

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

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

APPLICATION



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

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.

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	

SUBSTRATES



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

POT LIFE AT 20°C / 68°F



24 hour

COMPONENTS



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

ADDITIVES



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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.

NEXT LAYER



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

PHYSICAL DATA

EU REGULATIONS 1-7520 Epoxy Primer Grey		
VOC Code		2004/42/IIIB(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.		IIIB/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

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°C - 30°C / 50°F - 90°F) (unopened container).



NOTES

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