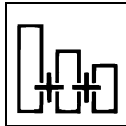


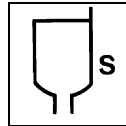


LS107 (29107) EPOXYPRIMER



1000 ml +
500 ml +
0-100 ml

Pot life at 20° C
4 h



22-30° DIN 4
at 20° C



Ø 1,6-1,9 mm
3,5-4,5 Bar
HVLP:
Ø 1,4-1,8 mm
2-2,5 Bar
N° of coats: 2-3



Air drying at 20°C
Handling: 5 h
Sanding: 18 h
Low bake:
30 min. at 60°C
45 min. at 50°C

DESCRIPTION

Two-pack epoxy primer-sealer/filler with anticorrosion power and zinc-phosphate.

USE

Suitable as a primer or as a sealer-filler in industrial Truck Refinish and Industry in general.

CHARACTERISTICS

- Easy to apply
- Very good adhesion to:
 - steel
 - zinc-coated steel (electro-galvanised and hot dip galvanised steel)
 - aluminium and light alloys
- Excellent anticorrosion power
- High filling power
- Fairly good sanding
- Low topcoat absorption
- Possible wet-on-wet process
- Chromate- and lead-free

SUBSTRATE PREPARATION

Black steel sheet: microsand or sand.

Steel sheet: degrease carefully with 00695 SILICONE REMOVER SLOW and sand or sandblast.

Aluminium and light alloys: clean and degrease with 00695 SILICONE REMOVER SLOW. Sandblast or sand carefully.

Electro galvanised steel: degrease carefully with 00695 SILICONE REMOVER SLOW.

Hot dip galvanised steel: degrease with 00695 SILICONE REMOVER SLOW and sand or rub down.

Fibreglass: Degrease with 00695 SILICONE REMOVER SLOW. Sand if necessary.

APPLICATION

Spraying.

Mixing ratio:

	weight	volume
LS107 EPOXYPRIMER (derived from binder 29107)	1000 g	1000 ml
29370 (Standard)-29371 (Fast) LECHSYS EPOXYPRIMER HARDENERS	300 g	500 ml
00516 LECHSYS EPODUR THINNER or 00556 LECHSYS EPODUR PF THINNER *	0-50 g	0-100 ml

*for extra-EEC countries only

Pot life at 20°C: 4 hours (with standard hardener)
Spray viscosity at 20 °C: 22 - 30" DIN4
Ø Air cap: 1.6 - 1.9 mm; HVLP: 1.4 - 1.8 mm
Air pressure: 3.5 - 4.5 bar; HVLP: 2 - 2.5 bar
Number of coats: 2 - 3
Film thickness: 70-100 µ
Theoretical coverage: 1 l mixture = 4.5 m² at 100 µ
1 kg mixture = 3.5 m² at 100 µ

DIR 2004/42/CE: Primer IIB/c – VOC ready for use 540 g/l
This product ready for use contains at most 500 g/l VOC

DRYING TIME

Air drying at 20 °C

Dust-free: 15-20 min.
Handling: 5 h
Sanding: 18 hours
Through-drying: 48 hours

Low bake:

at 60 °C: 30 min.
at 50 °C: 45 min.

Try not to dry the product under 15 °C

SANDING

When using EPOXYPRIMER as a **primer** dry sand with P180 - 220
When using EPOXYPRIMER as a **sealer-filler** dry sand with P280 - 320

SUGGESTED OVERCOATING

Dry-on-dry process:

- After 8 to 10 hours at 20°C from the application it can be overcoated with a knifing polyester putty.
- It can be overcoated with itself when used as a filler or with other epoxy and polyurethane fillers. Generally it is used in industrial Truck Refinish in "two products" cycles, that is to say directly overcoated with enamels of the LECHSYS range: ISOLACK – ACRITOP.

Wet-on-wet process:

Wait from 1 hour to 24 hours at 20°C and directly overcoat with two-pack polyurethane enamels (ISOLACK-ACRITOP).

NOTES

The binder 29107 is chromate- and lead-free. It is recommended to avoid adding the base colours 29011, 29012 and 29026 in the formulations, as they contain lead and would make the final product lose its non-toxic characteristics.

The use of the fast hardener causes a pot life reduction.

The catalysed and thinned product is also usable with universal electrostatic equipment.

Search the formulation to produce under "SOTT" on the Data Box and choose the colour in the respective colour fan.

TECHNICAL DATA SHEET N° 0356-GB **UPDATED 10/2014**

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