



## PRIMER 500 Epoxy Primer

**Description:** Anti-corrosion epoxy resin primer. Excellent adhesion to various types of substrates, with excellent insulating and sealing performance. Forms a strong, durable and elastic coat.

**Substrates:**

- old paint coatings,
- polyester putties,
- polyester laminates,
- steel,
- galvanized steel,
- aluminium.

Caution: The epoxy primer should not be applied directly to wash primer.

**Substrate preparation:**

- old paint coatings: degrease and dry sand with P220 to P360 paper,
- polyester putties: smooth finish by dry sanding with P240 to P320,
- polyester laminates: degrease and dry sand with P280,
- steel surfaces: degrease and dry sand with P120 to P240,
- galvanized surfaces: degrease and mat with an abrasive finishing pad. Degrease again,
- aluminium surfaces: degrease and mat with an abrasive finishing pad. Degrease again.

**Mixing ratio:**

	By volume	By weight
Filling version		
PRIMER 500 Epoxy primer	2	100
PRIMER HÄRTER Hardener for epoxy primer	1	30
THINNER Acrylic, epoxy and basecoat thinner	10 - 20%	5.5 - 11

The thinner quantity is given as calculated on the basis of the primer.

**Supplementary products:** Complementary articles:  
PRIMER HÄRTER Hardener for epoxy primer  
THINNER Acrylic, epoxy and basecoat thinner

**Pot life:** Ca. 5 hours at 20°C

**Application parameters:**

Spray viscosity: DIN 4/20°C - 25÷40 s  
 Spray gun nozzle: Ø1.6÷1.8 mm  
 Operating pressure: 2-4 bar

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**Volatile organic compounds content:**

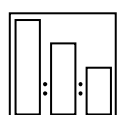
VOC II/B/c limit\* = 540 g/l  
Actual VOC = 510 g/l

\* For ready to use mixture acc. to EU Directive 2004/42/EC

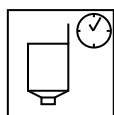
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**Procedure:**

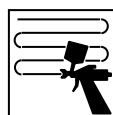
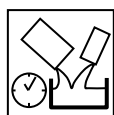
Apply in two wet layers, leave each to flash off for 5÷10 minutes at 20°C. The flash-off time depends on the temperature and the layer thickness.



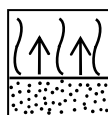
Ratio: DIN 4/20°C  
2+1+10-20% 25÷40 s



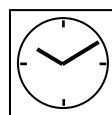
5 h/20°C



2X, 2÷4 bar  
Ø 1.6÷1.8 mm



5÷10 min  
1 h/60°C



12 h/20°C



P360 – P500



P600-1000

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**Layer thickness:** 40÷60 µm per layer

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**Curing time:** 12 h at 20°C; 1 h at 60°C, for a maximum of two layers.

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**Theoretical yield:** The complete mixture (1 l of the primer + the correct ratio of the hardener) gives ca. 7 m<sup>2</sup> of ca. 80 µm thick layer.

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**Recommended sand paper grades:**

Dry machine sanding:	P360 ÷ P500
Dry hand sanding:	P400 ÷ P500
Wet machine sanding:	P600 ÷ P1000
Wet hand sanding:	P800 ÷ P1000

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**Colour:** Grey

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**Equipment cleaning:** NC solvent

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**Storage conditions and shelf life:**

Store in a dry and cool room, away from sources of fire and heat. Avoid direct exposure to sunlight.

PRIMER 500

Epoxy primer: 24 months at 20°C.

PRIMER HÄRTER

Hardener for epoxy primer: 24 months at 20°C.

THINNER Acrylic, epoxy and basecoat thinner:  
24 months at 20°C.

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**Safety regulations:** See the Safety Data Sheet of the product.

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**Other information:**

Registration number: 000024104.

The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.