



Technical Data Sheet
EPOXY PRIMER 3:1
Anti-corrosion epoxy primer

RELATED PRODUCTS

EPOXY PRIMER
HARDENER

EPOXY THINNER

Epoxy primer hardener

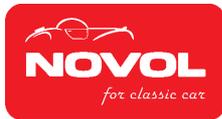
Epoxy thinner

PROPERTIES

- A product designed and dedicated for renovation of classic cars
 - High solid particle content
 - Perfect anti-corrosion properties
 - Perfect insulation properties
- Application of thick layers is possible
 - Very good chemical resistance
 - Very good mechanical resistance

SUBSTRATES					
Steel	Clean steel surfaces to Sa 2 ^{1/2} (wet blasting) or St3 (manual cleaning or with a power tool) in accordance with the PN-ISO 12944-4 standard; the surface after the treatment must be free of oil, grease, dust, loose old paint coating, mill scale, rust and foreign contaminants; the surface should exhibit the gloss of the metal substrate.				
Old paint coatings	Degrease and dry sand with P220 – P360 paper.				
Polyester putties	Dry sand, use P240 – P320 for final sanding.				
Aluminium	Degrease and mat with an abrasive finishing pad. Degrease again.				
Galvanised steel	Degrease and mat with a fine abrasive finishing pad. Degrease again.				
Stainless steel	Degrease and mat with an abrasive finishing pad. Degrease again.				
Polyester laminates	Dry sand with P280, degrease again.				
MIXING RATIO					
	EPOXY PRIMER 3:1 EPOXY PRIMER HARDENER EPOXY THINNER	Volume ratio	Weight ratio		
		3	100		
		1	20		
		10% – 20%	5.5 – 11		
Apply the thinner in the amount calculated for the primer.					
VISCOSITY					
	DIN 4/20°C	3 + 1	75 – 85 s		
		3 + 1 + 10%	40 – 45 s		
		3 + 1 + 20%	25 – 30 s		
APPLICATION					
 <p>CAUTION: Instructions of the equipment manufacturer must be followed.</p>	Conventional gravity fed spray gun	1.6 – 2.0 mm	3 – 4 bar	15 – 20 cm	
	Low-pressure gravity fed spray gun	1.6 – 2.0 mm	2 bar	10 – 15 cm	
	Number of layers	1 – 3			
	CAUTION: If the epoxy primer is the only primer in the paint coating, its minimum thickness must be 80 µm.				
	Single dry layer thickness	3 + 1	3 + 1 + 10%	3 + 1 + 20%	
		100 – 120 µm	80 – 100 µm	60 – 80 µm	
	Yield of the ready to apply mixture for a dry coating thickness in the provided range	approx. 8.0 m ² /l at 80 µm EPOXY PRIMER 3:1 + EPOXY PRIMER HARDENER (3:1)			
The actual yield depends on the surface shape, roughness and application parameters.					

	Mixture life at 20°C	2 h	
	Flash-off time between layers	15 –20 min	
CURING TIME			
	Time to sand For the max. dry coating thickness of 130 µm.	20°C	60°C
		24 h	45 min
IR DRYING			
	Distance	Follow the recommendations of the equipment manufacturer	
	Time depending on the type and power of the lamp	15 – 25 min	
CAUTION: Start IR heating no sooner than 10 mins after applying the last layer.			
SANDING			
	Dry sanding	P360 – P500	
	Wet sanding	P600 – P1000	
COATABILITY			
Can be coated with all NOVOL topcoats. After 60 minutes, apply a topcoat of EPOXY PRIMER 3:1, 80µm thick. Apply polyester putties after 24 hours.			
TECHNICAL DATA			
Product	Solids content by weight	Solids content by volume	Density
EPOXY PRIMER 3:1	≈ 82 %	≈ 67 %	≈ 1.62 g/cm ³
EPOXY HARDENER	≈ 71%	≈ 66%	≈ 0.97 g/cm ³
EPOXY PRIMER 3:1 + EPOXY PRIMER HARDENER, 3:1	≈ 81%	≈ 67%	≈ 1.53 g/cm ³



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CONTENT OF VOLATILE COMPONENTS	
VOC II/B/c limit*	540 g/l
Actual VOC content	281 g/l (for 3+1) 320 g/l (for 3+1+10%) 360g/l (for 3+1+20%)
* For ready to use mixture acc. to EU Directive 2004/42/CE	
COLOUR MATCHING	
Not recommended.	
APPLICATION CONDITIONS	
It is recommended to apply the primer at a temperature above 15°C and a humidity of no more than 80 %.	
COLOUR	
Beige	
EQUIPMENT CLEANING	
EPOXY THINNER.	
STORAGE CONDITIONS	
Store in a cool dry room, away from sources of fire and heat. Avoid direct exposure to sunlight.	
SHELF LIFE	
EPOXY PRIMER 3:1	24 months/20°C
EPOXY PRIMER HARDENER	24 months/20°C
EPOXY THINNER	24 months/20°C
SAFETY	
See Safety Data Sheet.	
OTHER INFORMATION	
The effectiveness of our systems results from laboratory research and many years of experience. The data contained herein meets the current knowledge about our products and their application potential. We ensure high quality, provided the user follows the instructions and the work is performed in accordance with good workmanship. It is necessary to do a trial/test application of the product due to the potential variation of product performance between substrate materials. We may not be held liable for defects if final results were affected by factors beyond our control.	



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ADDITIONAL INFORMATION

WEIGHT QUANTITY OF COMPONENTS: 3+1 filling version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture amount	EPOXY PRIMER 3:1	EPOXY PRIMER HARDENER
0.10 l	122 g	24
0.15 l	182 g	37 g
0.20 l	243 g	49 g
0.25 l	304 g	61 g
0.30 l	365 g	73 g
0.40 l	486 g	97 g
0.50 l	608 g	122 g
0.75 l	912 g	182 g
1.00 l	1216 g	243 g

WEIGHT QUANTITY OF COMPONENTS: 3+1+10% priming version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture amount	EPOXY PRIMER 3:1	EPOXY PRIMER HARDENER	EPOXY THINNER
0.10 l	113 g	23 g	6 g
0.15 l	170 g	34 g	9 g
0.20 l	226 g	45 g	12 g
0.25 l	282 g	57 g	15 g
0.30 l	339 g	68 g	18 g
0.40 l	452 g	90 g	24 g
0.50 l	566 g	113 g	30 g
0.75 l	848 g	170 g	45 g
1.00 l	1131 g	226 g	59 g



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WEIGHT QUANTITY OF COMPONENTS: 3+1+20% insulating version

CAUTION! In order to obtain a primer with appropriate parameters it is very important to exactly dose the individual components.

Mixture amount	EPOXY PRIMER 3:1	EPOXY PRIMER HARDENER	EPOXY THINNER
0.10 l	106 g	21 g	11 g
0.15 l	159 g	32 g	17 g
0.20 l	211 g	42 g	22 g
0.25 l	264 g	53 g	28 g
0.30 l	317 g	63 g	33 g
0.40 l	423 g	84 g	44 g
0.50 l	529 g	106 g	56 g
0.75 l	793 g	159 g	83 g
1.00 l	1057 g	211 g	111 g