

Product Data

408 Epotec Primer Surfacer

PRODUCTS

Epotec Primer Surfacer	408-Pack "A"
Epotec Primer Hardener	414-9105 Pack "B"
Thinners	R202-Normal conditions, R270-Hot conditions

Product Description

A polyamide cured epoxy primer surfacer, for use on metal, wood, masonry and fibreglass.

Available Colours

- 408-1011 Grey Green
- 408-5169 Ceramic Beige
- 408-6063 Grey
- 408-7218 Black
- 408-8008 White

Resistance Properties

- **Abrasion:** Excellent
- **Heat Resistance:** Good
- **Durability:** Excellent when topcoated
- **Chemical:** Excellent
- **Solvent:** Excellent

Preparation of Substrates



Ensure that all surfaces to be coated are clean and dry and free from all traces of oil and grease.



- **Steel:** (a) **Structural steel:** Abrasive blast clean to AS 1627.4 Class 2.5, apply primer within ½ hour of blasting.
(b) **New steel sheet:** Treat new steel sheet with 971 metal Conditioner
 - Do not allow the solution to dry, but wipe off with clean cloths.
 - Rinse well with water to remove excess acid then wipe dry with clean cloths. Apply primer immediately after preparation of the clean surface.
- **Aluminium:** Bare aluminium surfaces should be thoroughly cleaned using R123 Wax and Grease remover before sanding, if necessary use a high grade scouring pad to remove heavy areas of grease and imperfections, all this is to be done in a wipe on wipe off motion using clean rags.

Once dry, thoroughly abrade the surface using P240 grit on an orbital sander or by hand rubbing using P320.

Once sanded the aluminium should be thoroughly blown down then cleaned with a 1:1 solution mix of R207 Methylated Spirits and clean water, using a wipe on wipe off action this must be repeated until no residue shows on the cleaning cloths.

*NOTE: The prepared aluminium must be primed within 6 hours after the preparation process; failure to do this will allow the aluminium to re-oxidise.

- **Galvanised & Zinc coated Steel:** Remove all surface contamination such as oil, grease or dirt by thoroughly washing the surface with Protec R123 Wax and Grease Remover.

Sand the surface by mechanical means using P80 grit – P120 grit sand paper, then thoroughly blow down and clean the surface once again using Protec R123 Wax and Grease remover.

- **Stainless Steel:** (a) Degrease with R123 Wax and Grease Remover and wipe dry with clean cloths before dry.
 - Abrade the surface using P240 grit on a orbital sander or by hand rubbing using P320 grit.
 - Clean the surface again using R123 Wax and Grease remover

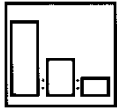
OR

 - (b) Abrasive blast clean to AS 1627.4 class 2.5
 - Surface must be primed within 4 hours of blasting.

	<ul style="list-style-type: none"> • Masonry, Brick & Concrete: Brush down to remove all dust and powdered materials by wire or power brush. <ul style="list-style-type: none"> ➤ Chemically neutralize the surface if efflorescence is present. • Timber: Ensure surface is clean and dry and sanded to a smooth finish.
	<ul style="list-style-type: none"> • Fibreglass, (GRP): Wash surface thoroughly using a mixture of warm water and detergent to remove waterborne release agents. <ul style="list-style-type: none"> ➤ Rinse with clean water and wipe dry ➤ Lightly dry sand entire surface with P320 grit paper ➤ Blow down then thoroughly clean the surface with R123 Wax and Grease remover, working in small areas then thoroughly wiping each section completely dry with clean cloths. • Previously painted surfaces: Remove all loose and flaking paint, rust etc. with power/hand tool combination. <ul style="list-style-type: none"> ➤ Spot prime all bare steel areas ➤ Before proceeding with the coating of any previously painted surface, a test patch should be done. Providing there has been no “frying” or other film defect, proceed as above. ➤ If any “lifting” or frying is evident, strip back to bare metal with 186 Superstrip Paint Remover. <p>Please note: Substrate other than those stated should be tested before use, to ensure that the performance of the product is suitable for the intended use.</p>
	<p>Cleaning: Before and after any sanding operation, the substrate must be thoroughly degreased with Protec R123 wax & grease remover to remove all traces of dirt, oil, grease, silicone, wax etc.</p>

Application Guide:

Mixing ratio:



By volume:

Epotec Primer Surfacer	4 Parts
414-9105 Hardener	1 Part
Reducer	Up to 20%

Spraygun Setup:



Suction

Conventional

1.8 – 2.0 mm

Spray Pressure:

45-65 psi
350 - 450 kPa

Application:



2-3 full, even coats allowing flash-off between coats.

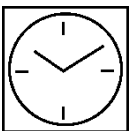
***NOTE:** Do not apply when temperature is either below 10°C or within 3 degrees above the dew point or relative humidity exceeds 85%.

Flash Off Time:



10-15 minutes between coats @ 25 °C.
(dependant of film build)

Drying Times:



Air Dry Only:

Drying of Epotec Primer surfacer is very dependent on temperature and humidity and it will not cure at temperatures below 5°C, or within 3°C of the dew point.

Touch Dry 1-2 Hours

Hard dry overnight under normal conditions

Recoat:



- After overnight under normal conditions
- Sand surface well with P320/P360 grit paper
- Approximate re-coat times
 - At 30°C min 10 hours – max 24 hours
 - At 20°C min 20 hours – max 48 hours
 - At 10°C min 30 hours – max 60 hours

Performance Guidelines

- Drying times will vary dependent on temperature, flash off between coats, number of coats used.
- Is suitable for brush application in small areas.
- 39-49% Volume solids (Depending on Colour)
- Pot life of mixed material is 10 hours under normal conditions. Do not return unused mixed material to the can.
- Approximately 11 square metres per litre at 40 microns dry film thickness.

Health and Safety

Please refer to Material Health and Safety Datasheets for full health and safety details.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



PROTEC PTY LTD
97-105 Bedford Street
Gillman SA Australia 5013
Tel: 08 8447 6311
Fax: 08 8447 6692

PROTEC NZ LIMITED
327b Neilson Street, Penrose
Auckland New Zealand
Tel: 0011 64 9 634 6718
Fax: 0011 64 9 634 8203

