

2110 Epo-Prime

Epoxy primer with high filling power, excellent adhearance and high resistance to chemicals.

- suitable for application over old paint or polyester putties
- polyester putty could be applied over it
- easy to spray, easy to sand wet or dry
- suitable for wet-on-wet application
- standard hardener 2120 (3:1) and fast hardener 2130 (2:1)

Substrate preparation

Clean, dry, and degrease the surface with a suitable anti-silicone cleaner. Epo-Prime may be applied directly to properly prepared bare steel, zinc coated, galvanised steel, aluminium, sanded old coatings and polyester body fillers.

- Bare steel sand with grid P80 – P120/dry.
- Aluminium sand with Scuffing – Cleaning Pad.
- Galvanised steel sand with grid P400/dry.
- Zinc coated steel sand with Scuffing – Cleaning Pad.
- GRP or Fiberglass sand with grit P320/dry or P800/wet.
- Old coatings sand with grid P320/dry or P800/wet.
- Polyester Fillers sand with grit P120-P220/dry.

Mixing ratio (normal application)

<div><div></div><div>3</div></div> : <div><div></div><div>1</div></div>	STANDARD HARDENER	By volume	By weight
	2110 Epo-Prime	3	1000
	2120 Hardener	1	185
	2115 Epoxy hinner	10 - 30%	60 - 170
<div><div></div><div>2</div></div> : <div><div></div><div>1</div></div>	FAST HARDENER	By volume	By weight
	2110 Epo-Prime	2	1000
	2130 Hardener	1	280
	2115 Epoxy hinner	10 - 30%	110 - 220

Spray gun setup (normal application)

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Nozzle	1,4 – 1,8 mm
Pressure (upper cup)	1,5 – 2 bar
Pressure (suction cup)	Verify manufacturer's info

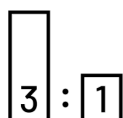
Application (normal application)



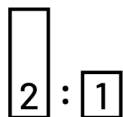
Number of coats	1 – 3
Total dry film build	50 – 150 µm
Flash-off	3 – 5 min (until matt)

For normal corrosion protection at least 150 microns of epoxy primer is needed. Because of different surface preparation and different edges/corners on the substrate, it is recommended to apply more than 150 microns of dry film thickness.

Mixing ratio (wet-on-wet)



STANDARD HARDENER	By volume	By weight
2110 Epo-Prime	3	1000
2120 Hardener	1	185
2115 Epoxy hinner	20 – 30%	110 – 170
Overcoatable after:	Min 30 minutes (or until the whole surface is matt). Max 24 hours (sanding needed after 24 hours).	



FAST HARDENER	By volume	By weight
2110 Epo-Prime	2	1000
2130 Hardener	1	280
2115 Epoxy hinner	10 – 30%	110 – 220
Overcoatable after:	Min 20 minutes (or until the whole surface is matt). Max 24 hours (sanding needed after 24 hours).	

Spray gun setup (wet-on-wet)

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Nozzle	1,2 - 1,4 mm
Pressure (upper cup)	1,5 - 2 bar
Pressure (suction cup)	Verify manufacturer's info

Application (wet-on-wet)



Number of coats	1
Total dry film build	35 - 50 µm
Flash-off	3 - 5 min (until matt)

Drying



Dry to sand [20 °C/68 °F]:	16 - 24 h
2120 Epoxy Hardener	90 - 120 min
2130 Fast Epoxy Hardener	

Dry to sand [60 °C/140 °F]:	30 - 60 min
2120 Epoxy Hardener	20 min
2130 Fast Epoxy Hardener	

Potlife [20 °C/68 °F]:	
2120 Epoxy Hardener	8 - 12 h
2130 Fast Epoxy Hardener	90 min



Recoat with:
• All topcoats
• Primer/Fillers
• Putties

Complementary products

- 2120 Hardener
- 2130 Hardener

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- 7035 4Plastic Adhesion additive (Plastic primer additive)

Packaging

Product number	Description	Volume/Weight	Packaging
2110-1	Light Grey	1 L	6
2110-5	Light Grey	5 kg	2
2110-20	Light Grey	20 kg	/

Volatile organic compounds

The VOC value for this product is 475 g/L

The product category is VOC 2004/42/II B (c) (540)

Testing of 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.

Application on plastic parts

In case of coating plastics: 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. 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).

Shelf life

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

Mixing ratio by weight: 3:1 with 2120 Hardener

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Volume of RFU paint required	Weight primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
(ml)	(g)	(g)	(g)
100	117	137	149
250	293	343	373
330	384	453	492
500	587	687	746
750	880	1030	1118
1000	1174	1374	1491

Mixing ratio by weight: 2:1 with 2130 Hardener

Volume of RFU paint required	Weight primer	Weight Primer + Hardener	Weight Primer + Hardener + Thinner
(ml)	(g)	(g)	(g)
100	106	133	144
250	265	332	359
330	349	439	474
500	529	665	718
750	794	997	1076
1000	1059	1329	1435

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.



Technical data sheet

2025-1

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