

ADLER 2K-Epoxi-Grund containing no zinc chromate 68304 f

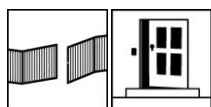
Solvent-based **anti-corrosive primer** and **adhesion promoter** for **industrial and professional** use

PRODUCT DESCRIPTION

General

- Solvent-based 2K-primer based on epoxy resin for indoors and outdoors. Excellent anti-corrosive action on steel, outstanding adhesion on aluminium, zinc and non-ferrous metals, good adhesion on various paintable plastics, consolidates the MDF substrate

Application areas



- Metal constructions made of iron, steel, non-ferrous metals with zinc, aluminium and copper and materials made of coatable, solvent-resistant plastics, as well as wood. High-quality MDF front doors.

PROCESSING

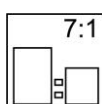
Instructions for use



Spraying is only allowed in spray booths complying with the VOC Directive.

- Please stir the product before use.
- The temperature of the product and object, and the room temperature must be at least + 10 °C.
- The optimal processing conditions are between 10 – 25 °C with a relative humidity of 40 – 80 %.

Mixing ratio

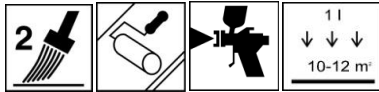


7 parts 2K-Epoxi-Grund 68304 f
1 part ADLER Epoxi-Härter 82313

Pot life

1 working day

Application technique



Application method	Brushing	Rolling	Cup gun
Spraying nozzle (Ø mm)	-	-	1.8 – 2
Spraying pressure (bar)	-	-	2 – 2.5
Dilution (thinning)	ADLER Epoxi-Streichverdünnung 80389 ADLER Epoxi-Spritzverdünnung 80364		
Thinner amount added in %	5 – 10 brushing Rolling undiluted	approx. 20 – 25	
Yield per application (m²/l)	10 – 12		

The shape, properties and dampness of the substrate affect the consumption/yield. Accurate values for consumption must be obtained by applying trial coats in advance.

Drying times

(room temperature 20°C)



Recoatable	after approx. 3–4 hours
Ready for sanding	after approx. 12 hours

The figures given above are reference values. The drying time depends on the type of substrate, coat thickness, temperature, air exchange and relative atmospheric humidity.

Avoid direct sunshine (dries too quickly). **Cleaning the**

Working equipment



With ADLER Epoxi-Streichverdünnung 80389 or ADLER Epoxi-Spritzverdünnung 80364 or ADLER Aceton-Waschmittel 95130.

SUBSTRATE

Type of substrate

Iron and steel, non-ferrous metals and coatable plastics, MDF boards

Substrate property (or condition)

The substrate must be dry, clean, capable of holding the paint, free from separating substances such as grease, wax, silicone, resin etc. and free from wood dust, as well as tested for suitability for coating.

Please observe and follow ÖNORM B 2230 Part 3.

See also VOB, Part C, DIN 18363, Paragraph 3, painting and coating work.

Any coatings that cannot be recoated must be removed thoroughly.

Preparation of the substrate

Iron and steel

Remove rust down to bare metal.

Thoroughly remove greasy or oily impurities using ADLER Entfetter (degreaser) 80394.

Zinc, aluminium and other non-ferrous metals

Sand matt with grinding fleece and ADLER Entfetter 80394.

Hard PVC and coatable plastics

Sand matt with grinding fleece and ADLER Entfetter 80394.

MDF boards

Sand with grit size 150 and clean.

Old coats of paint

Sand with grit size 120 and clean. Remove old coatings that

cannot be recoated.

The compatibility of the paint must be tested on old coats of synthetic resin (risk of "lifting").

Please observe the respective technical data sheets of the products.

COATING SYSTEM

Primer coat

Iron and steel

Indoors: 1 x ADLER 2K-Epoxi-Grund 68304 f

Outdoors: 2 x ADLER 2K-Epoxi-Grund 68304 f

Zinc, aluminium and other non-ferrous metals

1 x ADLER 2K-Epoxi-Grund 68304 f

Sand anodised aluminium and stainless steel very well until matt and prime within 60 minutes with ADLER 2K-Epoxi-Grund 68304 f.

Hard PVC and coatable plastics

1 x ADLER 2K-Epoxi-Grund 68304 f

Due to the large number of plastic materials, an adhesion test is recommended.

MDF front doors

Pre-coat milled areas and edges with ADLER 2K-Epoxi-Grund Weiß.

Intermediate drying: approx. 4 hours

Spray the whole area.

Intermediate drying: overnight

Sand smooth with grit size 240.

Please observe our "**Working guideline for the coating of dimensionally stable and limited dimensionally stable construction elements – Coating front doors and garage doors with Aquawood Protor – Chapter 2.4**"

Please observe the respective technical data sheets of the products.

Intermediate sanding



Grit size 240

Remove sanding dust.

Intermediate and finishing coat

ADLER 2K-Epoxi-Grund 68304 f can be recoated with practically any solvent and water-based intermediate and final coats. An exception is chlorinated rubber paints, which are practically no longer used however (swimming pool paintwork, heavy-duty corrosion protection).

ORDERING INFORMATION

Size of trading unit 1 kg, 3.45 kg twin can with curing agent

Colours Hellgrau (light grey) 68304
Weiß (white) 68316

Supplementary products ADLER Epoxi-Härter 82313
ADLER Epoxi-Streichverdünnung 80389
ADLER Epoxi-Spritzverdünnung 80364
ADLER Aceton-Waschmittel 95130.
ADLER Entfetter 80394

FURTHER DETAILS

Durability / storage At least 3 years in the original sealed containers.



Make sure the product is protected against moisture, direct sunlight, frost and high temperatures (above 30 °C).

Technical specifications VOC content EU threshold for ADLER 2K-Epoxi-Grund (Cat. A/h): 750 g/l (2010). ADLER 2K-Epoxi-Grund contains a maximum of 580 g/l VOC.

Product code for paints and varnishes M-GP01

Safety-related information



Please pay attention to the associated safety data sheet. The current version can be accessed on the Internet at www.adler-lacke.com.

In general, inhaling paint aerosols must be avoided. This is ensured by correctly using a breathing mask (combination filter A2/P2 – EN 141/EN 143).