



Technical Data Sheet

ISOLATOR PRIMER

Isolating epoxy primer with anti-corrosion additives




RELATED PRODUCTS



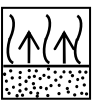




ISOLATOR PRIMER
HARDENER

Hardener for Isolator Primer

PROPERTIES

- Fast-drying epoxy primer
 - Excellent adhesion to metal parts
- Good insulating performance
 - Wet on wet application



SUBSTRATES				
Old paint layers, including thermoplastic ones	Degrease and dry sand with P220 - P360.			
Polyester putties	Dry sand, finishing levelling with P240 - P320.			
Steel	Clean steel surfaces to Sa 2 ^{1/2} (wet blasting) or St3 (manual cleaning or with a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free of oil, grease, dust, loose old paint layers, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.			
Aluminium	Degrease and dry sand with P280 - P360 or matt with an abrasive finishing pad, then degrease again.			
Galvanized steel	Degrease, matt with a fine abrasive finishing pad, and degrease.			
Stainless steel	Degrease.			
Polyester laminates	Degrease and dry sand with P280.			
MIXING RATIO				
	ISOLATOR PRIMER ISOLATOR PRIMER HARDENER	Volume ratio	Weight ratio	
		1	100	
		1	52	
VISCOSITY				
	DIN 4/20°C	14 - 15 s		
VOC CONTENT				
VOC II/B/c limit*		540 g/l		
Actual VOC content		537 g/l		
* For a ready to apply mixture acc. to EU Directive 2004/42/EC				
APPLICATION CONDITIONS				
It is recommended to apply the primer at over 15°C and at a humidity of 80%.				
APPLICATION				
	Conventional gravity fed spray guns	Nozzle 1.3 - 1.4 mm	Pressure 2 bar	Distance 15 - 20 cm
	CAUTION: Follow the equipment manufacturer's guidelines Low-pressure spray guns Gravity fed HVLP guns	1.2 - 1.3 mm	2 bar	10 - 15 cm

	Number of coats	1 - 3	
	CAUTION: When applying directly on bare steel, the primer coat must be 80 µm or thicker for proper anti-corrosion protection.		
	Dry coat thickness:		
	1 layer	20 - 30 µm	
2 coats	40 - 60 µm		
3 coats	60 - 90 µm		
The yield of the ready to use mixture for the given range of dry coat thicknesses		13.0 m ² /l at 30 µm	
	Mixture life at 20°C	6 h	
	Flash-off time between coats	5 - 10 min	
APPLICATION OF FILLERS/PUTTIES OVER THE ISOLATOR PRIMER			
	ISOLATOR PRIMER layers	1	
	ISOLATOR PRIMER drying time	30 min	
CAUTION: Recoat the system within 12 hours. Sand down ISOLATOR PRIMER after 12 hours.			
BASECOAT OR COLOUR TOPCOAT APPLICATION OVER THE ISOLATOR PRIMER			
	ISOLATOR PRIMER layers	1 - 2	
	ISOLATOR PRIMER drying time	15 min	
CAUTION: Recoat the system within 12 hours. Sand down ISOLATOR PRIMER after 12 hours.			
CURING TIME			
	Time to sand	20°C	60°C
		3 h	45 min
CAUTION: The curing times apply to the temperatures of the individual elements.			
IR DRYING			
	Distance	Follow the recommendations of the equipment manufacturer	
	Time depends on the lamp type and power	10 - 20 min	
CAUTION: Start IR heating no earlier than 10 minutes after applying the final coat.			



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SANDING		
	Dry sanding	P360 - P500
	Wet sanding	P600 - P1000
EQUIPMENT CLEANING		
Epoxy thinner.		
STORAGE CONDITIONS		
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.		
SHELF LIFE		
ISOLATOR PRIMER	24 months/20°C	
ISOLATOR PRIMER HARDENER	24 months/20°C	
SAFETY		
See the Safety Data Sheet.		
OTHER INFORMATION		
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, providing the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to perform a test application of the product due to its potentially different reaction with different materials. We may not be held liable for defects if the final result was affected by factors beyond our control.		



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WEIGHT QUANTITY OF COMPONENTS:

CAUTION! It is very important to precisely dose the specific components to obtain a primer with suitable performance parameters.

Mixture quantity	ISOLATOR PRIMER	ISOLATOR PRIMER HARDENER
0.10 l	80 g	41.5 g
0.20 l	160 g	83.0 g
0.30 l	240 g	124.5 g
0.40 l	320 g	166.0 g
0.50 l	400 g	207.5 g
0.75 l	600 g	311.0 g
1.00 l	800 g	415 g
2.00 l	1600 g	830 g