

A-614 2K Epoxy Primer Grey

# **GENERAL INFORMATION**

A-614 2K Epoxy Primer Grey is a multi-use high solids epoxy primer designed for both wet-on-wet and high fill applications. It has excellent adhesion and corrosion resistance properties in direct to metal applications.

#### This TDS is about the Sanding version.

# **MIXING RATIO**



4:1+35-40% Primer: Activator: Thinner

#### **GUN SETUP**

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,6 - 1,8	2
HE	1,6 - 1,8	3 - 4
Pressure pot	1,1 - 1,2	4

Air pressure mentioned in table is base on inlet air.

#### **APPLICATION**



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D	1 - 2 coat 30 - 40 µm per coat
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# FLASH-OFF AND DRY TIMES

$ \uparrow \uparrow $	AIR DRY 20°C / 68°F		FORCED DRY	
	Flash off	10 minutes	Flash off	-
	Dust free	-	Dust free	-
	Dry to handle	Overnight	Dry to handle	3 hours at 35°C 30 minutes at 60°C
	Dry to tape	-	Dry to tape	-
	Dry to sand	-	Dry to sand	-
	Dry to polish	-	Dry to polish	-

### **SUBSTRATES**



On properly cleaned and prepared steel, zinc, aluminium, polyester putties and OEM finishes.

#### **POT LIFE**



8 hours

Waiting longer for application might affect the application properties.

## **COMPONENTS**



### **ADDITIVES**



# SURFACE PREPARATION



Cleaning: Clean by using wipe on/wipe off method. Sanding: Sand surface thoroughly with P180 dry discs. For preparation and OEM finishes sand with P280 - P320 dry discs or scuffing pad. Wet P600. Cleaning: After preparation of substrate repeat cleaning procedure.

Mask entire vehicle to eliminate unwanted overspray.

### **NEXT LAYER**



Prospray Intermix Basecoat system Prospray Intermix Single Stage system Prospray Engine Bay System

# **PHYSICAL DATA**

	PHYSICAL DATA				
	Chemical Base	Special resins mixed with modified epoxy			
	Physical Properties	Viscosity (RTS)	18 - 20 sec DIN Cup4 30°C		
		Specific Gravity (kg/l)	1,55		
		Flash Point Closed Cup	27°C / 80.6°F		
		Volume % Solids	50%		
		Economy	10,8 m²/L/40 µm RTS		
		Gloss	-		
		Colour	Grey		

# PROTECTION



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

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

sds.prosprav.eu

#### **CLEANUP**



Use cleaning thinner.

### **STORAGE / SHELF LIFE**



Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

#### NOTES



All reported product properties on the TDS are determined at a temperature of 30°C unless specified otherwise.

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