

GlobalStar

2I.3.70121

Grey Epoxy Primer

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EU/ROW082320162I.3.70121

Technical Data Sheet

Description

2I.3.70121 is a 2K, high build, epoxy primer with excellent corrosion resistance and adhesion onto properly prepared hot or cold roll steel, aluminum and many other non-ferrous metals, fiberglass, concrete and over properly prepared 2K painted surfaces.

Suggested Uses

As a non-sand or sand-able primer.

Over any of the above mentioned properly prepared substrates where:

- High level of corrosion resistance is needed.
- Excellent adhesion is needed.
- High productivity is required.
- VOC restrictions are present.
- Excellent performance when applied with airless, air-assist airless pressure pot, cup gun.

Components

2I.3.70121

0G.006

0B.150

0B.V50

Base

Epoxy Reducer

Quick Epoxy Hardener

Epoxy Vinyl Hardener (For extended open time before topcoat)

Field Applications

- Semi-trucks
- Structural steel
- Coachworks (Buses)
- Work panel trucks
- Trailers and frames

GlobalStar Industrial

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- Construction equipment
- Cement trucks and snow plows
- Many OEM applications
- Oil Field Equipment
- Aircraft and marine

Mixing Ratio

Mix:

Four (4) parts 2I.3.70121 Epoxy Base to one (1) part 0B.150 Epoxy Hardener. Reduce 0%-15% with selected reducer.

*Option, 0B.V50 Hardener can be used at the same mixing ratio to extend the recoat open time on this product to one month.

Application

Apply:

One to two medium wet coats, allow 10-20 minutes flash between coats.

Or Apply one medium light coat followed by a medium cross coat.

Spray Gun:

HVLP Gravity Feed – 1.4 – 1.6mm tip and needle
Pressure Pot HVLP – 1.0 – 1.2mm tip and needle
Air Assist Airless - 1.0 – 1.2mm tip and needle
Conventional – 1.5 – 1.8mm tip and needle
Airless - 310 – 610 – 313 – 613 nozzle
Brush or Roller for small areas.

Film Build:

50-60 microns – (2.0 – 2.5 mils.)

Dry Times

Dust Free:

20-30 minutes @ 20° C (68° F)

Recoat Time:

1 Hour @ 20° C (68° F)

Dry to Touch

4-5 hours @ 20° C (68° F)

Total Hardness

24 - 36 hours @ 20° C (68° F)

Force Dry

30 - 40 minutes @ 60° C (140° F)

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Surface Preparation

Ferrous metals:

Best Case

SA2 or SA2 1/2 sandblast, Blow all dust and contaminates off and apply primer within 8 hours.

Second Best Case

Hot Phosphate wash system, blow dry and apply 2I.3.70121 primer within 8 hours.

Third Best Case

Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply 2I.2.70133 primer within 4 hours.

Aluminum:

Clean surface with clean drying wax and grease remover. Light Sanding (400P-500P grit) or brown scotch brite sanding. Clean again with clean drying wax and grease remover using a wipe and dry process. Apply 2I.2.70133 Epoxy Primer within 4 hours.

Galvanized Steel:

Clean all dust, oil residue, and contaminates from surface using a Clean drying wax and grease remover.
Light Sanding (320P-500P grit) or brown scotch brite sanding
Clean again with clean drying wax and grease remover using a wipe and dry process. Apply 2I.2.70133 epoxy primer.

VOC

Regulatory VOC

540 g/l

Actual VOC

540 g/l

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Solids

By Volume

48% + or - 2%

By Weight

64% = or - 2%

Specific Gravity

1.60 + or - 0.05 Kg/l for Base

Coverage

8 - 9m² /Kg

Repainting

After 36 hours @ 20°C (68° F) light sanding needed.

(If OB.V50 Hardener is used open time extends to 1 month)

Adhesion

(ASTM D 4541)

1850 psi - Excellent

(ASTM D 3359)

A/B (5/5) - Excellent

Salt Spray

(ASTM B 117)

Pass 1000 hours

Direct Impact

(ASTM D 2794)

Very Good (140 in-lb.)

Reverse Impact

(ASTM D 2794)

(50 in-lb.)

Humidity Resistance

(ASTM D 2247)

Pass 1000 hours

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Flexibility

(ASTM D 522)

Excellent (Mandrel)

Storage Stability

Two year, stored in closed package, in cool dry place, away
From any sources of heat.

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