



A high build, fast-drying, multi-substrate primer with excellent adhesion and corrosion protection properties to all ferrous and non-ferrous metal surfaces such as galvanised steel and aluminium. It is specially formulated to enhance the adhesion and anti-corrosion properties of ToughOX to provide the ultimate long term protective coating system.

Features and benefits

- Outstanding adhesion to multiple substrates
- Fast drying time - overcoat wet on wet with ToughOX after 30 mins
- Easy to sand - wet or dry
- Solvent and chemical resistant
- Excellent corrosion and moisture protection

Mixing Instructions

- Mix 4 parts ToughOX 2K Epoxy Primer to 1 part ToughOX 2K Epoxy Hardener by volume
- Thinning: Use ToughOX 2K Epoxy Thinner 10-40% depending on application

Surface Preparation

All surfaces must be clean, dry and free of grease

Substrate sanding guide

Bare Steel	P80
Zinc coated/Galvanise	P180
Aluminium	P180
Wood	P180/240
Body Filler	P180/240
GRP / SMC	P180/240

Physical and chemical data

Resin: 2K Epoxy

Colour: Grey

Pot Life: 6 hours at 20°C

Dry Film Thickness: 50-100 µm

Theoretical Coverage: 10m² / litre at 50 µm

Viscosity: DIN 6: 30-40s at 20°C

Vol Solids: 50% by volume

VOC Max 580 g/l in the ready to use form

Storage: Store in a cool dry place in original container between 10°C - 25°C

Substrates

Bare steel
 Aluminium
 Galvanised
 Wood
 GRP/SMC

Drying Times @ 20°C

Dust-free	30 minutes
Wet on wet over coatable with ToughOX (50µm)	30 minutes
Dry to handle	2-3 hours
Dry to sand	3-5 hours
Fully cured	5 days

IMPORTANT: Do not stack or load heavy objects onto the painted surface until the coating is fully cured. Always adhere to the drying times above. Thicker coats will extend the final curing time.

Storage

Product is recommended to be stored in cool, dry conditions in original containers between 5-27°C. The shelf life of the product is 24 months from date of manufacture in unopened containers.

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