

# 2K Epoxy Primer

Technical Data Sheet

26 / 01 / 2018

L2.05.01 U.K & Ireland

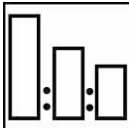



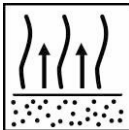
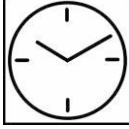


Primers/Surfacers

## LESONAL

### Description

Two component, VOC compliant, mild chromate free epoxy primer for refinishing cars, chassis and also light commercial vehicles. Perfect substrate for Body fillers and Polyester spraying filler, for restoration, new work and repairs. Gives good chemical and corrosion resistance and is very mild for soft substrates such as powder slurries

### Sanding version

Mixing ratio		5 2.5 2	2K Epoxy Primer Hardener Epoxy Primer Multi Thinner
Mixing stick		<b>K</b>	
Equipment		Spray gun set-up: 1.5-1.9 mm	Application pressure: 1.7 – 2.2 bar* <small>*refer to user manual spray gun</small>
Application		2 - 3 x 1 coat	
Flash-off		Between coats 5 - 10 minutes at 20°C	
Drying		20°C 8 hours	60°C 45 minutes
Recoatability		Topcoat HS 420	Basecoat WB GT
Protection			

Read complete technical data sheet for detailed product information

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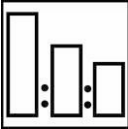



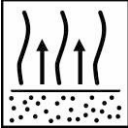


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Two component, VOC compliant mild chromate free epoxy primer for refinishing cars, chassis and also light commercial vehicles. Perfect substrate for Body fillers and Polyester spraying filler, for restoration, new work and repairs. Gives good chemical and corrosion resistance and is very mild for soft substrates such as powder slurries

## Non Sanding version

<b>Mixing ratio</b>		2 1 1	2K Epoxy Primer Hardener Epoxy Primer Thinner 540 Non Sanding
<b>Mixing stick</b>		<b>K</b>	
<b>Equipment</b>		Spray gun set-up: 1.4-1.7 mm	Application pressure: 1.7 – 2.2 bar* <small>* refer to user manual spray gun</small>
<b>Application</b>		1 x 1 coat	
<b>Flash-off</b>		Before topcoat 15 - 20 minutes at 20°C	
<b>Recoatibility</b>		Topcoat HS 420	Basecoat WB GT
<b>Protection</b>			

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<b>Product &amp; ancillary items</b>	
<b>Product</b>	2K Epoxy Primer
<b>Hardener</b>	Hardener Epoxy Primer
<b>Thinners</b>	Multi Thinners
<b>Chemical Basis</b>	2K Epoxy Primer – Epoxy resins Hardener Epoxy Primer – Amine resins Multi Thinners – A blend of organic solvents
<b>Method of use</b>	
<b>Substrates</b>	Sound original finishes, with the exception of thermoplastic acrylics OEM electro coat Steel Aluminum Galvanized steel Stainless steel Polyester laminates Wood or plywood Polyester bodyfiller or Polyester Spraying Filler <b>OEM E-coated primers:</b> Sanding is not necessary, thoroughly cleaning and degreasing is sufficient.
<b>Substrate preparation</b>	Prior to commencing any sanding work, thoroughly cleanse the surface with Lesonal Degreaser. Existing finishes: Degrease and dry sand with P320-grit or with wet sanding P600 grit OEM E-coated primers: Sanding is not necessary, thoroughly cleaning and degreasing is sufficient. Aluminum and stainless steel: Degrease, scuff with Scotch Brite Type A and degrease again. Steel, zinc-coated steel, and polyester: Degrease and dry sand with P180-P280 grit; if necessary, blast-clean steel surfaces. Wood or plywood: Dry sand with P180-P280-grit to achieve a smooth surface to remove loose fibers from the surface. Lesonal body fillers and spraying filler: Dry sand dry with P220-P320-grit
<b>Tinting</b>	2K Epoxy Primer can be tinted with Topcoat HS 420 without hardener up to a maximum 5 percent by weight.



