



Technical Datasheet

Jul. 2019



TDS 20-2-1

Cardea® Epoxy Primer

Description	Cardea® Epoxy Primer is a 2K primer with a good chemical and corrosion protection. Do not content any lead and chrome.						
Related Products		Cardea® Epoxy Primer Cardea® Epoxy Primer Hardener TDS no: 40-1-1 Cardea® Universal Thinners TDS no: 50-2-1					
Substrate		Old painted surfaces, steel, galvanize, zinc & aluminum surfaces, stainless steel, polyether surfaces, wood.					
Surface Preparation		Degrease with Cardea® U-Clean 300 by clean cloth. Aluminum: fiber cloth or dry sanding - P320 sanding paper Steel, Galvanize,: dry sanding - P120 → P220 sanding papers Zinc Polyester putty: dry sanding - P220 → P320 sanding papers Old paint: dry sanding - P220 → P320 sanding papers Note: If surface was cleaned by a degreaser with acid chemicals, remove acid chemicals before applying this product. Clean with Cardea® U-Clean 300 by clean cloth.					
Mixing		Cardea® Epoxy Primers Cardea® Epoxy Primer Hardener Cardea® Universal Thinners		System By Weight 100 30 30 - 50		By Weight 100 30 50 - 70	
Viscosity	s	Sanding system Wet-on-wet system	: 15 - 18 s/20°C (DIN 4) : 13 - 15 s/20°C (DIN 4)				
Pot Life		Sanding system Wet-on-wet system	: 5 hours (at 20°C) : 7 hr (at 20°C)				



The effectiveness of our systems is based on many years' practical experience and laboratory research. We guarantee that the quality of the work performed in accordance with our systems meets the Kansai Altan standards, provided that our instructions are followed carefully and the work is performed in accordance with the requirements as to good craftsmanship. We decline any responsibility, if the final result is affected by factors beyond our control. The customer has to determine the suitability of the delivered products for the intended application by using the means which normally are at his disposal.





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Spray Gun Parameters		Gun Type	Nozzle size	Air pressure			
	>1	Suction feed spray gun	1,8-2,0 mm	2 - 4 bars			
		Gravity feed spray gun	1,6-1,8 mm	2 - 4 bars			
		HVLP Suction feed spray gun	1,8-2,0 mm	2 - 2,2 bars			
		HVLP Gravity feed spray gun	1,7-1,9 mm	2 - 2,2 bars			
		(wet-on-wet)					
		Suction feed spray gun	1,4-1,6 mm	2 - 4 bars			
		Gravity feed spray gun	1,3-1,5 mm	2 - 4 bars			
Application		2 - 3 coats					
Flash-off Time	<u>}</u> † <u>}†</u>	Approximately 10 minutes (at 20 °C) until touch-dry. Note: In wet-on-wet application wait between 5 - 30 min (at 20 °C) before next coat. Note: The flash-off time between two coats depends on the application temperature, film thickness and air circulation.					
Drying		60°C / 30 min 20°C / 2 hr					
Dry Film Thickness		50 μm / coat					
Next Coat		Dry sanding First sanding : P320 Finish sanding : P400/P500					
		Clean with Cardea® U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.					
		Cardea® Primers & Fillers, 2K Topcoats and Basecoats. See TDS No: 20-1-1, 20-1-2, 30-3-1, 30-1-1					
		20 1 1, 20 1 2, 30 3 1, 30 1 1					
Equipment Cleaning		Use acrylic or cellulosic thinners.					
Package		Cardea® Epoxy Primers : Cardea® Epoxy Primer Hardener : Cardea® Epoxy Primers : Cardea® Epoxy Primer Hardener : Cardea® Epoxy Primer : Cardea® Epox	1 L 0,5 L				
Color		Grey					
Safety		Professional use only. See Material	Safety Data Sheet.				



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