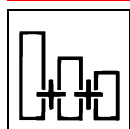


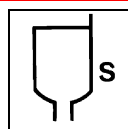


04384 - EPOFAN PRIMER R-EC GRIGIO



1000 ml +
500 ml +
250-500 ml

Pot life at 20° C:
2-8 hours



20-30" FC 4
at 20° C



Ø 1,8-2 mm
3,5-4,5 Bar
HVLP:
Ø 1,6-1,8 mm
2-2,5 Bar
N° of coats: 2



Air drying at 20°C
12-24 hours
Low bake:
30-40 min at 70-80° C
60-90 min at 50-60° C

DESCRIPTION

Grey two-pack primer based on epoxy resins and anticorrosive non-polluting pigments.

USE

Primer suitable for all metallic surfaces and for fibreglass (GFRP).

CHARACTERISTICS

- Suitable as an anticorrosive primer under polyester putties
- Excellent adhesion to stainless steel, aluminium, light alloys, zinc coated sheets, concrete.
- High anti-corrosive power
- Good filling power
- The product may be used without sanding in "wet-on-wet" systems (with 00103 EPOFAN R-EC HARDENER W/W)
- Chromate- and lead-free
- Sealer for thermoplastic lacquers

SUBSTRATE PREPARATION

Carbon steel, stainless steel, aluminium and light alloys, hot dip galvanized steel sheet. Sand and degrease with 00695 SILICONE REMOVER SLOW.

Galvanized steel sheets: degreased with 00695 SILICONE REMOVER SLOW.

APPLICATION

Spraying.

Mixing ratio:

a) For general use, preferably in case of low baking, prepare the following mixture:

| | volume | weight |
|-----------------------------------|--------------|-------------|
| 04384 EPOFAN PRIMER R-EC GRIGIO | 1000 ml | 1000 g |
| 00305 EPOFAN R-EC HARDENER | 500 ml | 300 g |
| 00535 EPOFAN THINNER or | 250 - 500 ml | 150 - 300 g |
| 00556 LECHSYS EPODUR PF THINNER * | | |

*for extra-EEC countries only

Pot life: 6 - 8 hours at 20 °C

b) For “wet-on-wet” systems:

| | volume | weight |
|---|---------------|---------------|
| 04384 EPOFAN PRIMER R-EC GRIGIO | 1000 ml | 1000 g |
| 00103 EPOFAN R-EC HARDENER W/W | 500 ml | 300 g |
| 00535 EPOFAN THINNER or 00556 LECHSYS EPODUR PF THINNER * or 00544 EPOFAN THINNER SLOW ** | 250 - 500 ml | 150 - 300 g |

***for extra-EEC countries only**

**** Special product – Available upon request**

Pot life: 4 hours at 20 °C

c) In winter use the product at average temperatures of 12-13°C in the following mixture:

| | volume | weight |
|--|---------------|---------------|
| 04384 EPOFAN PRIMER R-EC GRIGIO | 1000 ml | 1000 g |
| 00451 EPOFAN R-EC HARDENER FAST | 500 ml | 300 g |
| 00535 EPOFAN THINNER or 00556 LECHSYS EPODUR PF THINNER * | 250 - 500 ml | 150 - 300 g |

***for extra-EEC countries only**

The film obtained with this mixture may be overcoated through “wet-on-wet” system.

Pot life: 2 hours at 20 °C

Spray viscosity: 20 - 30" FC4

Ø Air cap: 1,8 - 2 mm; HVLP 1,6 - 1,8 mm

Air pressure: 3,5 – 4,5 Atm; HVLP 2 - 2,5 Atm

N° of coats: 2 normal

Recommended film thickness: 80-100 µ

Coverage (theoretic value): 1l mixture = 7,4 m² at 50 µ

1 kg mixture = 6,2 m² at 50 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l

This product ready for use contains at most 540 g/l VOC

DRYING TIME

a) **With 00305 EPOFAN R-EC HARDENER**

- Air drying: at not less than 20 °C sand after 12 - 24 hours

- Low bake: at 70 - 80 °C sand after 30 - 40 min.

at 50 - 60 °C sand after 60 - 90 min.

b) **With 00103 EPOFAN R-EC HARDENER W/W (for wet-on-wet process)**

Wait at least 30 - 40 min. at 20 °C prior to applying/reapplying the finishing topcoat.

c) **With 00451 EPOFAN R-EC HARDENER FAST (hardener for low temperatures)**

Flash-off and drying times depend on the temperature. Generally the enamel or the sealing coat may be overapplied through “wet-on-wet” system after 2 hours at 12°C, while sanding may occur after 24 hours at 12-13°C.

OVERCOAT WITH

Two-pack fillers and topcoats within the Lechler range.

NOTES

As for all epoxy products, EPOFAN PRIMER R-EC GRIGIO 04384 catalysed with HARDENERS 00305 and 00103 **must not be** air dried at temperatures below 15 °C.

Under this temperature a through-hardening cannot be achieved and as a consequence some defects in the painting system may occur.

HARDENER 00451 is not recommended in summer as the pot-life is reduced to a few minutes.

TECHNICAL DATA SHEET N° 0197-GB

UPDATED 09/2018

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