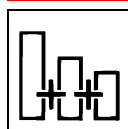


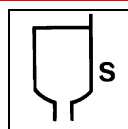


LS102 (29102) EPOBUILD PRIMER 2K



1000 ml +
500 ml +
0-150 ml

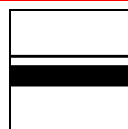
Pot life at 20°C:
4 hours



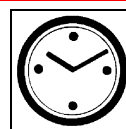
22-30" FC4
at 20 °C



Ø 1,6-1,9 mm
3.5-4.5 Atm
HVLP:
Ø 1,4-1,8 mm
2-2.5 Atm
N° coats: 2



70-120 µ



Air drying at 20° C
Tack-free, handling: 5 h
Through-dry: 48 h
Low bake at 60° C:
60 min.

DESCRIPTION

Two-pack epoxy primer with high filling power.

USE

Suitable as a primer for Truck Refinish and Industry in general.

CHARACTERISTICS

- Easy application
- Very good adhesion on:
 - Steel
 - Electro-galvanized and hot dip galvanized steel
 - Aluminium and its alloys
- Good anticorrosive power
- Good vertical stability
- Very good filling power
- Good sanding
- Possible application by wet-on-wet and dry-on-dry systems
- Chromate-free

SUBSTRATE PREPARATION

Black steel sheet: microsandblast, sand.

Steel: degrease carefully with 00695 SILICONE REMOVER SLOW, and sand or sandblast.

Aluminium and its alloys: degrease carefully with 00695 SILICONE REMOVER SLOW. Sandblast or sand or rub down carefully.

Electro-galvanized steel : degrease carefully with 00695 SILICONE REMOVER SLOW.

Hot dip galvanized steel: degrease with 00695 SILICONE REMOVER SLOW and sand or rub down.

Fibreglass: degrease with 00695 SILICONE REMOVER SLOW and sand if necessary.

APPLICATION

Spray.

Mixing ratio:

	weight	volume
LS102 EPOBUILD PRIMER (derived from binder 29102)	1000 g	1000 ml
29302 LECHSYS EPOBUILD PRIMER HARDENER	300 g	500 ml
00516 LECHSYS EPODUR THINNER or	0-100 g	0-150 ml
00556 LECHSYS EPODUR PF THINNER * or		
00544 EPOFAN THINNER SLOW **		

***for extra-EEC countries only**

**** Special product – Available upon request**

Pot life at 20 °C: 4 hours

Application viscosity at 20 °C: 22-30" FC 4

Ø Air cap: traditional 1,6 - 1,9 mm; HVLP 1,4 - 1,8 mm

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

N° of coats: 2

Suggested thickness: 70 - 120 µ

Theoretic coverage: 1 l of mixture = 4,5 m² at 100 µ

1 kg of mixture = 3,5 m² at 100 µ

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

This product ready for use contains at most 500 g/l VOC

DRYING

Air drying at 20°C:

Dust-free: 15-20 min.

Handling: 5 hours

Sanding after 18-20 hours

Through-drying: 48 hours

Low bake at 60°C:

60 min.

SANDING AND SUGGESTED OVERCOATING

It can be puttied after 8-10 h at 20°C:

Dry-on-dry system

Sand dry with grit paper P280-320

Wet-on-wet system

Overcoating from 1 h to 12 h (at 20°C) with acrylic (ACRITOP) or polyurethane enamels (ISOLACK).

NOTES

It is not recommended to apply the mixture at temperatures below 15°C.

This product is chromate- and lead-free. It is recommended to avoid adding the base colours 29011, 29012 and 29026 in the formulations, as they contain lead and would make the final product lose its non-toxic characteristics.

Search the formulation to produce under "SOTTOTINTE-UNDERCOATS" on the Lechler Explorer / MAP® and choose the colour in the respective colour fan.

TECHNICAL DATA SHEET N° 0482-GB

UPDATED 02/2018

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