Technical Data Sheet

ISOLATOR PRIMER

Isolating epoxy primer with anti-corrosion additives

RELATED PRODUCTS

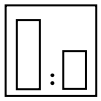
ISOLATOR PRIMER
HARDENER

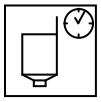
Hardener for Isolator Primer

PROPERTIES

- Fast-drying epoxy primer
- Excellent adhesion to metal parts
- Good insulating performance
- Wet on wet application

SUBSTRATES	
Old paint layers, including thermoplastic ones	Degrease and dry sand with P220 - P360.
Polyester putties	Dry sand, finishing levelling with P240 - P320.
Steel	Clean steel surfaces to Sa $2^{1}/_{2}$ (wet blasting) or St3 (manual cleaning or with a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free of oil, grease, dust, loose old paint layers, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.
Aluminium	Degrease and dry sand with P280 - P360 or matt with an abrasive cloth, then degrease again.
Galvanized steel	Degrease, matt with a fine abrasive cloth, and degrease.
Stainless steel	Degrease.
Polyester laminates	Degrease and dry sand with P280.

MIXING RATIO			
		Volume ratio	Weight ratio
	ISOLATOR PRIMER	1	100
	ISOLATOR PRIMER HARDENER	1	52

VISCOSITY		
	DIN 4/20°C	14 - 15 s

VOC CONTENT	
VOC II/B/c limit*	540 g/l
Actual VOC content	537 g/l

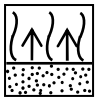
* For a ready to apply mixture acc. to EU Directive 2004/42/EC

APPLICATION CONDITIONS

It is recommended to apply the primer at over 15°C and at a humidity of 80%.

APPLICATION

		Nozzle	Pressure	Distance
	Conventional gravity fed spray guns	1.3 - 1.4 mm	2 bar	15 - 20 cm
CAUTION: Follow the equipment manufacturer's guidelines	Low-pressure spray guns Gravity fed HVLP guns	1.2 - 1.3 mm	2 bar	10 - 15 cm

	Number of coats	1 - 3
	CAUTION: When applying directly on bare steel, the primer coat must be 80 µm or thicker for proper anti-corrosion protection.	
	Dry coat thickness: 1 layer 2 coats 3 coats	 20 - 30 µm 40 - 60 µm 60 - 90 µm
	The yield of the ready to use mixture for the given range of dry coat thicknesses	13.0 m^2/l at 30 µm
	Mixture life at 20°C	6 h
	Flash-off time between coats	5 - 10 min
APPLICATION OF FILLERS/PUTTIES OVER THE ISOLATOR PRIMER		
	ISOLATOR PRIMER layers	1
	ISOLATOR PRIMER drying time	30 min
CAUTION: Recoat the system within 12 hours. Sand down ISOLATOR PRIMER after 12 hours.		
BASECOAT OR COLOUR TOPCOAT APPLICATION OVER THE ISOLATOR PRIMER		
	ISOLATOR PRIMER layers	1 - 2
	ISOLATOR PRIMER drying time	15 min
CAUTION: Recoat the system within 12 hours. Sand down ISOLATOR PRIMER after 12 hours.		
CURING TIME		
	Time to sand	20℃ / 3 h; 60℃ / 45 min
CAUTION: The curing times apply to the temperatures of the individual elements.		
IR DRYING		
	Distance	Follow the recommendations of the equipment manufacturer
	Time depends on the lamp type and power	10 - 20 min
CAUTION: Start IR heating no earlier than 10 minutes after applying the final coat.		

SANDING		
	Dry sanding	P360 - P500
	Wet sanding	P600 - P1000

EQUIPMENT CLEANING

Epoxy thinner.

STORAGE CONDITIONS

Store in a cool dry room, away from sources of fire and heat.

Avoid direct exposure to sunlight.

SHELF LIFE

ISOLATOR PRIMER	24 months/20℃
ISOLATOR PRIMER HARDENER	24 months/20℃

SAFETY

See the Safety Data Sheet.

OTHER INFORMATION

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, providing 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.

ISOLATOR PRIMER

WEIGHT QUANTITY OF COMPONENTS:

CAUTION! It is very important to precisely dose the specific components to obtain a primer with suitable performance parameters.

Mixture quantity	ISOLATOR PRIMER	ISOLATOR PRIMER HARDENER
0.10 l	80 g	41.5 g
0.20 l	160 g	83.0 g
0.30 l	240 g	124.5 g
0.40 l	320 g	166.0 g
0.50 l	400 g	207.5 g
0.75 l	600 g	311.0 g
1.00 l	800 g	415 g
2.00 l	1600 g	830 g