

Primers

4082 Epoxy Primer

Product Description






Anti-corrosion epoxy primer for bare metal. Adhesive to steel, aluminium and galvanised steel.

Technical Characteristics

Colour: Grey Shelf life: 24 months at 25°C Theoretical spreading rate: 300-360 m²/l (avg) at 1 µm

Pre-treatment

Degrease with HAMR PREPSOLVE and washed with a tack rag.
Wet flat with P180-240 grade paper or dry flat with P80-120 grade paper.
Clean with HAMR PREPSOLVE.

	Mixing Ratio	<p>Stir well before use.</p> <table border="0"> <tr> <td>4082 Primer</td> <td>100 (vol)</td> <td>100 g</td> </tr> <tr> <td>4092 Hardener</td> <td>25 (vol)</td> <td>18 g</td> </tr> <tr> <td>411 Thinner</td> <td>35-45 (vol)</td> <td>32-41 g</td> </tr> </table> <p>Mix well and strain before application.</p>	4082 Primer	100 (vol)	100 g	4092 Hardener	25 (vol)	18 g	411 Thinner	35-45 (vol)	32-41 g
4082 Primer	100 (vol)	100 g									
4092 Hardener	25 (vol)	18 g									
411 Thinner	35-45 (vol)	32-41 g									
	Spray Viscosity Potlife	<p>16 to 20 seconds DIN 4 cup 25°C 8 hours at 25°C in a sealed plastic or glass container</p>									
	Sprayguns	<table border="0"> <tr> <td>HVLP gravity-feed spraygun</td> <td>1.5 – 1.7 mm</td> <td>1.8 – 2.0 bar</td> <td>15 – 20 cm</td> </tr> <tr> <td>Compliant gravity-feed spraygun</td> <td>1.6 – 1.8 mm</td> <td>3.0 – 4.0 bar</td> <td>20 – 25 cm</td> </tr> </table>	HVLP gravity-feed spraygun	1.5 – 1.7 mm	1.8 – 2.0 bar	15 – 20 cm	Compliant gravity-feed spraygun	1.6 – 1.8 mm	3.0 – 4.0 bar	20 – 25 cm	
HVLP gravity-feed spraygun	1.5 – 1.7 mm	1.8 – 2.0 bar	15 – 20 cm								
Compliant gravity-feed spraygun	1.6 – 1.8 mm	3.0 – 4.0 bar	20 – 25 cm								
	Application	<p>Number of coats: 2 coats Flash-off: 8 – 10 mins Film thickness: 50 – 60 µm Note: This primer can also be applied with a brush.</p>									
	Drying	<p>Dust free after: 20-30 mins Drying at 25°C 6 hours Drying at 60°C 1 hour</p>									
Further Treatment		<p>After fully cured, apply HAMR 2K primer or polyester filler for repairing damaged areas. (optional). Surface must be sanded to ensure adhesion.</p>									

The products are suitable for professional use only. The data contained in this publication are based on our current knowledge and experience. You can obtain the latest version of technical data sheet directly from your supplier.