



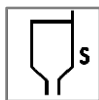




TDS 20-2-1








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																											
		Clean with Cardea® U-Clean 300 by clean cloth.																											
Mixing		<table border="1"> <thead> <tr> <th rowspan="2"></th> <th colspan="2">Sanding System</th> <th colspan="2">Wet-on-wet System</th> </tr> <tr> <th>By Volume</th> <th>By Weight</th> <th>By Volume</th> <th>By Weight</th> </tr> </thead> <tbody> <tr> <td>Cardea® Epoxy Primers</td> <td>100</td> <td>100</td> <td>100</td> <td>100</td> </tr> <tr> <td>Cardea® Epoxy Primer Hardener</td> <td>50</td> <td>30</td> <td>50</td> <td>30</td> </tr> <tr> <td>Cardea® Universal Thinners</td> <td>40 - 60</td> <td>30 - 50</td> <td>60 - 80</td> <td>50 - 70</td> </tr> </tbody> </table>					Sanding System		Wet-on-wet System		By Volume	By Weight	By Volume	By Weight	Cardea® Epoxy Primers	100	100	100	100	Cardea® Epoxy Primer Hardener	50	30	50	30	Cardea® Universal Thinners	40 - 60	30 - 50	60 - 80	50 - 70
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Cardea® Universal Thinners	40 - 60	30 - 50	60 - 80	50 - 70																									
Viscosity		Sanding system : 15 - 18 s/20°C (DIN 4) Wet-on-wet system : 13 - 15 s/20°C (DIN 4)																											
Pot Life		Sanding system : 5 hours (at 20°C) Wet-on-wet system : 7 hr (at 20°C)																											



TDS 20-2-1

Cardea® Epoxy Primer

Spray Gun Parameters		Gun Type	Nozzle size	Air pressure
		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 (wet-on-wet)	1,7-1,9 mm	2 - 2,2 bars
		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		<p>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.</p>		
Drying		<p>60°C / 30 min 20°C / 2 hr</p>		
Dry Film Thickness		50 µm / coat		
Next Coat		<p>Dry sanding First sanding : P320 Finish sanding : P400/P500</p>		
		<p>Clean with Cardea® U-Clean 300 by clean cloth. Wipe the surface with a tack cloth and blow air.</p>		
		<p>Cardea® Primers & Fillers, 2K Topcoats and Basecoats. See TDS No: 20-1-1, 20-1-2, 30-3-1, 30-1-1</p>		
Equipment Cleaning		Use acrylic or cellulosic thinners.		
Package		Cardea® Epoxy Primers	: 1 L	
		Cardea® Epoxy Primer Hardener	: 0,5 L	
Color		Grey		
Safety		Professional use only. See Material Safety Data Sheet.		