

TECHNICAL INFORMATION

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Product name: Two-component epoxy primer APP Grunt EP 3:1. APP No. 021201.

Two-component, chromate-free, epoxy filler primer with 2K-zinc phosphate.

Intended for active corrosion protection on cars, buses and trucks. Very good adhesion to steel, galvanized steel, aluminum, glass-fibre reinforced plastics, and mineral substrates. For conventional use with grinding, wet-on-wet, as an adhesion primer, and as an insulator on substrates such as thermoplastics.

Packaging: APP Grund EP - 1.0 kg,
APP Harter Grund EP - 0.2 kg.

Product and additives: APP Grund EP - epoxy primer,
APP Harter Grund EP - hardener of standard binding time,
APP Epoxy Verdunnung - epoxy thinner.

Specification: Color: Light gray.
Binder: Epoxy resin.
Solids content: 65%-68% by weight.
Delivery viscosity (DIN 53211): Thixotropic.
Specific gravity (DIN EN ISO 2811 (kg/l): 1.4-1.5
Gloss (DIN EN ISO 2813 60°): 10-20 matt.

Spreading rate: 35.8 - 36.8 m²/kg for 10 µm dry film.

Caution!

In practice, performance depends on factors such as object shape, substrate roughness, application method and working conditions.

Properties

- Excellent active corrosion protection,
- good insulating properties on thermoplastic substrates,
- high resistance to mechanical damage,
- exceptional temperature resistance:
continuous action: 150°C; short-term action: 180°C,
- Adhesion test (DIN 53151): steel: Gt 0 (very good); zinc:
Gt 0 (very good); aluminum: Gt 0 (very good)
- Can be applied electrostatically.

Substrate

Suitable substrates: Ferrous metals, steel, galvanized steel, aluminum, fiberglass reinforced materials, mineral substrates.
Grounded OEM factory finish and old refinish coatings.
Surfaces pre-treated with polyester products
e.g. APP Ultra. Thermoplastic substrates.

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Substrate preparation:



- Steel: cleaned with P120-P220, possibly sandblasted (remove all traces of rust, scale, oxides, and rolling residues to SA 2½ purity grade), with removed dust and degreased with APP W900 anti-silicone remover,

APP W911.

- Galvanized steel: dry finish sand P220-P320, dust off and degrease using APP W900 or APP W911 antisolicone remover, or an alkaline ammonia agent, e.g: 10 l water + 0.5 l ammonia + 25 ml detergent.
- Aluminum: clean with P360-P400, if necessary sandblast, dust off, and degrease with APP W900 antisolicone remover,

APP W911.

- Existing finishes: dry sand P220-P320, dust off, and degrease with an anti-silicone remover.

APP W900, APP W911.

Application examples:

As insulating primer with 30% dilution and spray gun with 1.3 nozzle to cover (1-2 x 1) is ready for repainting with acrylic primer:

- at +20°C: 45 min.
- at +60°C: 15 min.

As a primer ready for repainting after a minimum of 60 minutes:

Steel, galvanized:

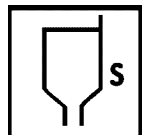
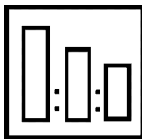
- priming: APP Grunt EP 50-70 µm,
- top coat: APP Modular 2K Acryl Line 50-60 µm.

Aluminum:

- priming: APP Grunt EP 25-30 µm,
- top coat: APP Modular 2K Acryl Line 50-60 µm.

Use

Mixing ratios:



A) Volume mixing proportions:

3 volumes APP Grunt EP
1 volume APP Harter Grund EP
20-30% APP Epoxy Verdunnung
Spraying viscosity: 20-30 s 4 mm DIN /+20°C.

B) Mixing ratios by weight:

5 APP Grunt EP
1 APP Harter Grund EP
0.9 APP Epoxy Verdunnung

Caution!

Use only APP Harter Grund EP hardener.

Do not exceed recommended hardener dosage.

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APP Grunt EP 3:1	APP Harter Grund EP	APP Epoksy Verdunnung		
Ratios volume	3 : 1		+20%	+25%
	Mixing ratio by weight			
L	[g]	[g]	[g]	[g]
0.1	153.6	31.3	22.1	27.7
0.2	307.2	62.7	44.3	55.3
0.3	460.8	94	66.4	83
0.4	614.4	125.3	88.5	110.7
0.5	768	156.7	110.7	138.3
0.6	921.6	188	132.8	166
0.7	1075.2	219.3	154.9	193.7
0.8	1228.8	250.7	177.1	221.3
0.9	1382.4	282	199.2	249
1.0	1536	313.3	221.3	276.7

Application:



A) Pneumatic Spraying.

Apply with a spray gun equipped with a nozzle
ø1.3-ø1.8 mm at air pressure between 2.0 and 2.5 bar.

B) Hydrodynamic spraying.

To spray the primer by hydrodynamic method (airless), use a
mixture with 10%-15% diluent and a nozzle 0.28-0.33mm at
100-120 bar.



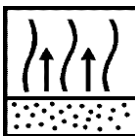
Number of coats:

- 1-3 x 1 by airless spraying,
- 1-2 x 1 by hydrodynamic spraying.

Coating thickness: 50-70 µm.

Recommended working conditions:

- minimum temperature: +10°C
- maximum relative humidity: 80%.



Evaporation time between coats at +20°C:

- 5-10 minutes.

Shelf life of ready to use mixture: 7-9 hours.

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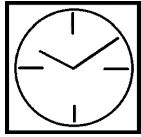


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Drying



At +20°C:	
Dust dry:	45-50 minutes
Touch resistant:	4-5 hours
Ready to install:	10-12 hours
Ready to sand:	24 hours
Repainting:	Min. 1 hour

Caution!

Spraying the topcoat without sanding is possible after 1 hour at the earliest, but not later than

but not later than 24 hours. Sanding is required after 24 hours.



At +60°C:	
Dust dry:	10 minutes
Ready to install:	45 minutes
Repainting:	-- minutes

Please note - applies to primer only!

As insulating primer with 30% dilution and spray gun with 1.3 nozzle to cover (1-2 x 1) is ready for repainting with acrylic primer:

- at +20°C: 45 min.
- at +60°C: 15 min.

Sanding



After complete curing, i.e. after 24 hours, it is necessary to sand before applying the next coat.

For example, sanding for topcoats:

- wet with abrasive P600-P1000,
- machine dry with abrasive P360-P400.

Coatability:

Polyester products e.g. APP Ultra.
Filling primers, e.g. APP AcrylFiller 401.
APP Modular Special Base lacquers.
One and two-ingredient surface lacquers,
e.g. APP Modular 2K Acryl Line.

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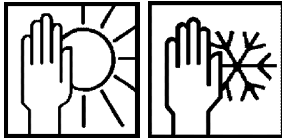
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Equipment Cleaning: Nitrocellulose solvent.

Storage:



Store in closed original containers in a dry and well-ventilated area.
Protect against freezing.

Safety and health
regulations



For professional use only.
See text on product labels or safety data sheet.

Users must comply with the health and safety regulations in force in
their country.

VOC:

VOC limit g/l in the ready to use product.

540g/l for APP Grunt EP

Maximum VOC content g/l in the ready to use product.

< 534g/l for APP Grunt EP

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