

EPOXY HIGH BUILD – GP-EW1

GP-EW1—GREY



FASTER CONSTRUCTION

PRODUCT DESCRIPTION

Advanced environmentally friendly water-based technology products, consisting of water-based epoxy polymers, various environmentally friendly pigments and fillers, purified water, and a small amount of film forming additives

Self-drying and low temperature baking, 2 component water-based epoxy thick paste paint. Excellent rust resistance, chemical resistance, and salt spray resistance; Good construction performance, high quality and efficiency; Low odor, extremely low VOC content, green and environmentally friendly Suitable for various steel structures such as phosphated steel plates, sandblasted steel plates, or cured and polished two component epoxy primers.

Widely used in the coating of bus, special vehicles construction machinery and other fields.

PRODUCT FEATURES

- Very fast drying.
- Excellent adhesion.
- Excellent corrosion resistance.
- Excellent mark and abrasion resistance.
- Excellent durability.

PRODUCT APPLICATION

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

Property	Value	Standard
Color	GREY	
Solids % Content	≥55%	GB/T 1725
Drying & Cure times at 20°C (68°F)		
Pot Life	2 hours	
Touch dry	30 min	
Hard dry	12-16 hours	
Dry to recoat	10-20 min	Flash Off
Fineness	≤ 25	GB/T 1724
Viscosity (cP/25°C)	3000-10000	GB/T 1723
Adhesion (<u>1mm</u> , grade)	≤1	GB/T 9286
Flexibility (mm)	≤1	GB/T 1731
Impact Resistance (kg/cm)	≥50cm	GB/T 1732
Hardness	≥H	GB/T 6739
Salt resistance	≥600H	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 120 µm achievable	
Theoretical Coverage Rate	5-8 meters squared per liter (m ² /L) two coating	



PRODUCTS

KIT FORM	GP-EW1
Epoxy High Build	WT-MT1108 Epoxy Primer
Hardener	WT-MT116 Epoxy Hardener
Reducers All Conditions	Distilled Water
Cleaners	GP5101 Prepsol heavy duty wax and grease

SUBSTRATES & PREPARATION

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

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

Heavily rusted surfaces should be abrasively blast cleaned.

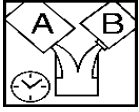
Before and after any sanding operation, the substrate must be thoroughly degreased to remove all traces of dirt, oil, grease, silicone, wax etc. Use GP5101 Prepsol.

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	<i>mix</i>	(by volume)
Hardener	<i>by</i>	(by volume)
Reducer	<i>weight</i>	(by volume)

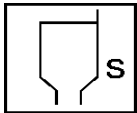


Epoxy Primer	6	(by weight)
Hardener	1	(by weight)
Reducer	0.2-0.8	(by weight)

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 2 hours at 25°C



SPRAY VISCOSITY

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

SPRAY GUN

CONVENTIONAL, HVLP



TIP SIZE	1.8-2.5MM
SPRAY PRESSURE	2.0-2.5 bar
VISCOSITY	25-35 second DIN4 cup

SUCTION



TIP SIZE	2.0MM - 3.0MM
SPRAY PRESSURE	2.0-3.0 bar
VISCOSITY	35-45 second DIN4 cup

DIAPHRAGM PUMP



TIP SIZE	NA
SPRAY PRESSURE	
VISCOSITY	

AIRLESS / AIR ASSISTED AIRLESS



TIP SIZE	NA
SPRAY PRESSURE	
VISCOSITY	



BRUSH OR ROLL	NA
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APPLICATION & FLASH OFF

CONVENTIONAL, HVLP, DIAPHRAGM

1-2 even full coats for filling and sanding

1 - 2 even full coats for Wet on Wet

AIRLESS, AIR ASSISTED AIRLESS

NA

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

Allow 10-15 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: 30 min
- TACK FREE: 2-3 hours
- HARD DRY: 12-16 hours
- BAKE (70 DEGREES) 60minutes (recommend bake for ambient temperatures below 20 degrees)

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

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.

If recoated after 14 days the coating must be abraded and degreased prior to re-priming.

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

BUILD

TOTAL DRY FILM BUILD

40-60 µm standard (2 coats)

120µm achievable (maximum)

Adjust drying times if applying above standard build

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	55%+
COVERAGE	5-8 meters squared per liter (m ² /L) two coating
RESISTANCE PROPERTIES	
WEATHERING	Poor (Requires topcoat) if in sunlight
ABRASION	Good
SOLVENT	Good to splash and spillage for common solvents
CHEMICAL	Good to splash and spillage for mild chemicals
HEAT	Satisfactory up to 120°C Dry Heat
IMMERSION	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 up to 9months

HEALTH AND SAFETY

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

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 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

Supplier: AMPRO AUSTRALIA PTY LTD
68-70 Western Avenue, Weastmeadows
Victoria Australia 3049

Email: support@amproaustralia.com

Tel: +61(03)8335 9532

Australian Emergency Telephone Numbers: 1800 089 766

Australian Poisons Information Centre: 131 126

Australian Transport Emergency: 0800 658 080

New Zealand Poison Information Centre: 0800 764 766

New Zealand 24 Hour Medical Emergency: 0800 111 174

New Zealand Transport Emergency: 0800 658 080