

TECHNICAL INFORMATION

Date of preparation:
3 July 2026



Date updated:
3 July 2026

1, from 4

Product name: APP Primer Epoxy Fast, a quick-drying two-component epoxy primer. APP No.: 021203.

APP Primer Epoxy Fast is a fast-drying, chromate-free, epoxy primer for wet-on-wet application. It adheres to steel, aluminium and galvanised substrates. Its excellent flow, short drying time and very good absorption of paint dust allow it to be overcoated after 20–30 minutes, for example with the APP AcrylFiller HQ Fast acrylic primer. It is designed for active anti-corrosion protection on passenger cars, buses and lorries. The anti-corrosion pigment is zinc phosphate.

Packaging.	021203 APP Primer Epoxy Fast – 1.0 L. 021204 APP Hardener Primer Epoxy Fast – 1.0 L.
Product and additives.	APP Primer Epoxy Fast – epoxy primer. APP Hardener Primer Epoxy Fast – epoxy hardener.
Specification.	Colour: RAL 7033 – olive grey (Cement grey). Binder: epoxy resin. Solids content: 78.9 per cent. Anti-corrosion pigments: yes – zinc phosphate. Specific gravity (DIN EN ISO 2811-1): 1.559 g/cm ³ .
Coverage:	13.0 – 13.5 m ² /l for 25 µm DFT (Dry Film Thickness)

Application It is designed for wet-on-wet application on passenger cars, buses and lorries. For use as a primer under acrylic undercoats and polyester spray-applied fillers, and in the classic version with sanding prior to application of a polyester filler applied with a putty knife. It adheres to steel, aluminium and galvanised substrates. It can be used as an insulating primer on glass-fibre-reinforced polyester laminate substrates.

Substrate

Suitable substrates. Cataphoresis, sanded-down OEM factory coatings.
Steel, galvanised sheet steel, aluminium, polyester laminates.
Polyester fillers, spray-applied filler.
Existing finishes.
Warning!
Do not apply APP Primer Epoxy Fast to reactive primers (wash primers), including APP Haftgrund.

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Substrate preparation.



Thoroughly remove any areas of corrosion.

Sand steel with P120–P150 sandpaper.

Sand aluminium with P220–P280 sandpaper.

Sand existing finishes and polyester products dry using P240–P320 sandpaper.

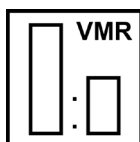
Wet-sand surfaces coated with factory-applied paints and primers using P320–P360 sandpaper.

Before spraying the primer, clean the surface to be treated of dust and degrease it using APP W900 or APP W911 degreaser.

Application

Mixing ratios.

A. Mixing ratios by volume.



1 part

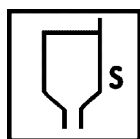
APP Primer Epoxy Fast

1 part

APP Hardener Primer Epoxy Fast

Spray viscosity:

16–22 s at 4 mm DIN/+20°C.



B. Mixing ratio by weight.

100 g

APP Primer Epoxy Fast

57 g

APP Hardener Primer Epoxy Fast

Volume of ready-to-use product	Mixing ratios by weight	
	APP HQ Fast Epoxy Primer	APP Hardener HQ Fast Epoxy Primer
	100	57.09
[L]	[g]	[g]
0.1	77.95	44.50
0.2	155.9	89.00
0.3	233.9	133.5
0.4	311.8	178.0
0.5	389.8	222.5
0.6	467.7	267.0
0.7	545.7	311.5
0.8	623.6	356.0
0.9	701.6	400.5
1.0	779.5	445.0

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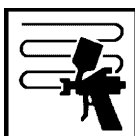
3, from 4

Product name: APP Primer Epoxy Fast, a quick-drying two-component epoxy primer. APP No.: 021203.

Application.



Apply using a spray gun fitted with a nozzle
 $\varnothing 1.3\text{--}\varnothing 1.6$ mm at an air pressure of 1.6 to 2.2 bar.

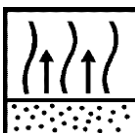


Number of coats: 1–2 x 1.

Dry film thickness: 25–50 μ m DFT.

Recommended operating conditions:

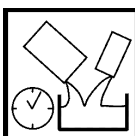
- minimum temperature: +10°C,
- maximum relative humidity: 80 per cent.



Flash-off time between coats at +20°C:

5–8 minutes.

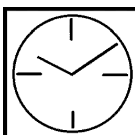
Evaporation time prior to forced drying at +60°C: 10–15 minutes.



Shelf life of the ready-to-use mixture:

~ 4 h / + 20°C.

Drying.



At +20°C for 25 μ m DFT:

Ready for topcoat 20–30 minutes.

application:

Dust-dry: 10–15 minutes.

Touch dry: 1.5–2 hours.

Ready for sanding: 3–4 hours.

At +60°C for 25 μ m DFT:

Touch dry: 30 minutes.

Ready for sanding: 30 minutes.

Wet-on-wet application possible:

- after 20 minutes at +20°C
for 25 μ m DFT and 30 minutes for 50 μ m DFT,
- after 48 hours, the primer must be sanded.

Filling possible for 25 μ m DFT after:

- 30 minutes at +60°C,
- 12 hours at +20°C.

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Sanding.



Once fully cured, sand the polyester filler:

- dry with an abrasive cloth, an abrasive sponge or P150–P220 sandpaper,

Once fully cured, sand the surface before applying acrylic primers as follows:

- machine-sand dry using P240–P320 sandpaper,

Once fully cured, sand the surface prior to applying topcoats as follows:

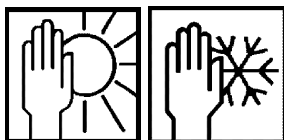
- dry machine sanding with P360–P500 sandpaper,
- wet sand with P600–P1000 sandpaper.

Coverage.

All APP polyester fillers and all APP acrylic primers, e.g. APP AcrylFiller HQ Fast, and APP Industrial Line polyurethane primers. Water-based and organic (conventional) base coats e.g. APP Modular Specjal Base. Single-component and two-component topcoats e.g. APP Modular 2K Acryl Line or APP Modular Industrial Line.

Cleaning of equipment. Nitrocellulose solvent.

Storage



Store in sealed original containers in a dry, well-ventilated room. Protect from freezing.

Health and safety regulations



For professional use only.

See: the text on the product labels or in the

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

VOC

Permissible VOC content (g/l) in the ready-to-use product.

540 g/l APP Primer Epoxy Fast
for

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

540 g/l APP Primer Epoxy Fast
for

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