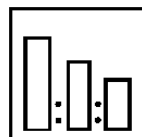


EPOPRIME 410

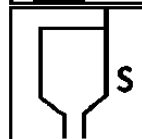
Primer Filler Epoxy 2K



100:25:50
Epoprime 410
Hardener EP 410
PU Thinner



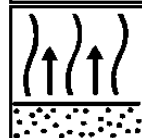
1



20-21



(syphon feed)
2-3*1
1.4-1.8 mm
3-5 bar



5-10 mins.



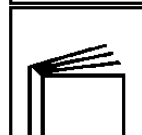
see t.i.s.



Indokit polyester putties



All Catina primers /
fillers
Catinacryl
Catinabase



7.3.2.47



Description:

Quickdrying, two-pack, chromate-free epoxy primer-surfacer for vehicles, chassis, etc. Developed for new work and repairs. Gives good chemical resistance and rust-inhibition.

Product and Additives:

Epoprime 410
Hardener EP. 410
PU Thinners

Basic Raw Materials:

Base paint: Epoxy resins.
Hardener: Amine resin

Suitable Substrates:

- existing finishes, with the exception of thermoplastic acrylic finishes;
- aluminium surfaces;
- steel surfaces;
- stainless steel surfaces;
- zinc-coated steel surfaces;
- zinc surfaces;
- polyester laminates;
- wood or plywood;
- Indokit polyester putties.

Note:

Do not apply this product to substrates which have been pretreated with a chemical cleaner. For commercial vehicles Catina representative should be contacted for suitability on aluminium. Due to the many different kinds of aluminium it is not possible to guarantee them all as a suitable substrate.

Surface Preparation:

- Existing finishes: Degrease and dry sand with P280-grit or with P600 grit wet.
- Aluminium and stainless steel surfaces: Degrease, scuff with Scotch Brite Type A and degrease again.
- Steel, zinc-coated steel, zinc and polyester: Degrease and dry sand with P180 grit (if necessary, blast-clean steel surfaces as well).
- Wood or plywood: Dry sand with P180-grit to achieve a smooth surface and no loose fibres are left on the surface.
- Indokit Polyester putties: Dry sand dry with P180-P280-grit sandpaper.

Tinting:

If necessary, Epoprime 410 can be tinted with up to 2½% parts by weight Catinacryl mixing colour (without hardener).

Mixing Ratio by volume:

100 parts of Epoprime 410
25 parts of Hardener EP.410
50 parts of PU Thinner.

Spraying Viscosity:

20-21 secs DIN Cup 4 at 20°C.

Spray gun fluid tip and working pressure:

Spray Gun:	Fluid Tip:	Working Pressure:
Gravity feed:	1.2-1.5 mm	3-5 bar
Syphon feed:	1.4-1.8 mm	3-5 bar
Pressure pot:	1.1-1.2 mm	4-6 bar
Airless spray:	0.011"/65°	140-160 bar
	0.013"/80°	

Also suitable for ES spray application.

Application Process:

Apply 2-3 single coats, allowing a flash-off time of 5 to 10 minutes between coats. If applied by brush, do not add any thinner.

Film Thickness:

Approx. 20µm for each single wet coat.

Cover rate:

Theoretical: 20 m²/l unthinned paint at 40µm.

Note: The practical cover rate depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of Equipment:

In Catina Solvent, nitrocellulose thinner or PU Thinner.

Drying times:

At 40 µm:	10°C:	20°C:	40°C:	60°C:
Dust-dry:	60 mins	15 mins	10 mins	5 mins
Tack-free:	2 hrs	30 mins	30 mins	10 mins
Hard dry:	8 hrs	5 hrs	2 hrs	60 mins
Recoat with putties after:	2 hrs	30 mins	30 mins	15 mins
Recoat With topcoats after:	30 mins	15 mins	10 mins	10 mins

Recommended Sandpaper grades:

For dry sanding: P280-P360

For wet sanding: P800-P1000.

Recoat with (Recoatability):

All current Catina's preparatory products.

The following topcoats: Catinacryl, Catinabase.

Note: If a drying time of 48 hours at 20°C. is exceeded, Epoprime 410 must be flatted prior to be recoated with a finish.

Packaging:

1 Lset

Colour:

Light grey

HEALTH & SAFETY DATA concerning Epoprime 410 and additives:

For professional use only.(See **Material Safety Data Sheet**).

See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.