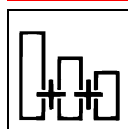


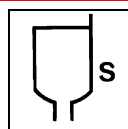


LS175 (29175) EPOFAN PRIMER R- EC



1000 ml +
500 ml +
250-500 ml

Pot life at 20° C:
2-8 h



20-30" DIN4
at 20° C



Ø 1,8-2 mm
3,5-4,5 Atm
HVLP:
Ø 1,6-1,8 mm
2-2,5 Atm
N° of coats: 2



Air drying at 20°C:
12-24 h
Low bake:
30-40' at 70-80° C
60-90' at 50-60° C

DESCRIPTION

Two-pack primer based on epoxy resins and non-polluting anticorrosive pigments.

USE

Adherence and anticorrosion primer for all metal surfaces.

CHARACTERISTICS

- Suitable as an anticorrosive primer under polyester putties.
- Excellent adhesion on steel, stainless steel, aluminium, light alloys, zinc-coated steel sheets, concrete.
- Very high anticorrosion power.
- Good filling power.
- Can be used without sanding in wet-on-wet processes (with 00103 EPOFAN EC HARDENER W/W).
- Sealer for thermoplastic enamels.

SUBSTRATE PREPARATION

Carbon steel, stainless steel, aluminium and its alloys, hot-dip galvanised steel sheet: sand and degrease with 00695 SILICONE REMOVER SLOW.

Galvanised steel sheet: degrease with 00695 SILICONE REMOVER SLOW.

APPLICATION

Spray.

Mixing ratio:

- a) For general uses and especially when low baking is needed, prepare the following mixture:

	volume	weight
LS175 EPOFAN PRIMER R-EC (derived from binder 29175)	1000 ml	1000 g
00305 EPOFAN EC HARDENER	500 ml	300 g
00516 EPODUR THINNER or	250-500 ml	150-300 g
00535 EPOFAN THINNER or		
00556 LECHSYS EPODUR PF THINNER *		
*for extra-EEC countries only		

Pot life: 6 - 8 hours at 20 °C

b) For **wet-on-wet processes**:

	volume	weight
LS175 EPOFAN PRIMER R-EC (derived from binder 29175)	1000 ml	1000 g
00103 EPOFAN EC HARDENER W/W	500 ml	300 g
00516 EPODUR THINNER or 00535 EPOFAN THINNER or 00556 LECHSYS EPODUR PF THINNER *	250-500 ml	150-300 g

***for extra-EEC countries only**

Pot life: 4 hours at 20 °C

- c) Despite losing some film elasticity in winter this product can be used at temperatures between +5 and +18°C with the following mixture:

	volume	weight
LS175 EPOFAN PRIMER R-EC (derived from binder 29175)	1000 ml	1000 g
00451 EPOFAN EC HARDENER FAST	500 ml	300 g
00516 EPODUR THINNER or 00535 EPOFAN THINNER or 00556 LECHSYS EPODUR PF THINNER *	250-500 ml	150-300 g

***for extra-EEC countries only**

This mixture can also be overcoated with wet-on-wet process.

Pot life: 2 hours at 20 °C

Spray application at 20 °C: 20 - 30" DIN 4

Air cap: 1,8 - 2 mm; HVLP: 1,6 - 1,8 mm

Air pressure: 3,5 - 4,5 Atm; HVLP: 2 - 2,5 Atm

N° of coats: 2 regular

Film thickness : 80-100 µ

Theoretical coverage of the mixture ready for use: 9,24 m²/l at 50 µ; 7,7 m²/kg at 50 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l

This product ready for use contains at most 456 g/l VOC

DRYING

a) With 00305 EPOFAN EC HARDENER:

- Air drying: at 20 °C, sanding after 12 - 24 hours
- Low bake: at 70 - 80 °C after 30 – 40 min.
at 50 - 60 °C after 60 – 90 min.

b) With 00103 EPOFAN EC HARDENER W/W:

Overcoat with polyurethane finishing coat after 1h and not beyond 24h from the primer application.

c) With 00451 EPOFAN EC HARDENER FAST (FAST HARDENER FOR LOW TEMPERATURES):

The temperature affects flash-off and drying time. Generally you can overcoat with the top coat or with the sealing coat with wet-on-wet process after 2 hours at 10°C, while sand after 12 hours at 10°C.

OVERCOAT WITH

Polyurethane fillers and two-pack top coats of the LECHSYS range.

Cannot be overcoated on synthetic primers.

OBSERVATIONS

Just like all epoxy products, EPOFAN PRIMER R-EC, hardened with HARDENERS 00305 or 00103, must not be air dried at temperatures below 15°C. Under this temperature the through-drying cannot be achieved and in the long run all the painting system could be faulty. The mixture with HARDENER 00451 is not recommended in summer as the pot life is shortened to a few minutes.

Since the composition is chrome-free, we recommend producing formulations NOT containing the base colours 29011-29012-29026, as they contain lead chromate causing the product the loss of its non-toxic characteristics.

Search the formulations to reproduce under the Car Manufacturer SOTT (undercoats) by choosing the colour in the relevant colour card.

TECHNICAL DATA SHEET N° 0525-GB

UPDATED 04/2015

All information contained in this data sheet is the result of carefully controlled tests and is correct to the best of Lechler's knowledge at the time of issue. Since conditions of use are beyond the control of the manufacturer, information contained herein is without warranty, implied or otherwise, and final determination of the suitability of any information or material for the use contemplated and the manner of use is the sole responsibility of the user. FOR PROFESSIONAL USE ONLY.