

2K-Epoxy-Grund

5604

Solvent-based **anti-corrosive primer** and **adhesion promoter** for industrial and professional use

PRODUCT DESCRIPTION

General

Solvent-based 2-component epoxy resin primer for exterior and interior use. The product is characterised by its excellent rust protection effect on steel, outstanding adhesion to aluminium, zinc and non-ferrous metals, good adhesion to various coatable plastics and to strengthen the MDF substrate.

Application area

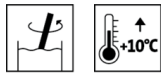


Metal constructions made of iron, steel, non-ferrous metals with zinc, aluminium and copper.

Materials made of coatable, solvent-resistant plastics such as hard PVC.
High-quality wooden front doors of moisture resistant MDF.

PROCESSING

Processing instructions



- **Spraying is only allowed in spray booths complying with the VOC Directive.**
- Please stir the product before use.
- The temperature of the product and object, and the room temperature must be at least +10 C.
- The optimal conditions for use are between 10 - 25 °C with a relative atmospheric humidity between 40 - 80 %.
- Do not close containers with hardened material.
- The color shade, compatibility and adhesion to the substrate must be checked by creating sample panels.
- Any change in the processing sequence, environmental conditions, non-observance of instructions or the use of products not listed may have an unfavourable effect on the result.

Blending ratio



7 Part(s) by weight 2K-Epoxy-Grund (5604)
1 Part(s) by weight Epoxy-Hardener 8442 (8442)

2K-Epoxy-Grund (5604) can only be used with a hardener and in the mixing ratio specified. Deviations lead to film and adhesion problems.

Epoxy-Hardener 8442 (8442) must be carefully worked into the product by stirring before processing.

After addition of hardener, a waiting time of approx. 10 minutes is recommended for improved degassing.

Pot life



8 hour(s)

A further extension of the pot life is not possible.

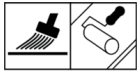
Increased temperatures reduce the pot life.

1-0 IMC 5604 | 07/24 | replaces 0-1

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Our instructions are based on the current state of knowledge and are intended to advise the buyer/user to the best of our knowledge, but must be individually adapted to the areas of application and processing conditions. The buyer/user is responsible for deciding on the suitability and use of the supplied product, which is why we recommend that a sample be produced to check the suitability of the product. In all other respects, our General Terms and Conditions of Sale apply. All previous data sheets lose their validity with this edition. We reserve the right to make changes to container sizes, color shades and available gloss levels.

Application technique

	Cup gun	Brushing	Rolling
Spraying nozzle Ø (mm)	1,8 - 2,0	-	-
Spraying pressure (bar)	2,0 - 2,5	-	-
Diluent	Epoxy-Spritzverdünner 8011 (8011)	Epoxy-Streichverdünner 8012 (8012)	
Diluent amount added (%)	20 - 25	5 - 10	
Applied quantity per application (ml/m ²)	100 - 125		

The shape and surface condition of the workpiece as well as the type of application influence the actual consumption. Accurate values for consumption must be obtained by applying trial coats in advance.

Drying times

(at 23 °C and 50 % rel. humidity)



Recoatable	approx. 3 - 4 hour(s)
Sandable	approx. 12 hour(s)

The figures given above are reference values. The drying time depends on the type of substrate, coat thickness, temperature, air exchange and relative atmospheric humidity.

Lower temperatures and/or high level of atmospheric humidity can increase the drying time.

Avoid direct sunlight!

Cleaning the working equipment

With Epoxi-Streichverdünner (8012) oder Epoxi-Spritzverdünner (8011) or Aceton-Waschmittel (8001) immediately after use.

SUBSTRATE**Type of substrate**

Iron and steel, non-ferrous metals, hard PVC and coatable plastics
MDF panels

Substrate property

The substrate must be dry, clean, capable of holding the paint, free from separating substances such as grease, wax, silicone, resin etc. and free from wood dust, as well as tested for suitability for coating.

Please observe the additional documents:

- ÖNORM B 2230-1
- ÖNORM B 3430-1
- DIN 18363
- Current BFS information sheets

Remove old coatings that cannot be recoated.

Substrate preparation**Iron and steel:**

Remove rust down to bare metal. Thoroughly remove greasy or oily impurities using Entfetter (7233).

Zinc, aluminium and other non-ferrous metals:

Sand until matt with abrasive fleece and Entfetter (7233).

Hard PVC and coatable plastics:

Sand until matt with abrasive fleece and Entfetter (7233).

MDF panels:

Sand with grit size 150 and clean.

Old coatings:

Sand with grit size 120 and clean. Remove old coatings that cannot be recoated. The compatibility of the paint must be tested on old coats of synthetic resin (risk of "lifting").

COATING SYSTEM

Primer coat**Iron and steel:**

Indoors: 1 x 2K-Epoxy-Grund (5604)

Outdoors: 2 x 2K-Epoxy-Grund (5604)

Zinc, aluminium and other non-ferrous metals:

1 x 2K-Epoxy-Grund (5604)

Sand anodised aluminium and stainless steel very well until matt and prime within 60 minutes with 2K-Epoxy-Grund (5604).

Hard PVC and coatable plastics:

1 x 2K-Epoxy-Grund (5604)

Due to the large number of plastic materials, an adhesion test is recommended.

Only for front doors in MDF quality

Pre-coat millings and edges with 2K-Epoxy-Grund (5604) non diluted.

Intermediate drying: approx. 4 hour(s)

Spray the whole area.

Intermediate drying time: approx. 12 hours (over night)

Slight smooth sanding Grit size 240

Please follow our **ARL 305 - Working guideline for coating dimensionally stable and limited dimensionally stable construction elements - Coating of front doors and garage doors.**

Intermediate sanding

Grit size 240

Remove sanding dust.

Intermediate/finishing coat

2K-Epoxy-Grund (5604) can be recoated with practically any solvent and water-based intermediate and top coats. An exception are chlorinated rubber paints, which are practically no longer used however (swimming pool coatings, heavy-duty corrosion protection).

ORDERING INFORMATION

Size of trading unit

920 g and 3.45 kg (double can including hardener)

Colour shades / Glosslevels

Standard colour(s):
Hellgrau (5604071698)
Weiß (5604071806)

Supplementary products

Aceton-Waschmittel (8001)
Entfetter (8009)
Epoxy-Hardener 8442 (8442)
Epoxy-Spritzverdünner 8011 (8011)
Epoxy-Streichverdünner 8012 (8012)

Please refer to the corresponding technical data sheets of the products.

FURTHER DETAILS

Durability / storage



Min. 3 year(s) in the original sealed containers.

Make sure the product is protected against moisture, direct sunlight, frost and high temperatures (above 30 °C).

Close opened containers well and use up the content as soon as possible.

Technical specifications

VOC content of the ready-to-use mixture: EU limit for 2K-Epoxy-Grund (Cat A/h): 750 g/l.

2K-Epoxy-Grund contains maximum 500 g/l VOC.

Giscode

RE75

Safety information



The product is only suitable for the industrial and professional use.

When sanding, use at least a P2 dust filter as personal safety equipment to protect against abrasive and wood dust. In case of hardwood (especially for Beech, Oak) a dust filter P3 is recommended.

The inhalation of paint aerosols during spray application must generally be avoided. This is ensured by the proper use of a respirator (combination filter A2/P2).

Further information on the subject of safety during transport, storage and handling as well as disposal can be found in the relevant safety data sheet. The current version can be accessed on the Internet at www.adler-lacke.com.