

Rhenoplast HP3 – 2K Primer, primer for metal, aluminum

Two-component primer

Art. No. 7805 - component A: HP3- 2 K Epoxi- Primer sandy beige

Art. No. 7806 - component B: HP3- Epoxi- hardener

Water-based. For professional use.

Specification: Extremely adhesive 2-component primer for industry, vehicle manufacturing and domestic purposes. Suitable for various substrates, for steel, aluminum, NE- metals und for other substrates.

Processing instructions: Surface needs to be dry, clean and free from rust, grease and dust. Clean aluminum thoroughly. Surface can be lightly sanded. Before use both products (lacquer and hardener components) must be mixed. Shake or stir container well before use.

Mixing ratio: 5 parts per weight HP3-2K epoxy primer + 1 part per weight HP3 epoxy hardener. In order to adjust the viscosity water can be added. After mixing with the hardener observe a flash off time of 5 min.

Processing method: By brush, by roller or spraying with HVLP or gravity cup pistol

Spraying device /nozzle: Gravity cup pistol: 1,5-3,0 mm nozzle, spraying pressure ca. 4 bar

Processing temperature: Recommended at +20°C

Spraying viscosity: 18- 22 sec (4 mm- DIN cup at 20 °C). The addition of water is not necessary. Product is being delivered in spraying viscosity.

Pot-life of the mixture: 4-6 hours, depending on temperature

Drying: At 20 °C and a maximum humidity of 65 %, dust dry after 2 hours and re-coatable after one day with Rhenoplast KP1+

Forced drying at +60 - +80°C: approx 1 hour; observe flash off time of 10 - 15 min.

Application amount: 30 - 50 g/m²

Thinning: With water, only after mixing. Adding larger amounts of water will lead to an increase of the surface tension and to wetting mistakes.

Special note: After application the epoxy products are sensitive to cold and draught. If possible process at temperatures above +20°C.

Processing procedure:

- Conduct adhesion tests prior to using with any substrate.
- Carefully clean the profile surface with compressed air so that no loose particles interfere with the varnishing process.
- Any parts not to be varnished have to be covered with tape (e.g. fine masking tape).
- Please observe 5 min drying time before varnishing so that the cleaning agent does not interfere with the process.
- Dust-coat the edges before spraying the surface.

Supply Units:

HP3-2K Primer (component A)

5 kg pail

20 kg pail

Please always order component A and B accordingly.

HP3 Hardener (component B)

1 kg tin

4 kg tin

Storage: Cool but frost-free, close once-opened container firmly, storable for 1 year in the original container.

VOC 2010: Cat. I / base wb / max value 140 g/L / actual value 12 g/L

Labeling according to regulation (EC) No 1272/2008: HP3-2K Primer (component A)

WARNING – H315, H319, H317

GGVS/ADR: non dangerous goods

Labeling according to regulation (EC) No 1272/2008: HP3 Härter (component B)

WARNING – H315, H319, H226

GGVS/ADR: UN 3092 1-METHOXY-2-PROPANOL, Solution,3,III

Safety advice: During processing, common protection measures and regulations according to the authorized trade association must be observed. Safety-relevant data and instructions regarding disposal can be found in the safety data sheet.

Service:

Our service team for application technology is available to you at any time without obligation.

Phone: ++49 (0)6384 99 38 - 0

Fax: ++49 (0)6384 99 38 - 112

Email: info@rhenocoll.de

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