

Application Sheet



Epoxy primer 4:1

GREY

Art.no. 4238

APPLICATION DATA

Mixing ratio	:		4 : 1 In volume with Unilux Epoxy Hardener 6225 Add if necessary 0-30% Unilux Epoxy thinner Standard 1019 or fast 1020 or 2K PU Thinner 1031												
Application-viscosity	:		At 20°C DIN Cup 4 mm. Gravity spraygun: 18 – 22 sec. Wet in wet : 16 – 18 sec.												
Equipment	:		<table><thead><tr><th></th><th><u>Nozzle diameter (mm)</u></th><th><u>Spraying pressure (bar)</u></th></tr></thead><tbody><tr><td>Gravity feed</td><td>1.4 – 1.8</td><td>2.0 – 2.5</td></tr><tr><td>Suction feed</td><td>1.6 – 1.8</td><td>3.5 – 4.0</td></tr><tr><td>HVLP/LVLP</td><td>1.4 – 1.8</td><td>1.5 – 2.0</td></tr></tbody></table>		<u>Nozzle diameter (mm)</u>	<u>Spraying pressure (bar)</u>	Gravity feed	1.4 – 1.8	2.0 – 2.5	Suction feed	1.6 – 1.8	3.5 – 4.0	HVLP/LVLP	1.4 – 1.8	1.5 – 2.0
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Spray coats Film thickness	:		1 – 3 40 – 120 µm												
Flash-off	:		10 – 20 min. Between de layers Wet in wet 60-90 min. Depending on layer Thickness en temperature.												
Drying	:		20°C: 16 hours per layer. 60°C: 50 min. per layer. May be sprayed over wet-on-wet. Wet on wet use 20% till 30 % Thinner. Thick coats 18 hours at 20°C (Do not force-dry thick layers at 60 C). Maximum time to overspray the epoxy primer is 4 days.												
Potlife	:		16 hours at 20 C.												

Note : Use it only on (steel,zinc,Aluminium)
Do not use on top of Wash primer
Do not use on Aluminium parts wich are subject to movement
Do not use on anodized, popped aluminium.