840R
VOC EPOXY PRIMER-SURFACER



PRODUCT DESCRIPTION

VOC Epoxy Primer-Surfacer 840R Off White is a VOC-compliant, versatile 2K chromate-free epoxy primer-surfacer. It offers outstanding corrosion resistance and adhesion, and meets homologation requirements of certain car manufacturers.

R – Reliable Line. Consistently performing to specification to ensure process stability, deliver high-quality results, and support seamless operations across entire repair workflow.

FEATURES

01 Suitable for use as a sanding and as a non-sanding primer-surfacer.

02 Suitable for use on rough substrates such as grit-blasted metals.

03 Recommended as a first coat over bare metals.

04 Single step quality repair primer-surfacer, eliminated the need for a wash primer.

05 Provides excellent adhesion to properly treated metal substrates.

06 Suitable for tinting with AM Centari MasterTints, up to maximum 10% by weight.

07 Provides very good filling properties.

08 Has very good corrosion and chemical resistance.

TECHNICAL DATA SHEET

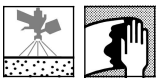
840R

VOC EPOXY PRIMER-SURFACER

Product preparation - application STANDARD NON-SANDING



It is strongly recommended to use appropriate personal protection equipment during application to avoid respiratory, skin and eye irritation.



Bare steel sanded and cleaned
Galvanised steel or aluminium sanded and cleaned
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.



	VS2	VS3	VS4	VS5
840R	100	100	100	100
AM5	-	1.5	5	10

	Standard		Large surface	
	Volume	Weight	Volume	Weight
840R	5	100	5	100
850R	1	11	1	11
AU370 / XB383	1.5	15	-	-
XB387	-	-	1.5	15



Potlife at 20°C: 6 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.6	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	final flash-off: 30 min - 2 hr	1 - 2 coats	with intermediate flash-off: 5 min - 10 min final flash-off: 1 hr - 2 hr



Primer	Primer-surfacer
2K Filler	2K Topcoat Centari Basecoats + Clearcoat

VOC compliant

2004/42/IIB(c)(540) 540: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

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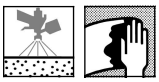
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Galvanised steel or aluminium sanded and cleaned
Old or original paintwork, sanded and cleaned.
OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
Surfaces pretreated with 2K polyester products and then finely sanded.
Glass fibre polyester substrates, free of release agents, sanded and cleaned.



	VS2	VS3	VS4	VS5
840R	100	100	100	100
AM5	-	1.5	5	10

	Standard		Large surface	
	Volume	Weight	Volume	Weight
840R	5	100	5	100
850R	1	11	1	11
AU370 / XB383	1.5	15	-	-
XB387	-	-	1.5	15



Potlife at 20°C: 6 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.6	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min
before bake: 5 min - 10 min



	850R / AU370 / XB383	850R / XB387
20 °C	12 hr - 16 hr	12 hr - 16 hr
60 - 65 °C	35 min - 40 min	35 min - 40 min



Guideline for short wave IR equipment
Half power: 3 - 5 min
Full power: 12 - 15 min



P400 - P600



2K Topcoat
Centari Basecoats + Clearcoat

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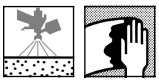
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Galvanised steel or aluminium sanded and cleaned
Old or original paintwork well sanded and cleaned.
OEM Primer (e-coat), finely sanded or unsanded and thoroughly cleaned. Remark: due to the wide variety of electrocoats present on the market, its quality can differ a lot. For this reason preferably scuff sand the e-coat
Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre reinforced polyester substrates, free of release agents sanded.



	VS2	VS3	VS4	VS5
840R	100	100	100	100
AM5	-	1.5	5	10

	Standard	
	Volume	Weight
840R	4	100
845R	1	14
XB387	1.5	20



Potlife at 20°C: 6 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.6	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.6	0.7 bar	air cap pressure

see manufacturer's instructions



Primer		Primer-surfacer	
1 coat	final flash-off: 30 min - 2 hr	1 - 2 coats	with intermediate flash-off: 5 min - 10 min final flash-off: 1 hr - 2 hr



Primer	Primer-surfacer
2K Filler	2K Topcoat Centari Basecoats + Clearcoat

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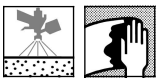
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Surfaces pretreated with 2K polyester products and then finely sanded and cleaned.
Glass fibre reinforced polyester substrates, free of release agents, sanded and cleaned.





M-6152 / M-6153

	VS2	VS3	VS4	VS5
840R	100	100	100	100
AM5	-	1.5	5	10

	Standard	
	Volume	Weight
840R	3	100
845R	1	18
AU370 / XB387	1	18



Potlife at 20°C: 6 hr



	Spray nozzle	Spray pressure	
Compliant	1.3 - 1.5	1.5 - 2 bar	inlet pressure
HVLP	1.3 - 1.5	0.7 bar	atomisation pressure

see manufacturer's instructions



2 - 3 coats

with intermediate flash-off: 5 min - 10 min
before bake: 5 min - 10 min



	845R / AU370	845R / XB383
20 °C	12 hr - 16 hr	12 hr - 16 hr
60 - 65 °C	35 min - 40 min	35 min - 40 min



Guideline for short wave IR equipment
Half power: 5 min
Full power: 12 - 15 min



P400 - P500



2K Topcoat
Centari Basecoats + Clearcoat

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Products

840R VOC Epoxy Primer-Surfacer

850R Epoxy Activator

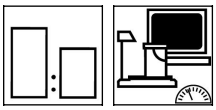
845R Epoxy Activator

AU370 Imron® 700 Polyurethane Thinner

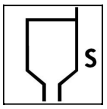
XB383 Standard Thinner

XB387 HI-Temp Thinner

Product mix



Mixing ratios with special agents are available in the productmix table on ChromaWeb and in the specific TDS.



DIN 4: 16 - 19 s at 20°C



60 - 110 µm sanding
20 - 30 µm non-sanding

Theoretical coverage

375 - 390 m²/l at 1 micron dry film thickness
Due to different activator characteristics and different mixing ratios of the ready-to-use mixture in some TDS versions, the theoretical coverage calculation may vary.
Note: The practical material consumption depends on several factors, e.g. geometry of the object, surface formation, application method, spray gun setting, inlet pressure, etc.



Clean after use with a suitable solventbased guncleaner.

Remarks

- Material has to be at room temperature (18-25°C) before use.
- Allow additional time for preheating up to panel temperature.
- Surplus ready for use material should not be returned to original can.
- Can not be applied over acid containing primers.
- Polyester putties can be applied over cured and sanded epoxy primer-surfacers.
- Mix thoroughly by hand before placing the can on mixing machine.
- 840R can be applied by brush if no reducer is added to the activated material.

TECHNICAL DATA SHEET

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VOC EPOXY PRIMER-SURFACER

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.

All other products referred to in the refinish build up are from our Cromax product range. System properties will not be valid when the related material is used in combination with any other materials or additives which are not part of our Cromax product range, unless explicitly indicated otherwise.

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