

GOLDline

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

TROTON GOLD LINE EPOXY 1:1



PRODUCTS

Troton Gold Line Epoxy 1:1
Hardener 1:1 for Troton Gold Line Epoxy

PRODUCT DESCRIPTION

2-pack epoxy primer with anti-corrosion additives for car body repairs. Designed especially for wet-on-wet application.

- ✓ Excellent protection of steel surfaces.
- ✓ Very strong adhesion to various substrates.
- ✓ Easy to mix and apply.
- ✓ Exceptional smooth leveling.

Color - Light grey.
Gloss Grade – Matt.
Density – 1,57 kg/l.

VOLATILE ORGANIC COMPOUNDS

VOC = 540 [g/l]

The share of VOC is 540 g/l. These products fulfill the EU directive (2004/42/EC) that sets the VOC value for this product category (B/3), as 540 g/l.

SUBSTRATES AND PREPARATION

Epoxy primer can be applied over:

- ✓ Bare steel and aluminum.
- ✓ Zinc coated, galvanized steel.
- ✓ Polyester laminates (GFK/GRP).

TROTON Sp. z o.o.

Ząbrowo 14A; 78-120 Gościno; Poland

Tel/Fax: +48 94 35 126 22; Tel: +48 94 35 123 94; Website: www.troton.com.pl; Email: troton@troton.com.pl

- ✓ 2-pack polyester putties.
- ✓ 2-pack epoxy fillers.
- ✓ Old finishes in good condition.

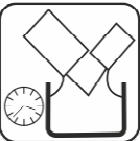
Steel surface should be first degreased, dry sanded and degreased again.

Aluminum and galvanized steel should be degreased, dulled with the abrasive cloth and degreased again.

Old coatings should be degreased, dry sanded and degreased again.

Good preparation is necessary for achieving the best results.

APPLICATION PROCESS

	USE For car repairs as a grounding primer.										
	<table border="0"> <tr> <td>Mixing ratio</td><td>by volume</td></tr> <tr> <td>Primer</td><td>1 part</td></tr> <tr> <td>Hardener</td><td>1 part</td></tr> <tr> <td>Thinner</td><td>---</td></tr> <tr> <td colspan="2">Stir well</td></tr> </table>	Mixing ratio	by volume	Primer	1 part	Hardener	1 part	Thinner	---	Stir well	
Mixing ratio	by volume										
Primer	1 part										
Hardener	1 part										
Thinner	---										
Stir well											
	Spraying viscosity 18÷20 seconds at 20°C.										
	Pot life approx. 3 hours at 20°C.										
	Number of layers For wet-on-wet application: 1,5÷2 layers; approx. 25÷50µm of dried film thickness. For sanding: 2÷3 layers; 100÷140µm of dried film thickness. Gun Parameters Nozzle: 1,4÷1,7 mm . Pressure: according to the gun's producer recommendations, usually 2÷3 bar. Gravity: 1,2÷1,5 mm,										

	Evaporation time Between layers: approx. 5÷10 minutes Before baking: approx. 10 minutes Before applying the next coating (wet-on-wet): 45÷60 minutes Evaporation time depends on the temperature and layer thickness.
	Hardening time Specific dryness at 20°C: after approx. 5 hours (depending on the layer thickness) Specific dryness at 60°C: after approx. 35 minutes (depending on the layer thickness) Temperature below 20°C significantly increases the hardening time.
	IR drying 8÷10 minutes under short waves depending on the layer thickness (100÷140µm) and type of radiator. Do not exceed the temperature of 60°C. Use in accordance with the recommendations of the equipment's manufacturer. Wait about 10 minutes before starting the IR drying.
	Dry Sanding Abrasive paper P400÷P500 Wet-on-wet application does NOT require sanding!
	Wet Sanding Abrasive paper P800÷P1000 Wet-on-wet application does NOT require sanding!

Component quantity by weigh:

Mixture Quantity [ml]	Epoxy Primer [g]	Hardener [g]
100	78	44
150	117	66
200	157	88
300	235	132
400	313	176
500	391	220
1000	783	441

1500	1174	661
2000	1565	881

FURTHER WORKS

2K epoxy primers can be directly over coated with:

- ✓ 2-pack polyester body fillers.
- ✓ 2-pack polyester spray fillers.
- ✓ 2-pack acrylic primers.
- ✓ 2-pack acrylic topcoats.
- ✓ 1-pack basecoats.

GENERAL NOTES

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

Caution: *To maintain safety, always follow the instructions given in the MSDS of the products.*

STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: *After each use the container with products should be immediately closed! Protect hardener against freeze and humidity!*

WARRANTY PERIOD

Troton Gold Line Epoxy 1:1 - 12 months from the date of Manufacture.

Hardener 1:1 for Troton Gold Line Epoxy – 12 months from the date of Manufacture.

Limitation of liability:

The information contained in the TDS is up-to-date and correct on the day the information is released.

Because TROTON can not control or predict the conditions under which a product will be used, each user should review information in the specific context of the intended usage. To the maximum extent permitted by applicable law, TROTON shall not be liable for damages of any kind arising from the use or reliance on information contained in this TDS.

Given the variety of factors that can affect the usage and application of the TROTON product, some of which are only within the user's knowledge and control range, it is essential that the user evaluate the TROTON product to determine if the product is fit for a particular purpose and whether the product is suitable for the user's usage.

Under no circumstances shall TROTON be liable to the user or any third party for any indirect, derivative, incidental, special or punitive damages, including loss of profits resulting from the use of products manufactured by TROTON and / or TROTON's services.

All information is based on meticulous laboratory tests and many years of experience. An established position on the market does not release us from continuous quality control of our products. However, we are not responsible for the final effects of improper storage or use of our products, and for work that is not in line with good craftsmanship.

TROTON Sp. z o.o.
Ząbrowo, Poland.