













Technical information (04/2021)

GRAVIHEL EPOXY PRIMER 50 RAL

- 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)535
 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 535 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: Shade according to the RAL card

	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

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.

The information was derived from years of experience in the collaboration of Development and Technical Services and is the property of HELIOS Refinish.

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