#### **GENERAL INFORMATION**

1-7520 Epoxy Primer Grey is a high-filling Epoxy Primer with good resistance to chemicals, that is easy to spray. Wet-on-wet application is possible.

#### **MIXING RATIO**



Sanding: 2:1 Primer: Hardener + 15% Uni Thinner Non-Sanding: 2:1 Primer: Hardener + 20% Uni Thinner

# **COMPONENTS**



1-70 Epoxy Primer Hardener 1-141 Uni Thinner Fast 1-151 Uni Thinner Medium 1-161 Uni Thinner Slow

## **GUN SET UP**



	NOZZLE (MM) AIR PRESSURE (BAR / PSI		
HVLP	1,3-1,5	2/29	
HE	1,3-1,8	1,8-2,0/26-29	
Airless / Airmix	0,009-0,011"/40°	160-200/ 2100-2900	

#### **ADDITIVES**



#### **APPLICATION**



**Sanding:** 1 - 2 coat 50 - 80 μm (2,0-3,15 mil) **Non-Sanding:** 1 coat 50 μm (2,0 mil)

#### **SURFACE PREPARATION**



Cleaning: Clean with 1-951 Silicone Remover by using wipe on/wipe off method. Sanding: Sand surface thoroughly with P180 dry discs. For preparation of E-coat and OEM finishes sand with P240 dry discs or scuffing pad. Cleaning: After preparation of substrate repeat cleaning procedure.



Mask entire vehicle to eliminate unwanted overspray.

# **FLASH OFF AND DRY TIMES**





AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off wet-on-wet	45 minutes	Flash off dry	10 - 20 minutes
Dust free	45 minutes	Dust free	-
Dry to handle	16 hours	Dry to handle	60 minutes
Dry to tape	16 hours	Dry to tape	60 minutes
Dry to sand	16 hours	Dry to sand	60 minutes
Dry to polish	-	Dry to polish	-

Flash off times for wet-on-wet application 45 minutes.

## **NEXT LAYER**



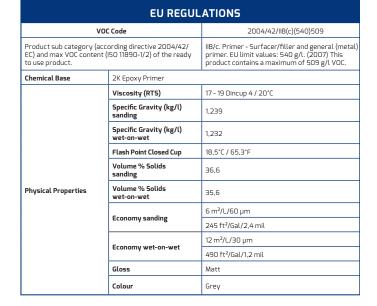
MM 900 - 9999 WaterBase 900\* Series MM 500 - 5999 BeroBase 500 Series MM 2000 - 2099 BeroMix 2000 Series MM 3000 - 3046 BeroThane HS420 3000 Series

# **SUBSTRATES**



Cured and sanded old paint systems on: Metal, (Steel-zinc-aluminium) or sanded polyester.

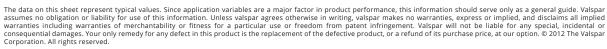
## **PHYSICAL DATA**



# POT LIFE AT 20°C / 68°F



24 hour







# 1-7520 Epoxy Primer Grey

## **PROTECTION**

Use suitable respiratory protection (fresh air supply respirator is strongly recommended).



For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.de-beer.com/en/debeer/choose\_localization

#### **CLEAN UP**



1-051 Gun Cleaner

### STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F ) (unopened container).



#### **NOTES**

Can be sanded both wet and dry. Due to the large variety of aluminium parts, first contact supplier.

