1-7520 Epoxy Primer Grey

GENERAL INFORMATION

1-7520 Epoxy Primer Grey is a high-filling Epoxy Primer with good resistance to chemicals, that is easy to spray. Wet-on-wet application is possible.

MIXING RATIO



Sanding: 2:1 Primer: Hardener + 15% Uni Thinner Non-Sanding: 2:1 Primer: Hardener + 20% Uni Thinner

COMPONENTS



1-70 Epoxy Primer Hardener 1-141 Uni Thinner Fast 1-151 Uni Thinner Medium 1-161 Uni Thinner Slow

GUN SET UP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3 - 1,5	2/29
HE	1,3 - 1,8	1,8 - 2,0 / 26 - 29
Airless / Airmix	0,009 - 0,011"/40°	160 - 200 / 2100 - 2900

ADDITIVES



APPLICATION



Sanding: 1 - 2 coat 50 - 80 μm (2,0 - 3,15 mil) **Non-Sanding:** 1 coat 50 μm (2,0 mil)

SURFACE PREPARATION



Cleaning: Clean with 1-951 Silicone Remover by using wipe on/wipe off method. Sanding: Sand surface thoroughly with P180 dry discs. For preparation of E-coat and OEM finishes sand with P240 dry discs or scuffing pad. Cleaning: After preparation of substrate repeat cleaning procedure.



Mask entire vehicle to eliminate unwanted overspray.

FLASH OFF AND DRY TIMES





AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off wet-on-wet	45 minutes	Flash off dry	10 - 20 minutes
Dust free	45 minutes	Dust free	-
Dry to handle	16 hours	Dry to handle	60 minutes
Dry to tape	16 hours	Dry to tape	60 minutes
Dry to sand	16 hours	Dry to sand	60 minutes
Dry to polish	-	Dry to polish	-

Flash off times for wet-on-wet application 45 minutes. Application window 45 minutes to 48 hours.

NEXT LAYER



MM 900 - 9999 WaterBase 900° Series MM 500 - 5999 BeroBase 500 Series MM 2000 - 2099 BeroMix 2000 Series

FIL PEGILI ATIONS 1-7520 Engry Primer Grey

INFRARED DRYING



AFTER FULL FLASH OFF AND AT PROPER DISTANCE			
Half-bake	4 min 50°C		
Full-bake	40 min 65°C		
See IR Manufacturer information			

ACTED CITIL CL



Cured and sanded old paint systems, metal, (steel-zinc-aluminium) or sanded polyester.

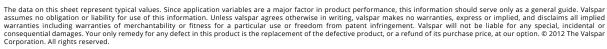
PHYSICAL DATA

EU REGULATIONS 1-7520 Epoxy Primer Grey				
VOC Code		2004/42/IIB(c)(540)534		
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/c. Primer - Surfacer/filler and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 534 g/l VOC.		
Chemical Base	2K Epoxy Primer			
Physical Properties	Viscosity (RTS)	17 - 19 Dincup 4 / 20°C		
	Specific Gravity (kg/l) sanding	1,239		
	Specific Gravity (kg/l) wet-on-wet	1,232		
	Flash Point Closed Cup	18,5°C / 65,3°F		
	Volume % Solids sanding	36,6		
	Volume % Solids wet-on-wet	35.6		
	Economy sanding	6 m²/L/60 μm		
		245 ft²/Gal/2,4 mil		
	Economy wet-on-wet	12 m²/L/30 μm		
		490 ft²/Gal/1,2 mil		
	Gloss	Matt		
	Colour	Grey		

POT LIFE AT 20°C / 68°F



24 hour







1-7520 Epoxy Primer Grey

PROTECTION

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.de-beer.com/en/debeer/choose_localization

CLEAN UP



1-051 Gun Cleaner

STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions $10^{\circ}C$ - $30^{\circ}C$ / $50^{\circ}F$ - $90^{\circ}F)$ (unopened container).



NOTES

Can be sanded both wet and dry. Due to the large variety of aluminium parts, first contact supplier.

