

PRIMER CA 680
EPOXY PRIMER WITH SURFACE TOLERANCE

01.01.2018 /rev.2

PRODUCT DEFINITION

Epoxy resin based high tolerance epoxy primer with two components, solvent, surface additive, high solid matter rate.

AREAS OF USE

Used as anti-corrosive primer for protection of metal surfaces with poor surface cleaning against external effects.

PRODUCT SPECIFICATIONS

Color	Grey
Appearance	Matt
Thinner	Epoxy Thinner
Solid Matter by Weight, %	80
Density	1,55 g/cm ³
Usage Rate	See usage rate table.
Packaging	17,4 kg A component + 2,6 Kg B component; Total Kg 20
Fire Point	>100 °C
Mixture Rate	6,7/ 1
Application Methods	Brush, Roller, Air-Airless Paint Gun
Mixture Life	180-300 minute / 25°C
Shelf Life	1 year
Waiting Time Between Coats	14 hours/25 °C
Drying Time	24 hours/25 °C
Mechanical Strength	7 days
Equipment Cleaning	Epoxy Thinner

SURFACE PREPARATION

Surface preparation is crucial for the epoxy paint to show expected performance. Surfaces must be ground with mechanical methods, roughened with sanding machine and cleaned of all dirt, dust, oil and grease. Sand blasting of at least SA1 by Swedish standard SIS 05 59 00 is strongly recommended for surface cleaning. First coat of primer is applied immediately after sand blasting.

MIXTURE PREPARATION

Being careful with the mixture ratios of A and B components, it must be mixed for at least 3-4 minutes with a low speed mixer until a homogenous mixture is obtained. **Ready for application after mixing.**

COATING SYSTEM

Special care must be taken with bolt heads, weld beads and sharp edges while applying the prepared primer. It must be applied on metal surfaces as one or two coats so as to have 40-50 microns dried film thickness.

APPLICATION CONDITIONS

Application must be avoided in temperatures below 10°C and very humid ambiances.

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Products recommended for use on:

- AC 8380 Epoxy Top Coat Paint
- AC 8390 Epoxy Top Coat Paint

SAFETY

This product is for professional use. Pay attention to the safety warnings on the package before use, see the product's Material Safety Know-How Index when needed. Do not inhale, avoid contact with skin and eyes, do not swallow, use proper work safety equipment. Take safety precautions for environment protection as well as fire and explosion danger. Apply in well ventilated areas.

**TRANSPORTATION and
STORAGE**

The product must be stored in 5-35°C.
The product must not be subjected to direct sun light.
Opened product must be stored in its own package, with its lid firmly sealed.

NOTE

GRADA reserves the right to make improvements/revisions on the product and this technical document in time. This Know-How Index renders invalid the Know-How Indexes published before, and is valid for 5 years. The user must ensure that the technical document they have is of the latest version, and contact our company when needed for querying about the validity of the document. Proper use of the product, validity of the application conditions and methods are under the user's responsibility. GRADA Epoxy Paint declines any warranty claims regarding the consequences, work accidents, direct or indirect damages or harm caused by not using the product as recommended. Packaging values stated above are the nominal values in the formulae standardized by GRADA. Under normal production conditions, there may be deviations in a level estimated in international standards.

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