



## TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

### TROTON GOLD LINE CATHODE PRIMER 3:1

#### PRODUCTS

TROTON GOLD LINE CATHODE PRIMER 3:1

Hardener 1:3 for Cathode Primer

Thinner for acrylic systems



#### PRODUCT DESCRIPTION

High quality 2-pack acrylic primer with anti-corrosion additives for car body repairs. Works perfectly as an insulating base and prevents against mapping effects. Offers very good protection against corrosion especially for places sanded to bare steel and new panels. Designed especially for wet-on-wet application.

- ✓ Very good protection of steel surfaces.
- ✓ Strong adhesion to various substrates.
- ✓ Short hardening time.
- ✓ Exceptional smooth leveling.
- ✓ Very good insulating properties

Color – light grey.

Gloss Grade – Matt.

Density – 1,42 kg/l.

#### VOLATILE ORGANIC COMPOUNDS

VOC for mixture = 538 [g/l]

The share of VOC is below 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

Cathode Primer can be applied over:

**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](http://www.troton.com.pl); Email: [troton@troton.com.pl](mailto:troton@troton.com.pl)

- ✓ Bare steel and aluminum.
- ✓ Zinc coated, galvanized steel.
- ✓ Polyester laminates (GFK/GRP).
- ✓ Wash primers.
- ✓ 2-pack polyester putties, polyester spraying fillers.
- ✓ 2-pack acryl fillers.
- ✓ 2-pack epoxy fillers.
- ✓ Old finishes in good condition.

Good Surface preparation is necessary to achieve the best results.

#### APPLICATION PROCESS

	<b>USE</b> For car body repairs.												
	<table border="0"> <tr> <td><b>Mixing ratio</b></td><td><b>by volume</b></td></tr> <tr> <td>Primer</td><td>3 parts</td></tr> <tr> <td>Hardener</td><td>1 part</td></tr> <tr> <td>Thinner</td><td>35% for wet-on-wet application</td></tr> <tr> <td></td><td>20% for sanding</td></tr> <tr> <td colspan="2">Stir well</td></tr> </table>	<b>Mixing ratio</b>	<b>by volume</b>	Primer	3 parts	Hardener	1 part	Thinner	35% for wet-on-wet application		20% for sanding	Stir well	
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Primer	3 parts												
Hardener	1 part												
Thinner	35% for wet-on-wet application												
	20% for sanding												
Stir well													
	<b>Spraying viscosity</b> 17÷19 seconds at 20°C with 35% of thinner. Approx. 30 seconds at 20°C with 20% of thinner.												
	<b>Pot life</b> approx. 40 minutes at 20°C.												
	<b>Number of layers</b> 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. <b>Gun Parameters</b> Nozzle: 1,4÷1,7 mm . Pressure: according to the gun's producer recommendations, usually 2÷2,5 bar. Gravity: 1,2÷1,5 mm,												

	<p><b>Evaporation time</b>  Between layers: approx. 5÷10 minutes  Before coating with solvent based system: approx. 20 minutes  Before coating with water based system: approx. 30 minutes</p> <p>Evaporation time depends on the temperature and layer thickness.</p>
	<p><b>Hardening time at 20°C:</b>  Isolation primer /30÷50 µm/ready to sand after 2÷3 h.  <b>Hardening time at 60°C:</b>  Isolation primer /30÷50 µm/ ready to sand after 15÷20 minutes of baking in the booth and after the surface has cooled down (about 1h).</p> <p>Temperatures below 20°C significantly decrease the hardening time</p>
	<p><b>IR Drying</b>  Isolation primer /30-50 µm/: 5÷7 minutes under short wave.  Primer for sending /50-100 µm/: 8÷10 minutes under short wave.  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.</p>
	<p><b>Dry Sanding</b>  By machine P360÷P500.  By hand: P320÷P500.</p> <p>Wet-on-wet application of this primer does not require sanding!</p>
	<p><b>Wet Sanding</b>  By hand: P800÷P1000.</p> <p>Wet-on-wet application of this primer does not require sanding!</p>

**Component quantity by weigh while adding 20% of thinner by volume :**

Mixture amount [ml]	Primer [g]	Hardener [g]	Thinner [g]
100	89	20	15
150	133	30	22
200	178	40	30
300	266	61	45
400	355	81	59
500	444	101	74
1000	888	202	148
1500	1331	303	223
2000	1775	404	297

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**Component quantity by weigh while adding 35% of thinner by volume :**

Mixture quantity [ml]	Primer [g]	Hardener [g]	Thinner [g]
100	79	18	23
150	118	27	35
200	158	36	46
300	237	54	69
400	316	72	92
500	394	90	115
1000	789	180	231
1500	1183	269	346
2000	1578	359	461

**FURTHER WORKS**

2K acryl fillers can be directly over coated with:

- ✓ 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 Cathode Primer 3:1 - 12 months from the date of Manufacture.  
Hardener 1:3 for Cathode Primer – 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.

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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.

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Ząbrowo, Poland.