

# C.A.R.FIT

## Description

High quality two component epoxy primer can be used as an insulation coating. 2K epoxy primer 1:1. It is specially recommended to apply the product wet on wet.

## Application

For two-coat paintworks in car refinishing.

## Characteristics

- Perfect protection of steel surfaces from corrosion due to anticorrosion additives
- Easy to mix and apply
- Easy to overcoat due to light-grey color
- Excellent flow
- Excellent adhesion to different surfaces: steel, aluminum, galvanized steel, fiberglass, polyether and epoxy putties, wash primers, paintworks

## Substrates

Steel, aluminum, galvanized steel, polyester laminates GFK/GRP, polyester / epoxy putties, 2K primers, old finishing coatings in good condition.

Articles	Description	Pcs. / pack
4-390-0500	0.5 L, Primer	6
4-415-0500	0.5 L, Hardener	6

## 2K Epoxy Primer 1:1



VOC: <540 g/L  
EU limit value: 2004/42/IB(c)(540)

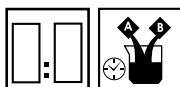
### Substrate preparation



All substrates must be cleaned, dried, degreased with C.A.R.FIT Silicone Remover and sanded. Steel surface should be degreased, dry sanded and degreased again. The aluminum and galvanized steel surfaces should be degreased, sanded and degreased again. The old coatings should be degreased, dry sanded and degreased again. The following abrasives are recommended:

- by hand (dry or wet): P280+P320; - by machine (dry): P180+P220.

### Preparation



- 1:1 with Hardener for 2K Epoxy Primer 1:1  
- Pot life at 20°C: ca. 3 h



18-20 sec, FORD 4 at 20°C



- Do not exceed recommended doses of hardener!
- The best repair results you can achieve while working at room temperature.
- The temperature in a body shop and the temperature of a product should be the same.
- When working with 2K products, clean spray guns and equipment immediately after use.

### Intermediate sanding application and treatment



1.4–1.7 mm / Inlet pressure: see spray gun manufacturer's tips



- Flash-off at 20°C: ca. 10 min  
- Drying at 60°C: 35 min



2 – 3 layers = 100 – 140 µm  
Flash-off between layers: 5 – 10 min



- Flash-off at 20°C: ca. 10 min  
- Short wave IR drying: 15 – 20 min (at 100-140 µm dry coat thickness)



5 h at 20°C



- Sanding dry P400-500  
- Sanding wet P800-1000

### Wet-on-wet application and treatment



1.4–1.7 mm / Inlet pressure: see spray gun manufacturer's tips  
1.5 – 2 layers = 20 – 25 µm  
Flash-off between layers: 5 – 10 min



Flash-off at 20°C: ca. 45 - 60 min depending on dry coat thickness

### Further treatment



Overcoats with 2K acrylic fillers, 2K epoxy fillers or / and refinishing materials.

### Technical data

Color light grey  
Density 1560 g/L

### Storage



Keep away from direct sunlight