

58-3016

EPOXY PRIMER GREEN

Epoxy Primer

VERSION

Version 1

Date 10 January, 2020

PRODUCT DESCRIPTION

A Two-component Epoxy Primer that contains epoxy resin as the first part and Polyamide as the second part. It provides excellent adhesion to all metals and protects against harsh conditions that can cause rust on steel surface. In addition, it can be used as heavy build filler without affecting the gloss of top/base coat.

SUITABLE SUBSTRATE

Direct to steel
 Direct to Aluminum
 Direct to galvanized steel
 OEM Electro coat [E-coat]
 Existing finishes
 Glass Reinforce Polyester laminates
 Polyester Body filler

KEY CHARACTERISTICS

- Quick dry
- Epoxy Primer
- Easy to sanding
- Good adhesion on metal
- Protective primer

PHYSICAL PROPERTIES

Color	Green
Supply viscosity	70 - 75 KU at 30 °C
Specific gravity	1.35 – 1.45 g/cm ³
Shelf Life	1 Year, Store in average temperature between 40 – 95 °F (5 – 35 °C). Avoid too much temperature fluctuation or direct contact with sunlight. Suitable storage temperature is 70 °F or 21°C

MIXING AND RELATED PRODUCTS

Mixing Ratio	Paint : Hardener : Thinner [4 : 1 : 215-20%] [by Volume]
Hardener	Epoxy hardener 4:1 # 21-17 or recommended by our technician
Reducer Thinner	Epoxy thinner #85-57

APPLIED CONDITION

Spray Viscosity at 25°C	Zarn Cup#2	20 – 24 seconds		
	FORD 4	11 – 16 seconds		
Spray equipment		Fluid tip	Spray distance	
	Gravity feed	1.2-1.4 mm	15-20 cm	
	Suction feed	1.4 -1.6 mm	15-20 cm	
	HVLP	1.2-1.4 mm	10-15 cm	
	Pressure feed	1.0-1.2 mm	15-20 cm	
Spray pressure		Overall and panel repair	Spot repair	
	Gravity feed	3-4 bar	2.0-2.5 bar	
	Suction feed	3-4 bar	2.0-2.5 bar	
	HVLP	0.7 bar at nozzle	0.7 bar at nozzle	
	Pressure feed	4-6 bar	-	
Number of coats	2 – 3 coats			
Film Thickness	60 - 80 micron [Total dry film]			
Cover rate	Approximately 35-50 m ² . / liters of un-mixed paint per single coat.			
Touch dry	15-20 °C	21-25 °C	25-30 °C	30-40 °C
	50-60 min	40-50 min	30-40 min	20-30 min
Hard dry	15-20 °C	21-25 °C	25-30 °C	30-40 °C
	10-12 hr	8 – 10 hr	7 – 8 hr	6 - 8 hr
Surface Preparation	with soap and water. Rinse and wipe dry with clean cloth. Finally, clean surface using Wiping Solvent #85-4 (slow) or #85-7 (fast) with clean cloth. Sand steel, aluminum, or galvanized metal with 150 – 240 grit sand paper. Primer can be applied direct to metal; however, for improved adhesion to metal, we recommend priming with Epoxy Primer #58-xxxx or Etch Primer/Wash Primer #82-xxxx. OEM or Original Paint must be cured and sanded with 150 – 240 grit sand paper. Clear or lacquer must be sanded with 150 – 240 grit sand paper before to avoid lifting. Body filler or fiberglass must be sanded with 150 – 240 grit sand paper.			
Sanding step	Final dry sanding by #P500 to #P600 before apply Topcoat			
	- Initial sanding steps may be executed with a coarser sanding grit #P320 to #P400			
Surface cleaning	Final wet sanding step #P800 before apply Topcoat			
	- Initial sanding steps may be executed with a coarser sanding grit P600 – P800t a maximum 200 sanding grit step difference or less throughout the sanding procedure.			
Surface cleaning	Remove any surface contamination prior to the application of topcoat using an appropriate surface cleaner			

PRECAUTION

Warning	For professional or trained applicator use only. Not for sale or use by the general public. Before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep outreach of children. Always wear approved organic vapor goggle and safety mask when using product. Apply paint in good ventilating area.
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