

Description

Top-quality primer suitable for wet-on-wet application directly on new unsanded ecoated panels. With easy application it delivers smooth surface finish. E-coat primer 7100 M10 enables fast repair process with elimination of sanding and drying times. The primer can be overcoated wet-on-wet after minimum 30 minutes from application and even after 4 days from application without sanding.

Features & Benefits

- application directly to new ecoated parts without sanding
- direct to metal application, adhesion on Zinc-platted and Aluminium substrates
- minimum flash-off before topcoat application: 30 minutes
- maximum flash-off without sanding: 4 days
- smooth surface delivers top finish results
- 4:1 mixing ratio (hardeners: 9220, 9230, 9250, 9270)

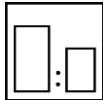
Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner (art. 9515). Before application of the primer filler on bare steel/metal, sand the surface. Bare steel should be lightly abraded and completely rust free before application.

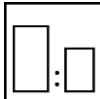



- New ecoated parts/panels: use anti-silicone cleaner
- Steel parts: sand with P400/dry or P800/wet.
- Old coatings sand with P280 - P320/dry or P800/wet.
- GRP or Fiberglass sand with P320/dry.
- Polyester Fillers sand with P120-P320/dry.
- Zn and Alu: Scuffing pad + matting paste

The primer can be applied directly, but a 2K Epoxy primer is recommended where optimum adhesion and corrosion resistance is required. It is recommended to use appropriate primer to optimize adhesion and corrosion protection on aluminium and galvanized steel surfaces.

Application

	Mixing ratio	By volume	By weight
	7100 M10 E-primer	4	1000
	9220/9230/9250/9270 HS Hardener	1	170
	7050 Maxx Thinner, standard	10 – 20 %	65 – 130
	Extra fast (9220) and fast (9230) hardeners should be used in case of painting only smaller parts or/and at lower temperatures. Standard (9250) and slow (9270) hardeners should be used in case of painting larger areas and/or at high temperatures. For detailed mixing ratios please see table 1.1 at the end of this document. If thicker layers are needed less thinner should be added.		

Application on plastic parts

	Mixing ratio	<u>By volume</u>	<u>By weight</u>
	7100 M10 E-primer	4	1000
	9220/9230/9250/9270 HS Hardener	1	170
	7035 4Plastic additive	10 %	65
	7050 Maxx Thinner, standard	0 – 10 %	0 – 65 %
	Spray gun set /air inlet		
	Gravity feed 1.2 - 1.4 mm:	1.5 – 2.0 bar	
	Suction feed:	Verify manufacturer's info	
	Application		
	Total dry film build:	30 – 35 µm	
	Number of coats:	1 – 2 coats (Apply 1 full single coat or 1 light + 1 full to give a film thickness of 30 – 35 microns)	
	Flash-off between layers:	5 min	
	Overcoating		
	MIN flash-off before next coating (20°C/68°F):	30 min	
	MAX flash-off before next coating (20°C/68°F):	Up to 4 days *	
	After 4 days thorough sanding with P400 - P500 is needed before topcoat system can be applied.		
	* This time can be shorter if faster hardener speed is used.		

	<u>Hardener speed</u>	<u>MAX flash-off time</u>	<u>MIN flash-off time</u>
	9220	Same working day	20 min
	9230	Within 24 hours	30 min
	9250	4 days	30 min
	9270	4 days	30 min
Dry to sand (20°C/68°F): Next day			
Potlife (20°C/68°F): 60 min			

Complementary products

- 9220/9230/9250/9270 HS Hardener
- 7050 Maxx Thinner Standard
- 7035 4Plastic Additive

Prod. Nr.	Description	Volume	Packaging Box
7100-A-1	White	1 L	6
7100-B-1	Dark Grey	1 L	6
7100-C-1	Light Grey	1 L	6

VOC

2004/42/IIIB(c) (540) <540

Additional information

Spray viscosity: 15 – 16 s DIN4

Specific weight: 1,43 – 1,48 kg/L

Theoretical coverage (ready to spray): 14 m²/ 30 µm

Testing of the material

Any kind of testing of the applied material (adhesion test, stone-chip test, chemical resistance, salt chamber test ...) has to be done at least 15 days after the application.

Processing instructions – Painting plastic parts

Due to the most different kinds of plastic and compounds on the market we recommend pre-testing the product on original plastic parts (application and adhesion). The product should have good adhesion on PP-EPDM, PP and ABS.

Before application, reheat the object to be painted for 60 minutes at 60°C. Degrease the surface with Silco antisilicone degreaser. Sand/matt with matting paste. Clean again with Silco antisilicone degreaser. Allow parts to dry completely. **ATTENTION:** Sanded material must be removed completely! After this preparation we recommend doing a wetting test with water. If the water rolls off quickly repeat the pre-treatment. Additionally, use of Antistatic Degreasing Wipe (art.no. 2215) is recommended.

Shelf life

Min. 24 months from the production date under normal storage conditions and unopened can.

Table 1.1 – Mixing ratio by weight (with 9220/9230/9250/9270 Hardener)

Volume of RFU paint required (ml)	Weight Primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
100	114	132	139
250	284	330	347
330	375	436	458
500	569	660	694
750	853	990	1040
1000	1137	1321	1387

Additional Information

FOR PROFESSIONAL USE ONLY!

Always read the instructions.

IMPORTANT: This product contains hazardous substances at work so it is necessary to always use/wear appropriate protective equipment. For further instructions, check the label on the product and safety data sheet. A person who uses the product for any purpose other than recommended in this technical data sheet, acts at his own risk. It is the user's responsibility to take all necessary steps to fulfil the local legislation.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public.

Information and methods described are based on the best information and practices known to us and serve merely as guidelines for optimal use, without liability to performance, results or fitness for any intended use. We do not accept any responsibility for the behaviour of the product or damage arising from the use of the product. Before using the product, the user must check if this is the latest version.

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