

# HP EPOXY PRIMER 1.855.9900

## PRODUCT DESCRIPTION - GREY

**HP Epoxy Primer** is a 2-pack epoxy primer-filler with good anti-corrosion properties. It is extremely fast in drying time when used as sealer or surfacer and offers very good adhesion to a wide variety of substrates, including Aluminium, galvanized steel and GRP.

**HP Epoxy Primer** can be used as a sealer over critical substrates (i.e. OEM powder clear).

**HP Epoxy Primer** can be directly recoated with polyester stopper, after drying and sanding. It is used mostly in wet on wet systems but can be stoved and flatted if required.



## SUBSTRATES PREPARATION

Before and after any sanding operation, substrates must be thoroughly degreased and sanded.

**Substrates:**

Galvanized metal, Cast iron  
 Aluminium and light alloy  
 Stainless steel  
 Fiber glass, gel-coat  
 Old paintwork in good condition and sanded

**Preparation:**

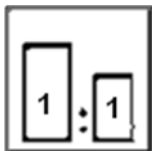
P80-120  
 P280-320 (dry)  
 P80-120  
 P320  
 P280-320 (dry)



## PREPARATION

Thoroughly clean the surface to be painted.

	SANDABLE SURFACER	WET ON WET	SEALER SURFACER
MIXING RATIO	VOLUME	VOLUME	VOLUME
HP EPOXY PRIMER	1	1	1
HP EPOXY HARDENER	1	1	1
THINNER	na	na	0.5
VISCOSTY-DIN4 20° C.	17"	17"	15"
POT LIFE	16 hours @ 20° C	16 hours @ 20° C	16 hours @ 20° C



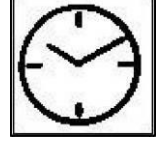
## HARDENERS - THINNERS

HARDENER	1.956.9500	HP Epoxy Hardener
THINNER	1.911.4310	

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## APPLICATION - FLASH OFF AND DRYING

	SANDABLE SURFACE	WET ON WET SURFACER	SEALER SURFACER
<b>Spray gun set up</b>			
Gravity spray gun (mm)	1,4	1,4	1,4
Suction spray gun (mm)	1,8	1,8	1,6
Pressure at the gun (bar)	4	4	4
Number of coats	2 - 4	2 - 4	1 full
<b>Flash of at 20° C.</b>			
Between coats	10 minutes	5 – 10 minutes	na
Before topcoat	na	15 minutes	10 minutes
<b>Drying Time *</b>			
Dust free @ 20° C.	15 minutes	15 minutes	na
Through dry @ 20° C	4 hours	na	na
Through dry @ 60° C.	30 minutes	na	na
<b>Dry film thickness</b>			
Minimum	40 microns	25 microns	15 microns
Maximum	60 microns	35 microns	20 microns
<b>Theoretical coverage **</b>	6 - 6.5 mq/l	6.5 - 7 mq/l	9 - 10 mq/l



\* Stoving times are for quoted metal temperature. Additional time should be allowed in the stoving schedule to allow metal to reach recommended temperature.

\*\* Assuming 100% transfer efficiency and dry film thickness as indicated.

**Important:**

Applications with temperature below 15° C. and relative humidity over 85% require longer drying times.

## RECOATABILITY

	SANDABLE SURFACE	WET ON WET SURFACER	SEALER SURFACER
Sanding Overcoat/Recoat	P320 Any MaxMeyer 2K Filler and Topcoat	Not necessary in Any MaxMeyer	normal use 2K Topcoat



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## PERFORMANCE AND LIMITATIONS

The use of HVLP gun can lead to 10% increase of transfer efficiency according to the spray gun brand and model.

**HP Epoxy Primer** must be used with the specific hardener (1.956.9500)

**HP Epoxy Primer** should not be used at temperatures lower than 10°C and humidity higher than 80%.

**HP Epoxy Primer** must be recoated within 1 week after the application, after this time, surface must be scuffed with medium coarse Scotch Brite, degreased with 1.931.3600 and a coat of **HP Epoxy Primer** re-applied. Leave 45' flash-off before Topcoat application.

If applied over TPA finishes, **HP Epoxy Primer** must be recoated within 8 hours.

After use, clean all equipment thoroughly with cleaning solvent or thinner.

## TECHNICAL DATA

Pack size	1 Ltr primer - 1 Ltr hardener
Storage	In a cool dry place away from heat



## SAFETY AND HANDLING

**These products are for professional use only** and are not to be used for purposes other than those specified.

The information on this TDS is based on present scientific and technical knowledge, and it is the responsibility of the user to take all necessary steps in order to ensure the suitability of the product for the intended purpose.

For Health and Safety information, please refer to the material Safety Data Sheet, also available at:

[www.maxmeyer.com](http://www.maxmeyer.com)



For further information please contact:

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