



Art.-No.: 6.4520.1000

4520

2K Epoxy Primer +

Characteristics

Chromate free EP primer for paintings of commercial vehicles and car repair. Adhesion to steel, aluminium and galvanized sheet. Excellent flow and outstanding overspray absorption. Fast drying (may already be recoated after approx. 45 minutes).

V.O.C. Value

EU limiting value for the product (cat. B/c): 540 g/l
This product contains max. 540 g/l VOC [4.50 lbs/gal].

Tech Tip

Suitable to be used before polyester putties and polyester spray filler.
Can be applied wet-on-wet.



Application

Processing conditions:
From +10°C and up to 80 % relative air humidity.

Suitable substrates:
Iron and steel, aluminium, sanded galvanized sheet, dried and sanded old paintings.

Substrate preparation:
Substrate must be clean, dry and free of dust, rust, oil and grease. Sand and then clean with silicone remover.

Mixing ratio:
2:1 by volume (with hardener 0451.0502)

Application process (Spraying / Air):
Viscosity: 16 - 22 s 4mm DIN
Nozzle: 1.2 - 1.6 mm (wet-on-wet: 1.2 - 1.3 mm)
Pressure: 2 bar
Number of coats: 1 - 2

Thinner:
4CR 0505 (addition 10 - 25 %)

Drying times:
Dust dry: after approx. 10 - 15 min.
Overpaint: after approx. 30 - 45 min. depending on the paint thickness

Recoatable with putties after 30 min. at 60°C or 12 hours at room temperature. Do not apply more than 25 µm film thickness (1 thin layer) when putties or spray filler will be used for recoating.

Groundcoat:
4520 2K Epoxy Primer + 25 - 50 µm dry film thickness (wet-on-wet: 15 - 20 µm)

After 48 hours the primer must be sanded.



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Technical Data

Binder basis	A combination of epoxide-polyamide resin
Colour	grey (RAL 7032)
Grade of gloss	satin mat D(IN 67 530)
Specific weight	1,3 - 1,4 g/cm ³ (DIN 51 757)
Viscosity	thixotropic
Pot life	5 h
Consumption	9 - 10 m ² / l (by 35 µm dry film thickness)

Storage and Transportation

At least 3 years, if stored in tightly closed original containers.