility (mm)	≤2	GB/T 1731
Impact Resistance (kg/cm)	≥50 cm	GB/T 1732
Hardness	≥HB	GB/T 6739
Salt resistance	≥168H	GB/T1771
Heat Resistance	(120°C ±2), 3h passed	
Water Resistance (40°C 240h)	No peel or bubble—slight gloss loss	GB/T1733
Film Thickness (typical)	40-60µm standard	
Theoretical Coverage Rate	8sq meter per kilogram	



## PRODUCTS

<b>KIT FORM</b>	<b>GP-EP1G (GREY)</b> <b>GP-EP1W (WHITE)</b> <b>GP-EP1B (BLACK)</b>
<b>Epoxy High Build</b>	NT-XW04 (BLACK WHITE OR GREY)
<b>Hardener</b>	NT-8541C Epoxy Hardener
<b>Reducers</b>	
<b>ALL</b>	NT-1750 Epoxy Reducer
<b>Conditions</b>	
<b>Cleaners</b>	GP5101 Prepsol heavy duty wax and grease

## SUBSTRATES & PREPARATION

Epoxy High Build can be applied over the following substrates once they have been prepared as follows:

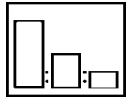
<b>SUBSTRATE</b>	<b>PREPARATION</b>
Cast Iron	P80-P120 - dry
Bare Steel	P80-P120 - dry, or shot blast
Phosphated Steel	SA2.5 level 30-75 µm
Galvanized Steel	Scourer
Light Alloys	P80-P180 - dry
Aluminium	P240-P320 - dry
Fibre Reinforced Plastic	P240-P320 - dry
Stainless Steel	P240 - dry
Concrete	P240-P320 – dry
Timber	Suitable grinded or sanded surfaces
	P120-240 - dry

Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased to remove all traces of dirt, oil, grease, silicone, wax etc. Use GP5101 Prepsol.

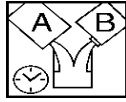
Substrates other than those stated above such as previously painted surfaces should be tested before use to ensure that the performance of this product is suitable for its intended use.

## MIXING RATIO BY VOLUME



### MIXING RATIO

Epoxy Primer	3.5	(by volume)
Hardener	1	(by volume)
Reducer	1(35%)	(by volume)

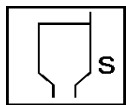


Epoxy Primer	4	(by weight)
Hardener	1	(by weight)
Reducer	1	(by weight)

Mix the primer with the explosion-proof motor agitator before and after adding hardener and thinner

### POT LIFE

Catalysed material is useable for up to 3 hours at 25°C



### SPRAY VISCOSITY

CONVENTIONAL, HVLP	18 - 25 seconds (B4) at 25°C
AIRLESS /	25 - 35 seconds (B4) at 25°C

## SPRAY GUN



### CONVENTIONAL, HVLP

TIP SIZE	1.6-2.0MM
SPRAY PRESSURE	2.0-3.0 bar
VISCOSITY	18-25 second DIN4 cup



### SUCTION

TIP SIZE	1.6 mm – 2.5 mm
SPRAY PRESSURE	3.0-4.0 bar
VISCOSITY	18-25 second DIN4 cup



### DIAPHRAGM PUMP

TIP SIZE	1.0 mm – 1.3 mm
SPRAY PRESSURE	3.0-4.0 bar
VISCOSITY	18-25 second DIN4 cup



### AIRLESS / AIR ASSISTED AIRLESS

TIP SIZE	0.43-0.48 mm
SPRAY PRESSURE	3.0-7.0 bar
VISCOSITY	25-35 second DIN4 cup

## APPLICATION & FLASH OFF

**CONVENTIONAL, HVLP, DIAPHRAGM** 2 wet even coats for filling and sanding  
1 - 2 wet even coats for Wet on Wet

**AIRLESS, AIR ASSISTED AIRLESS** 1 - 2 wet, even coats

Allow 5-20 minutes flash off between coats at 25°C say 10 minutes

Allow 20-30 minutes air dry before baking if baking

Allow 30 minutes air dry if applying topcoat colour in wet on wet application. Epoxy film will matte once sufficiently flashed off.



### DRYING TIMES

AIR DRY (25°C)

- TOUCH DRY: 1 hour
- TACK FREE: 2 hours
- HARD DRY: 16-24 hours
  
- BAKE (70 DEGREES) 60 minutes

**Note: Drying times can vary dependent on temperature, flash off between coats, film builds and number of coats applied. Do not apply in humidity above 85%.**

## RECOAT

Can be top coated with any Germatech direct gloss topcoat, DO NOT apply any Basecoat systems or single pack topcoats to this product. Recommendations are based on 25°C ambient temperature



Can be top-coated in a WET ON WET application after 30 minutes minimum dry time at 25°C.

If recoating after 48 hours the coating must be abraded and degreased prior to painting.

Aged films must be chalk and dirt (abraded and degreased) before recoating.

## BUILD

**TOTAL DRY FILM BUILD**

40-60 µm standard

150-200 µm achievable (maximum)

Adjust drying times if applying above standard build

## TECHNICAL PARAMETERS

<b>VOLUME SOLIDS (RFU)</b>	65%+ depending on colour
<b>COVERAGE</b>	5-7 meters squared per liter (m <sup>2</sup> /L)
<b>RESISTANCE PROPERTIES</b>	
<b>WEATHERING</b>	Poor (Requires topcoat) if in sunlight
<b>ABRASION</b>	Good
<b>SOLVENT</b>	Good to splash and spillage for common solvents
<b>CHEMICAL</b>	Good to splash and spillage for mild chemicals
<b>HEAT</b>	Satisfactory up to 120°C Dry Heat
<b>IMMERSION</b>	Not recommended

## EQUIPMENT CLEANING & STORAGE

After use, clean all equipment thoroughly with cleaning solvent or thinner.

Store in cool and dry place preferable 20°C within 5-30°C.

The original packaging can be sealed and stored for upto 12 months

## HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can

Hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development. Refer to [www.geramtatech.com.au](http://www.geramtatech.com.au) for the most up to date Technical Data Sheet versions.

Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

### Product name: GP-EP1 HIGH BUILD EPOXY PRIMER

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New Zealand Transport Emergency: 0800 658 080