



## SMAART 2K PU 2K EPOXY PRIMER

### PRODUCT DESCRIPTION

Smaart 2K Epoxy Primer is a chromate-free 2K primer filler for Commercial vehicles coating. The Product with strong filling power and fine adhesion between coats, has excellent flexibility and impact resistance which can increase gloss and build of topcoat. The high corrosion protection and the very good adhesion also on non - ferrous metals make this product perfectly suitable for composite substrates. Very good filling capacity and adherence to steel, aluminium, zinced steel and FRP.

### SURFACE PREPARATION

The substrate must be clean, dry and free from grease. All substrates must be cleaned beforehand with Silicon Remover Degreaser. Zinc substrates must be pre-treated with Sanding paper on aluminium with P 220, steel with P 180. After sanding clean again thoroughly with Silicon Remover Degreaser. In case of one-layer topcoat use sanding paper P 320 for dry sanding or P 600 for wet sanding. In case of a two-layer topcoat we recommend to use the sanding paper 600/800 for wet sanding. After having mixed the two components wait for 15 minutes before applying.

### APPLICATION METHOD



Application Method	Pressure/bar	Nozzle/mm	Spray Passes	Thinner (%)
Gravity Spray gun	2.5 - 3	1.6 -1.8	2 - 3	0 - 25
HVLP	2.5 - 3	1.6 -1.8	2 - 3	0 - 25

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Pot life:  
4 hrs @ 30° C



Hardener:  
Smaart 2K Epoxy Hardener



Thinner:  
Smaart Epoxy Thinner @ 0 - 25%

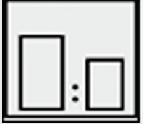
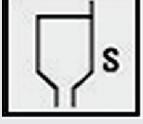
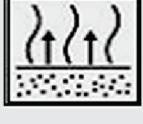


Drying Time:

Object temperature	Dust Dry/min	Set to touch	Ready for assembly	Sandable	Recoatable
30° C	10 - 15 min	NA	8 h	8 h	30 min
60° C	NA	NA	NA	30 min	NA

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### TECHNICAL INFORMATION

	Colour : Beige / Dark Grey
	Mixing Ratio : 4 : 1 (by Volume)
	Spraying Viscosity : 24 - 28 s FORD CUP #4
	Flash Off Time : 5 - 8 min between coats 10 - 15 min before oven drying
	Dry Coat Thickness : 50 - 70 µm

**Approx Coverage: 5 - 6 m<sup>2</sup>/l (for 50 - 70 µm DFT )**

Storage :	1 year from the date of manufacturing at 30° C, if stored in a dark / dry place in a tightly closed container.
VOC Regulation :	EU limit value for this product (category B/c): 540 g/l This product contains max. 540 g/l of VOC.
Processing Conditions :	From +10°C and up to 80% relative air humidity. Ensure an adequate air ventilation.

This data sheet is for information purpose only. To our knowledge the data provided complies with the latest standard and is based on years of experience in the manufacture of our products. However the data is not binding and without warranty. Please follow recommendations stated on the relevant precautions stated on the product label. We reserve our right to make additions, deletions or modifications to the information at any time without prior notification.