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**Mixing Ratio sanding version**

*Mixing stick K*

- 5 parts by volume: 2K Epoxy Primer
- 2.5 parts by volume: Hardener Epoxy Primer
- 2 parts by volume: Multi Thinner

**Mixing Ratio non sanding version**

*Mixing stick K*

- 2 parts by volume: 2K Epoxy Primer
- 1 parts by volume: Hardener Epoxy Primer
- 1 parts by volume: Thinner 540 Non sanding

**Spraying Viscosity**

25 – 30 sec. DIN Cup 4 at 20° C.

**Pot life**

After mixing, use within:  
6 hrs. at 20°C.

**Spraying pressure sanding:**

Spraygun	Fluid opening	Spraying pressure
HVLP Gravity	1.5 – 1.9 mm	0.7 bar (at aircap)*
LVLP (HR) Gravity	1.5 – 1.9 mm	1.7 – 2.2 bar (at inlet)*
Conventional Gravity feed	1.5 – 1.7 mm	1.7 – 2.2 bar (at inlet)*
<b>Spraying pressure non sanding:</b>		
HVLP Gravity	1.4 – 1.7 mm	0.7 bar (at aircap)*
LVLP (HR) Gravity	1.4 – 1.7 mm	1.7 – 2.2 bar (at inlet)*
Conventional Gravity feed	1.4 – 1.6 mm	1.7 – 2.2 bar (at inlet)*
<i>*refer to user manual spray gun used</i>		

**Application Technique**

**Sanding:**

Apply 2-3 single coats, allowing a flash off time of 5 to 10 minutes between coats.  
If applied by brush, do not add thinner.  
Apply only one coat of 2K Epoxy Primer if Polyester Body Filler or Polyester Spraying Filler will be applied.

**Non sanding:**

Apply 1 single coat, allowing a flash off time of 15-20 minutes before topcoat

(Drying times will be very much influenced by factors such as temperature and air movement at the time of application).

**Film Thickness sanding  
Non sanding**

30-35 micron per coat  
20-25 micron

**Theoretical use per ltr/m<sup>2</sup>**

At a layer thickness of 1 micron 405 m<sup>2</sup> /liter ready for use mixture



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<b>Cleaning Equipment</b>	Use Multi Thinner or nitrocellulose thinner.		
<b>Drying Times</b>		<b>at 20° C</b>	<b>at 60° C</b>
	Dust-dry	15 min.	5 min.
	Tack free	30 min.	10 min.
	Hard dry	8 hrs.	45 min.
	Recoatible with Polyester Bodyfillers after:	45 min.	15 min.
	fillers / topcoats after:	30 min.	10 min.
	<b>Infra red short wave equipment</b>	<b>Half power</b>	<b>Full power</b>
		3 min.	9 min.
<b>Recommended sandpaper grades</b>	<b>Method</b>	<b>Initial sanding</b>	<b>Final sanding</b>
	Wet, by hand	P500-P600	P800-P1000
	Wet, by machine	P500-P600	P800-P1000
	Dry, by hand	P320-P360	P400-P500
	Dry, by machine	P320-P320	P400-P500
<b>Recoatibility</b>	Topcoat HS 420 and Basecoat WB GT		
<b>Color</b>	Light grey		
<b>VOC</b>	<b>2004/42/II B(c)(540)540</b> The EU limit value for this product (product category: IIB.c) in ready to use form is 540 g/liter of VOC. The VOC content of this product in ready to use form is max. 540 g/liter.		
<b>Shelf life</b>	2K Epoxy Primer:	1 year	
	Hardener Epoxy Primer:	1 year	

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## **AkzoNobel Coatings LTD**

**Address:** Unit 2B, Didcot Park,  
Churchward Road, Southmead Industrial Estate,  
Didcot, Oxfordshire, OX11 7HB

**Tel:** 00 44 (0)1235 862226 **FOR PROFESSIONAL USE ONLY**

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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### **Head Office**

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