

## TECHNICAL INFORMATION

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### **Modular Industrial Line** **Product name: epoxy primer** **APP Primer EP 30-620 Grey 4:1. APP No.: 0276621.**

Anti-corrosive, two-component epoxy primer in grey. It is intended for priming surfaces made of any metal, such as: iron, steel, galvanised steel, aluminium and for coating with any topcoat from the APP Modular Industrial Line system. Allows wet-on-wet working.

Product and accessories.	APP Primer EP 30-620 Grey, APP Hardener Primer EP 30-720, APP Thinner Universal 30-810.
Basic ingredients.	APP Primer EP 30-620 Grey – epoxy binder and additives, APP Hardener Primer EP 30-720 – normal isocyanate hardener. APP Thinner Universal 30-810 – universal thinner.
Colour.	Grey.
Surface texture.	Smooth.
Gloss.	Matt.
Specific weight.	1.7 kg/L at 20°C
Binder solids content.	72-77% (by weight) 55-59% (by volume)
Solids content of ready-to-use primer without thinner.	68-72% (by weight) 52-56% (by volume)
Theoretical efficiency.	For binder: <ul style="list-style-type: none"><li>• 650-700 m<sup>2</sup>/L for 1 µm dry layer.</li></ul> For ready-to-use primer without thinner: <ul style="list-style-type: none"><li>• 510-560 m<sup>2</sup>/L for 1 µm dry layer.</li></ul> Note! In practice, efficiency depends on factors, such as the shape of the object, the roughness of the substrate, the application method and the working conditions.

The above information is in line with the current state of knowledge of our products and their possible applications. This does not guarantee specific properties or suitability for use under specific conditions. Follow the notes and warnings on the product labels and on the safety data sheet. We assume no liability if the final result of the work was influenced by factors beyond our control.

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Corrosion protection class  
according to ISO 12944.

For (240µm + 60µm): APP Primer EP 30-620 Grey  
+ Lack PUR 30-200 Gloss

- for corrosion class C5, durability H (from 15 to 25 years).

For (240µm + 60µm): APP Primer EP 30-620 Grey  
+ Lack AY/PUR 30-100 Gloss

- for corrosion class C5, durability M (from 7 to 15 years).

Application.

Designed for priming commercial vehicles, tractor frames and trailers, agricultural machinery, tanks, machine parts and steel structures.

Advantages

- Direct adhesion to iron, steel, stainless steel, galvanised steel, cast iron, aluminium, ABS, PVC, methyl acrylates.
- Can be applied by air, hydrodynamic and mixed spraying systems, as well as electrostatically.
- Can be coated with any topcoat from the APP Modular Industrial Line system.

Substrate

Direct adhesion to iron, steel, stainless steel, galvanised steel and aluminium, ABS, PVC.

Pre-sanded factory coatings.

Substrate preparation.



Steel.

- Blasting treatment to a cleanliness grade of Sa 2½.
- Manual cleaning to St 3.

The treated surface should be free of rust, scale, oil, grease, loose old coating, dust and other contaminants. It should have a uniform metallic sheen.

Galvanised steel and aluminium.

- Dry sand with P150-P240 abrasive paper.
- Very gentle blasting treatment.

Existing finishes.

- Dry sand with P240-P320 abrasive paper.

Before spraying APP Primer EP 30-620 Gray, clean the surface to be primed of dust and degrease with APP WB910 or APP W900 remover using APP Standard CT cleaner.



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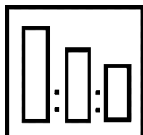
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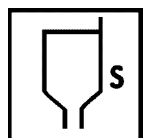
#### Application

Mixing ratios.



Mixing ratios by volume:

- 4 volumes    APP Primer EP 30-620 Gray
- 1 volume    APP Hardener Primer EP 30-720
- 10-20%    APP Thinner Universal 30-810



Spray viscosity at +20°C:            30-40 s F/4.

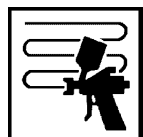
Note!

Use only APP Hardener Primer EP 30-720.  
Do not exceed the recommended hardener amount.

Application.



Apply with a spray gun equipped with a  $\varnothing 1.6$ - $\varnothing 1.8$  mm nozzle at an air pressure of 2.0 to 3.0 bar.

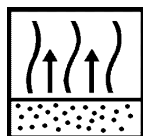


For airless spraying and number of coats 2 x 1:

- Dry coating thickness: 100  $\mu\text{m}$ .

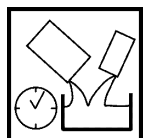
For hydrodynamic spraying of the primer with Thixo Additive 30-900 and a number of layers 2 x 1:

- dry coating thickness 240  $\mu\text{m}$ .



Evaporation time between coats at +20°C:

- 10-15 minutes.



Working time of the ready-to-use primer mixture:

- 3 hours.

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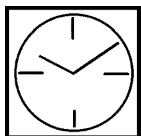


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Drying.



At +20°C:

Time to coat: from min 3 hours – to max 7 days for 100 µm  
min 1 hour for 50 µm

At +60°C:

Time to coat: from min 15 min to max 30 min.

The coating achieves its full performance properties after a seasoning period, i.e. after 10 to 15 days at 18-22°C.

Coverability

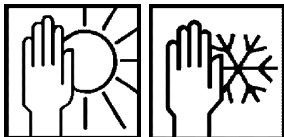
Intended for coating with any topcoat from the APP Modular Industrial Line system.

After 7 days, it requires sanding with P320-P360.

Equipment cleaning.

Nitrocellulose or acrylic solvent.

#### Storage



Store in closed original packaging in a dry and well-ventilated room, at +5°C to + 30°C.

Protect from frost and direct sunlight.

#### OHS regulations



For professional use only.

See text on product labels or SDS.

The user must comply with the OHS regulations in force in the country concerned.

#### VOC

VOC in g/L: 2004/42/EC – II A (j) (455)

Permissible VOC content in g/L in the ready-to-use product:

455 g/L for APP Primer EP 30-620 Grey.

Maximum VOC content in g/L in the ready-to-use product without thinner:

<500 g/L for APP Primer EP 30-620 Grey.

Maximum VOC content in g/L in the ready-to-use product with 20% thinner addition:

>500 g/L for APP Primer EP 30-620 Grey.

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