

GENERAL INFORMATION

SP5599 Epoxy Primer Grey 1:1 is a high-filling Epoxy Primer with good resistance to chemicals and is easy to spray with the simple mixing ratio.

MIXING RATIO



Sanding: 1 : 1 Primer : Hardener
Non-Sanding: 1 : 1 Primer : Hardener

GUN SET UP



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

APPLICATION



Sanding : 1 - 2 coat 30 - 60 µm (1,2 - 2,4 mil)
Non-Sanding : 1 coat 30 µm (1,2 mil)

FLASH OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F
Flash off	10 - 20 minutes	Flash off	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 minimum 60 minutes

SUBSTRATES



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

POT LIFE AT 20°C (68°F)



24 hour

COMPONENTS



SP2899 Epoxy Primer Hardener

ADDITIVES



SURFACE PREPARATION



Cleaning: Clean with SP6499 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



PHYSICAL DATA

EU REGULATIONS		
VOC Code		2004/42/IIIB(c)(540)540
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 540 g/l VOC.
Chemical Base	2K Epoxy Primer	
Physical Properties	Viscosity (RTS)	16 - 17 Dincup 4 / 20°C
	Specific Gravity (kg/l) sanding	1,200
	Specific Gravity (kg/l) wet-on-wet	1,200
	Flash Point Closed Cup	18,5°C / 65,3°F
	Volume % Solids sanding	32,0
	Volume % Solids wet-on-wet	32,0
	Economy sanding	5,3 m²/L/60 µm 210 ft²/Gal/2,4 mil
	Economy wet-on-wet	10,6 m²/L/30 µm 420 ft²/Gal/1,2 mil
	Gloss	Matt
	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 Spiralac](#)

CLEAN UP



Gun Cleaner

STORAGE/SHELF LIFE



The up-to-date shelf life overview can be found by clicking on the following link:

[Shelf life overview Spiralac](#)

NOTES



All reported product properties on the TDS are determined at a temperature of 20°C / 68°F unless specified otherwise.

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