













Technical information (04/2021)

GRAVIHEL EPOXY PRIMER 50 GREY

- Two-component priming coat based on an epoxy binder used for anti-corrosion protection of steel, galvanized sheet surfaces and aluminium
- Contains zinc phosphate as an active corrosion pigment, which additionally improves corrosion protection.
- It represents a high quality primer in the system of corrosion protection of metal surfaces
- The coating is distinguished for good chemical and mechanical resistance.
- It enables the application of the top coating according to the “wet on wet” system
- Combined with an adequate top coating, it is suitable for exposure in an industrial or marine atmosphere.
- VOC compliant

				SANDBLASTED SURFACE
SUBSTRATE PREPARATION	 P220 – P280	 GRAVIHEL Antisilicone cleaner	 GRAVIHEL Antisilicone cleaner	Dust free
	 GRAVIHEL Antisilicone cleaner	 P220 – P280	 P220 – P280	 GRAVIHEL Antisilicone cleaner
		 GRAVIHEL Antisilicone cleaner	 GRAVIHEL Antisilicone cleaner	

Typ of product: 2K epoxy-polyamidoamin
Appearance SEMI MATT

Delivery viscosity: Thixotropic
 DIN 53211 φ4 / 20°C

Density of component A: 1,499 – 1,685 kg/l











Solid content: By volume: 48%
 By weight: 78%

VOC: 2004/42/II B(c)(540)520
 EU limit value VOC for this type of product (category II B (c)) in the form, which is ready for application is

540 g/l. VOC of this product, prepared for use is 520 g/l

IT IS ALSO USED TO RENOVATE INDUSTRIAL AND COMMERCIAL VEHICLES

Theoretical yield: 6 - 7 m² /lit.
Temperature resistance (dry temperature) Short-term: up to 140 °C
 Long-term: up to 120 °C
Processing temperature: +10°C till max. +40°C, max.Humidity 75%
Color shades: GREY

	Mixing ratio by Volume:	3:1+15 - 25% GRAVIHEL EPOXY HARDENER GRAVIHEL EPOXY THINNER																		
	Pot life of the mixture at 20°:	8 h																		
	Viscosity (RFU): DIN 53211 Φ4 / 20°C	37 - 40 sec.																		
	Application with spray gun:	1,5 – 1,7 mm 2 – 3 bar																		
	Number of layers: Film thickness:	2 60 - 80 μm																		
	Flash-off:	5 - 10 min. /20°C between coats																		
	Drying time:	<table border="0"> <thead> <tr> <th>Object temperature</th> <th>at 20°C</th> <th>at 60°C</th> </tr> </thead> <tbody> <tr> <td>Powder dry:</td> <td>8 min.</td> <td>-</td> </tr> <tr> <td>Dry to touch:</td> <td>4,5 h</td> <td>-</td> </tr> <tr> <td>Dry to assembly:</td> <td>24 h</td> <td>40 min.</td> </tr> <tr> <td>Dry for sanding:</td> <td>24 h</td> <td>40 min.</td> </tr> <tr> <td>Top coat:</td> <td>24 h</td> <td>40 min.</td> </tr> </tbody> </table>	Object temperature	at 20°C	at 60°C	Powder dry:	8 min.	-	Dry to touch:	4,5 h	-	Dry to assembly:	24 h	40 min.	Dry for sanding:	24 h	40 min.	Top coat:	24 h	40 min.
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Top coat:	24 h	40 min.																		
	Application with Airmix:	0 - 5% GRAVIHEL EPOXY THINNER Nozzle: 0,28 – 0,33 mm Pressure: 100 bar Flash-off between coats: 0 - 5 min. /20°C																		
	Brush application:	Thinner is not needed!																		
		Adding 1% of GraviHEL EPOXY ACCELERATOR. ACCELERATES curing and achieving of the final hardness of the coating.																		

	Shelf life:	2 years
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FOR PROFESSIONAL USE ONLY - See Safety Data Sheet

The data may vary under various conditions.,

Any part of this information may change at any time without notice.

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