



Technical Data Sheet

Epoxy Primer-Surfacer 62 Grey 4:1 PLUS

Art.nbr.: 5370+

Primers

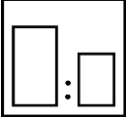


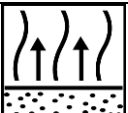

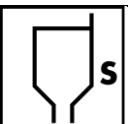



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APPLICATION SHEET

	4 Epoxy Primer-Surfacer 62 Grey 4:1 PLUS 1 EP Primer-Surfacer 62 Hardener PLUS Add, if necessary, 0 - 30% 2K PU Thinner PLUS
	Spray nozzle: 1.6 - 1.8 mm Pressure: 1.8 - 2.2 bar at the air inlet
	1 - 3 spray coats
	10 - 20 minutes between the layers Wet-in-wet 60 - 90 minutes (depending on layer thickness and temperature)
	20 °C 16 hours per layer 60 °C 60 minutes per layer Thick layers 18 hours at 20 °C (Do not dry thick layers at 60 °C)
	Application viscosity Airspray : 18 - 22 seconds (DIN CUP 4 mm / 20 °C) Wet-in-wet : 16 - 18 seconds (DIN CUP 4 mm / 20 °C) Application- and object temperature : 15 °C - 30 °C
	Potlife 24 hours at 20 °C
	Use suitable respiratory protection
	For full technical information, please read the complete Technical Data Sheet

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FULL TECHNICAL INFORMATION



- VOC Compliant conform directive 2004/42/EC
- Possible to spray wet-in-wet
- Excellent filling properties

FIELD OF APPLICATION

Passenger cars, commercial vehicles, coaches, trucks.

KRISTAL Epoxy Primer-Surfacer 62 Grey 4:1 PLUS, is a high-filling corrosion-resistant epoxy primer-surfacer with good resistance to chemicals. Easy to spray. May be sanded. Wet-in-wet application is possible.

PRODUCT AND AUXILIARY PRODUCTS

	KRISTAL Epoxy Primer-Surfacer 62 Grey 4:1 PLUS	
Hardener	KRISTAL EP Primer-Surfacer 62 Hardener PLUS	
Product to add	KRISTAL 2K PU Thinner STD PLUS	A thinner with which the right viscosity can be reached
Article numbers	KRISTAL Epoxy Primer-Surfacer 62 Grey 4:1 PLUS	5370+
	KRISTAL EP Primer-Surfacer 62 Hardener PLUS	8370+
	KRISTAL 2K PU Thinner STD PLUS	3110+

CHEMICAL BASIS

KRISTAL Epoxy Primer-Surfacer 62 Grey 4:1 PLUS	Epoxy resins
KRISTAL EP Primer-Surfacer 62 Hardener PLUS	Polyamino-amide

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SUBSTRATES

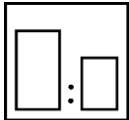
On: - metal (steel, zinc, aluminium)
- sanded polyester

Do not use on top of Washprimer.

Do not use on aluminium parts which are subject to movement.

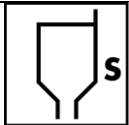
Do not use in anodized aluminium and not applicate on popped aluminium.

MIXING



- 4 Epoxy Primer-Surfacer 62 Grey 4:1 PLUS
 - 1 EP Primer-Surfacer 62 Hardener PLUS
- Add, if necessary, 0 - 30% 2K PU Thinner PLUS

APPLICATION VISCOSITY



Application viscosity

Airspray

: 18 - 22 seconds (DIN CUP 4 mm / 20°C)

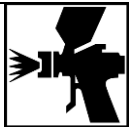
Wet-in-wet

: 16 - 18 seconds (DIN CUP 4 mm / 20°C)

Application- and object temperature

: 15°C - 30°C

EQUIPMENT SET-UP



Spray nozzle:

1.6 - 1.8 mm

Pressure:

1.8 - 2.2 bar at the air inlet

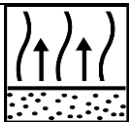
SPRAY COATS / LAYER THICKNESS



2 - 3 full spray coats

Layer thickness 60 - 180 µm

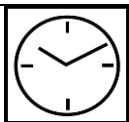
FLASH-OFF



10 - 20 minutes between the layers

Wet-in-wet 60 - 90 minutes

POTLIFE



24 hours at 20°C

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DRYING



20°C : 16 hours per layer

60°C : 60 minutes

Thick layers after 18 hours at 20°C (Do not dry thick layers at 60°C)

ECONOMY

9 m² per liter / 50 µm, ready to spray surfacer

CLEANING THE EQUIPMENT

KRISTAL NC Thinner 3120

PHYSICAL PROPERTIES

Density : 1,15 kg/l

Flashpoint : 22°C

Vol.% solids : 70,4%

VOLATILE ORGANIC COMPOUND

VOC CODE: **2004/42/IIB(c)(540)(440)**

Product Subcategory (according directive 2004/42/EG) and max. VOC content of the ready to use product IIB(d). Primers – Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007)

This product contains a maximum of 440 g/l. VOC

STORAGE LIFE

Under normal storage conditions for up to two years in unopened tins.

TRANSPORT- AND STORAGE CONDITIONS

Do not store or transport this product at a temperature lower than 8°C or higher than 30°C.

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