

**TECHNICAL DATA SHEET***Revision date: 20.03.2024***2K EPOXY PRIMER**

**Article number:** 14554

**Colour:** light grey

**Intended use:** Car refinishing product/ Filler

**General characteristics:** 2K Epoxy primer is a highly effective in harsh environments chromate free filler, based on epoxide-polyamide resin, designed to withstand moisture and chemicals. Perfectly suitable as primer for polyester body fillers and polyester spraying filler. Excellent flow, fast drying, can be recoated after only 30 - 45 min. High gloss retention by wet-on-wet processing.

**PAINTING PREPARATION PROCESS****Hardener:** Chamäleon 255 Hardener for 455 Epoxy primer**Mixing ratio (by volume):** 2:1**Mixing ratio (by weight):**

Primer, g	Hardener, g	Thinner, g	
		Filler, 10%	Wet-on-wet, 25%
97	30	9	22
194	59	18	44
291	89	26	66
387	119	35	88
484	148	44	110
581	178	53	132
678	208	62	155
775	237	71	177
872	267	79	199
969	297	88	221

**Dilution:** Chamäleon UNI Thinner 322/323, addition 10 % as sanding primer; 25% as wet-on-wet primer**Spraying viscosity 4 mm DIN (20°C):** 16 - 22 s**Pot life at 20 °C:** 5 h

### Substrate pre-treatment:

The substrate must be clean, dry, free from rust and grease. Remove old coatings or primers that have not cured or are not sound.

Old paint coating	Degrease, dry sand with P220-320, blow off, degrease again
Galvanized steel	Degrease, dry sand with P220-320, blow off, degrease again
Aluminium	Degrease, dry sand P220-320 or mat with an abrasive finishing pad, degrease again
Steel	Degrease, dry sand with P120-320, blow off, degrease again
Zinc	Pre-treat with the ammoniac wetting agent

### APPLICATION PROCESS

#### Processing conditions:

Please only use in an adequate ventilated environment with an ample supply of fresh air. Processing temperature should be at least +12 °C and max. air humidity should not exceed 80%.

Application method	Pressure	Nozzle
Gravity spray gun	1.6 - 2.0 bar	1.3 - 1.6 mm
HVLP	1.6 - 2.0 bar	1.3 - 1.6 mm

Spraying operations	DFT	Consumption
1 - 2	25 - 50 µm	9 - 10 m <sup>2</sup> /l

Flash-off time	Between the coatings	Before the oven drying
	5 - 8 min	10 - 15 min

Drying	Dust free	Re-coatable
Object temperature 20 °C	10 - 15 min	30 - 45 min
Object temperature 60 °C		30 min
IR-Drying shortwave*		8 min
IR-Drying mediumwave*		10 - 15 min

\*The temperature of the object should not be more than 60 - 70 °C.

#### Processing tips:

- Recoat with putties: after 30 min. at 60 °C or 12 hours at 20 °C. Do not apply more than 25 µm film thickness (1 thin layer) when putties will be used for recoating.
- If higher coat thickness is needed it's possible to apply 2K Epoxy primer 455 also in dry film thickness of up to 120 µm. In this case it's absolutely necessary to observe a drying time of at least 16 hours at 20 °C.

- After drying time of more than 48 hours it's necessary to sand the priming coat.
- Tools should be cleaned with thinner immediately after use. Clean overspray with nitro-thinner immediately. Remove dried films with a paint remover.

### Sanding:

Sand (with sandpaper P400 for dry or P600 for wet sanding for one-coat finishes, for two-coat finishes use P500 for dry and P800/1000 is recommended for wet sanding)

### Related Chamäleon products:

<b>Hardener</b>	255 Hardener for 455 Epoxy primer
<b>Thinner</b>	322 UNI Thinner/323 UNI Thinner slow

### VOC regulation:

EU limit value: Category B/c 540 g/l

This product contains max. 540 g/l VOC

### Shelf life:

36 months, if stored in tightly closed original containers.

This release replaces all eventually earlier issued versions.

For additional information, not contained in this Technical Data Sheet, please contact the supplier via:  
[info@chamaeleon-produktion.de](mailto:info@chamaeleon-produktion.de)

For safety information, please refer to the corresponding Safety Data Sheet.