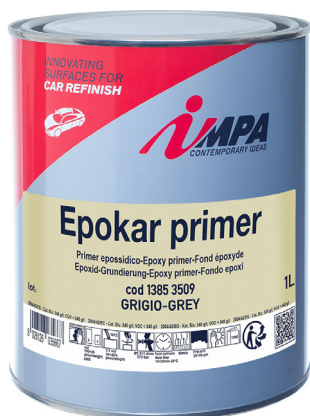


# 1385 EPOKAR PRIMER

EPOXY PRIMER



## Advantages

- Excellent anticorrosion effect
- Insulator and filler
- Also for old car restoration cycles

## Description and Use

Insulating epoxy primer for car refinish, with excellent anticorrosion effect and perfect adhesion on many different substrates. It can be used in refinish cycles as “wet-on-wet” applications. It is perfect, due to its excellent anticorrosion effect, in cycles of restoring of old cars. It can be used in painting cycles for trucks and commercial vehicles.

## Substrate preparation

### IRON SURFACES:

- Accurate mechanical cleaning followed by degreasing with organic solvents.

### GALVANIZED STEEL:

- Remove iron scale and foreign matters.
- Roughen with Scotch Brite and degrease with solvents.

### ALUMINIUM AND LIGHT ALLOYS:

- Mechanical cleaning by sanding followed by accurate solvent degreasing.

### OLD PAINTS:

- Previously check recoating resistance, then sanding followed by accurate cleaning with ANTISILICONE code 1618.

### ORIGINAL HARDENED FINISHINGS, FIBERGLASS AND PUTTIES:

- Sanding following with accurate cleaning with ANTISILICONE code 1618.

## Application

### Product preparation:

Stir thoroughly the Part "A" to achieve even colour and consistency. Then mix part A with component B code 4385 INDURITORE PER EPOKAR PRIMEE and thinner code 1612 DILUENTE EPOX using the following ratios.

Components	INSULATING PRIMER		FILLING PRIMER	
	By weight	By volume	By weight	By volume
1385 EPOKAR PRIMER	100	3	100	3
4385 IND. PER EPOKAR PRIMER	25	1	25	1
1612 DILUENTE PER EPOX	30/40	1	15	0.5
Application method	air mix spray gun: nozzle Ø 1.2-1.4 mm pressure 2-3 bar		air mix spray gun: nozzle Ø 1.5-1.7 mm pressure 2-3 bar	
N° coat	1 light		Max 2 full	
Flash off	30 min before acrylic filler application		5-10 min between two coats	
Recommended thicknesses	20-30 µm		60-80 µm	
Practical cover rate *	7-9 m <sup>2</sup> /l		4-5 m <sup>2</sup> /l	
Recoatible / over-plaster	after 30 minutes with 2K acrylic filler		after complete drying, sanding required	
	after 1 hour with polyurethane products			
	after 1 hour with polyester products			
Maximum recoating	up to 48h without sanding if used as an ISOLANT PRIMER		-	
Air drying (20°C - 65% RH)	15-20 minutes, dust free		20-30 minutes, dust free	
	-		2-4 hours, touch free	
	-		12-18 hours, through drying	
Oven drying (60°C)	-		30 minutes	

\* The cover rate is calculated on the suggested thickness and applied on plane and regular surfaces.

## Storage life

If stored in a cool, dry place, away from sources of heat and sheltered from sunlight, in its sealed original packaging, the product has a shelf life in months specified in the table of products with expiry date. Check the product's shelf life by referring to the production batch number shown on the packaging. The batch number is made of eight numeric characters in which the first four digits identify the year and month of production. Once the product has expired, it must be disposed of in accordance with the current legislation.

Table of products with expiry date		
Product name	Code	Expiry date in months
EPOKAR PRIMER	1385	24
INDURITORE PER EPOKAR PRIMER	4385	12

---

## Technical features

Colour	grey
Type of product	two component
Appearance of the dry film	satin
Pot-life	1 hour At higher temperatures pot-life decreases
Viscosity	1600-2000 mPa.s Brookfield rpm 20 s 4
EU limit values for VOC content (Directive 2004/42/EC)	Category B/c, SB: VOC max 540g/l product VOC < 540g/l
The data are measured at a temperature of 20°C.	

---

## Warnings

- Like all this kind of products, high humidity and low temperatures during application can damage the features and drying of the film.
- Do not apply when the temperature is below + 8°C (47°F) and the relative humidity exceeds 80%.
- For professional use only.
- Always read the safety datasheet before use.
- Dispose of contents / container in accordance with national regulations.
- It is recommended to acquire all the material required to finish the work of the same batch.
- The information provided on this technical datasheet is based on our technical and practical knowledge and experience. The technical data refer to the average characteristics of the basic product and are determined under controlled laboratory conditions. The variability of the raw materials available on the market can lead to slight deviations in the declared values. It is therefore necessary for the purchaser/user to personally verify, before application, the suitability of the product for the intended use, in particular when different batch numbers of the same material are used in the same work/site.

The above mentioned data are meant to facilitate our customers in the use of our products. IMPA is not responsible for applications of products carried out beyond its direct control. For further technical information about specific systems and/or special applications, please contact our TECHNICAL SERVICE at [assistenza.technica@impa.it](mailto:assistenza.technica@impa.it).