

840R

27.08.2014

VOC EPOXY PRIMER-SURFACER

DESCRIPTION

2-component chromate-free epoxy Primer-Surfacer.

Colour: off white.

Composition based on epoxy resin.

PRODUCTS

840R	VOC Epoxy Primer-Surfacer
845R	Epoxy Activator
AU370	Polyurethane Thinner
XB383	Standard Thinner
XB387	HI-Temp Thinner

PROPERTIES

- Very good corrosion and chemical resistance.
- Excellent adhesion on properly treated metal substrates.
- Recommended as a 1st coat over bare metals.
- Very good filling properties. Suitable for use over rough substrates e.g. gritblasted metals.
- High humidity resistance and good flexibility.
- Can be tinted with AM Centari[®] MasterTints[®] (up to max. 10 % by weight).
- Can be coated with 2K surfacers or topcoats.
- VOC compliant, conform with directive 2004/42/EC.

SUBSTRATES









- Bare metals: steel, aluminium and galvanised steel.
- OEM finishes.
- Cured repair finishes.
- Polyester putties.

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PRODUCT PREPARATION

	Mixing ratio	Sanding primer-surfacer		Non-sanding primer-surfacer	
		Volume	Weight	Volume	Weight
	840R	3	100	4	100
	845R	1	17.5	1	13
	AU370/XB383	1	17.5	-	-
	XB387	-	-	1.5	19.5
	VOC	< 540 g/l			
	Pot life at 20°C	8 hr			
	Spray viscosity at 20°C	DIN 4 FORD 4	3:1:1	4:1:1.5	
			16-20 s 16-21 s	16-19 s 16-20 s	
	Spray equipment	Compliant guns Gravity feed Suction feed Pressure feed	Fluid tip	Distance	Pressure
			1.4-1.5 mm 1.5-1.7 mm 1.1-1.4 mm	15 cm 15 cm 15 cm	
		Conventional guns Gravity feed Suction feed Pressure feed	1.4-1.6 mm 1.6-1.8 mm 1.1-1.4 mm	20-25 cm 20-25 cm 20-25 cm	2-2.5 bar 2-2.5 bar 2-2.5 bar
	Number of coats	1-2			
	Flash time	Between coats till flat.			
		Before recoating: 2K surfacers topcoats		minimum 30 min 1 hr	maximum 3 days 3 days
	DFT	25-30 µm/coat			
	Dry to sand at 20°C at 60°C	O.N.			
		35 min			
	IR drying*	Distance	80 cm	* Guideline for short/medium wave IR equipment.	Not applicable.
		Half power Full power	5 min 15-20 min		

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

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SURFACE PREPARATION

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
 - a. mechanical with P280 - P320;
 - b. wet with P600.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct final cleaner/degreaser. Wipe dry with a clean cloth.

EQUIPMENT CLEANING

Use a correct solventborne gunwash.

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REMARKS

- For optimum surface preparation gritblast to Sa 2 ½.
- Activated material should not be returned to original can of non-activated material.
- 840R can be applied by brush if no reducer is added to the activated material.
- Polyester putties can be applied over cured, sanded 840R.
- Material has to be stirred well before use.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.
- ValueShade® 2 (VS2) is equal to 100 % of 840R.
- ValueShade® 3 (VS3) can be obtained by adding 1.5 g of AM5 to 100 g of 840R.
- ValueShade® 4 (VS4) can be obtained by adding 5 g of AM5 to 100 g of 840R.
- ValueShade® 5 (VS5) can be obtained by adding 10 g of AM5 to 100 g of 840R.

PRODUCT DATA

Package viscosity:	340 cp
Theoretical coverage:	3:1:1 6.1-7.3 m ² /l at recommended DFT - ready-to-spray 4:1:1.5 12.1-14.5 m ² /l at recommended DFT - ready-to-spray
Directive 2004/42/EC:	The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

SAFETY

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

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All other products referred to in the paint system build-up are from Cromax®. System properties will not be valid when the related material is used in combination with any other materials or additives not belonging to Cromax®, unless explicitly indicated otherwise.

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