



## Technical Data Sheet:


07.2022




### Product Details:

<b>Product Name:</b>	Epoxy Primer
<b>Product Description:</b>	Germa-Tech Epoxy Primer gives excellent rust proofing for bare metal, good adhesion power to steel, aluminum and galvanized steel.

### Substrates:

	Sanded and dried existing finishes. Sanded steel, iron, galvanised steel, aluminum, and fiberglass.  Plastic automotive parts require plastic primer application.
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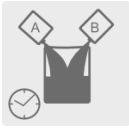
### Surface Preparation:

	Remove Wax, Silicon and other contaminants with Germa-Tech Prepsol
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**Directions For Use:**
**Mixing Ratio:**


Mixing Ratio	Epoxy Primer +	Hardener +	Thinner
Volume	3.5	1	1 (30%-35%)
>30 °C	GP3401	GP3402	GP3403

**Pot Life:**

**Pot-Life at 20 °C**

4-6 hours with Hardener

**Shelf Life:**

Shelf Life is up to 36 months if unopened and stored in a cool dry place (below 20°C). Shelf life is an optimal guide and the product is manufactured and tested to exceed shelf life recommendations, avoid ambient temperatures above 20 and exposure to direct sunlight which are amongst common factors that will diminish storage shelf life. Contact the distributor or manufacturer if requiring further advice.

If stored correctly, it can be used for up to 12 months from opening the original seal

**Spray Gun Set Up:**


Gravity Feed: 1.4-1.8mm Suction Feed: 1.7-2.0mm  
 Conventional: 3-4 bar RP: 2.0-2.5 bar HVLP: 2.0 bar

**Coats And Thickness:**


Spray viscosity: 20°C DIN4 cup 16-18 seconds  
 2-3 coats, total 40-60um

**Drying Time:**

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Flash Off Time	At 20°C 5-10 minutes between coats.
Air Drying Time	Allow 15-20 minutes air drying time before force drying
Drying Time	18-26 hours at 20°C or 40-60 minutes at 60°C

**Sanding Grit:**


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

<b>Re-Coat:</b>	Recoat with primer after flash-off time of 10-15 minutes
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**Additional Information**

<b>Package:</b>	5kgs
<b>Notes:</b>	<ol style="list-style-type: none"><li>1. For oxidized iron and cast iron, shot blasted sa2.5 class with roughness of 30-75um, or acid wash the oxidized parts</li><li>2. It is recommended to bake at 60-70 for 30 minutes when temperature is below 10°C for better curing of the paint film.</li><li>3. Choose the right hardener and thinner to avoid poor curing paint film.</li><li>4. Product must be cured before application of 2k Primer or Wet on Wet Primer</li><li>5. Cured product must be sanded immediately before application of primer</li><li>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.</li></ol>

*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.*