Technical Data Sheet

EPOXY LIGHTPRIMER 5:1

PRODUCT DESCRIPTION

Two pack multipurpose epoxy primer with very good adhesion to various type of surface.

Basic function of this primer is protection against osmosis and destructive effect of water on laminate. Next function are interlayer function and adhesion increase. This primer can be used also as a filling or finishing primer. Very easy in application and grinding, it can be used below and above water line.

PRODUCT INFORMATION

SURFACE TYPE	laminate, wood, aluminum
COLOR	white, grey
GLOSS	mat
VOLUME SOLIDS	65%
DENSITY	1,4kg/l
VOC	374,11g/l (+5%), 542,93g/l (+50%)
MIXING RATIO	5:1 by volume (ml), 100:12 by weight (g)
THEORETICAL COVERAGE	10÷11m²/l for thickness 90µm (WFT) / 60µm (DFT)
METHODE OF APPLICATION	Brush, roll, airless spray gun, pneumatic spray gun

INSTRUCTION FOR USE

SURFACE PREPARATION

Laminate – salt and other contaminations remove with pressurized fresh water after that wait until surface dry. Next step is to sand surface by abrasive paper P100-P240. Remove dust and degrease surface using Sea-Line Cleaner.
Wood – remove contaminations and degrease surface. Wood must be dry. Next, sand surface using abrasive paper P60-P120 on dry, sand along wood grain. After grinding remove dust and one more time degrease surface using Sea-Line Cleaner.
Aluminum- sand surface with P120. If exists corrosion, remove it. Rinse surface thoroughly with 10% ammonia solution. Start painting no later than 6 hours after finishing grinding and cleaning.

PRODUCT PREPARATION

This product is two pack product. Always mix components in accordance to mixing ratio. Component A is the base, Component B is the hardener. Once mixed, set should be used before pot life expiration- see chapter pot life. For diluting products, add thinner recommended by producer in proper mixing ratio. Thinning level depends on method of application, tools, air temperature, paint viscosity. Percentage dilution ratio see in chapter thinning. Mix all components thoroughly and wait for air bubbles to disappear.

MIXING RATIO

5:1 by volume (ml), 100:12 by weight (g)

THINNING

For thinning it is recommend to use Sea-Line Thinner for epoxy primers in proportion:

brush/roll	Thin layer of pneumatic spray application (up to 90-100µm WFT)	Thick layer of pneumatic spray application (up to 300µm WFT)
5-25%	40-50%	5-10%

APPLICATION

Number of coats interlayer 1-2 layers
protection against osmosis 2-4 layers (total film thickness minimum 225µm)

Pot life 2h (20°C) application airless spray gun
6h (20°C) application by bruh/roll

Spray parameters	Thin layer of pneumatic spray application (up to 90-100µm WFT)	Thic layer of pneumatic spray application (up to 300µm WFT)
gravity fed	1,4 - 1,6 mm	1,6 - 2,2 mm
pressure	2,0 bar	2,0 - 2,5 bar

CURING INFORMATION

Temperature	Overcoating interval	Dust dry	Fully hardened
20°C	minimum 4 h	3-4 h	7 days
10°C	minimum 8 h	6 h	14 days

The given times must be considered as a guideline only. The actual drying time may be longer or shorter depending on film thickness, ventilation, humidity etc.

IMPORTANT NOTES

Product temperature should be minimum 15°C. Air temperature should be at least 10°C.

Do not apply two pack epoxy Lightprimer 5:1 on one pack products. Avoid painting on direct sunlight. For degreasing use Sea-Line Cleaner.

The maximum overcoating time, without sanding the primer, applies when the surface is free from chalking and other contamination. If the primer coating was exposed to direct sunlight, it must be clean and sanded, removal of the top layer will provide better adhesion.

Immersion should be done only after when the last layer of primer and antifouling paint have hardened.

FURTHER WORK

After hardening it is recommend to sand surface using abrasive paper P240-P400

Sea-Line Epoxy Lightprimer 5:1 can be finished with:
any epoxy system
polyurethane 2K paint and varnish
any polyester system

STORAGE AND SAFETY INFORMATION

SHELF LIFE

Base (component A) 24 months from production date
Hardener (component B) 24 months from production date

STORAGE

Product components should be stored in tightly sealed containers, in a temperature of 10-25°C, away from sources of fire, heat and sunlight. Close container tightly immediately after each use. Store in a dry place and keep sealed cans until use.

HSE CONDITIONS

Please follow safety instructions from the Safety Data Sheet for hazardous chemical and follow workplace safety laws. The general rule is to avoid contact of the product with the skin and eyes. When product is used in a small, closed spaces you must provide

	forced ventilation. It is also recommended that you protect your respiratory system, eyes, and skin. Special care should be taken in the area of fire protection and explosion hazards. **Notice ! Always follow all precautionary, health and safety notice on the Safety Data Sheet and container labels.**
DISCLAIMER	All data in this document have been prepared for informational purpose only. We can not take responsibility for the results of user actions over which we have no control. The user is responsible for making the control sample and determining the suitability of the product for specific, individual applications. Company Troton Sp. z o.o. does not take responsibility for any damage, or loss of profits associated with the improper use of the products. All information is based on scrupulous laboratory research and many years of experience. Our position of market leadership does not free us from constant quality control of our products. However, we do not accept responsibility for the effects of improper use or storage of our products, or the effects of using our products in any way contrary to the standard of good workmanship.
QUALITY GUARANTEE	Production, quality control and the realization of deliveries fulfill the demands of ISO 9001 and 14001 standards.