



408 EPOTEC PRIMER SURFACER

PRODUCT DESCRIPTION

408 Epotec Primer Surfacers is a polyamide cured epoxy primer surfacer, suitable for use on metal, wood, masonry and fibreglass. It is available in Grey Green, Black, White and Cat Yellow.

PRODUCTS

PRIMER SURFACERS

408-1011 Epotec Primer Grey Green

408-7218 Epotec Primer Black

408-8008 Epotec Primer White

408-2620 Epotec Primer Cat Yellow

HARDENERS

414-9105 Epotec Primer Hardener

REDUCERS

Normal conditions

EXR20 Epoxy Reducer Normal

Hot conditions

EXR30 Epoxy Reducer Slow

Very hot conditions or large equipment

EXR40 Epoxy Reducer Extra Slow

CLEANER

AA-6822 *Protec* Heavy Duty Degreaser

SUBSTRATES & PREPARATION



408 Epotec Primer Surfacers can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE

PREPARATION

Structural Steel

Abrasive blast clean to AS 1627.4 Class 2.5.

Apply primer within ½ hour of blasting.



New Steel Sheet

Treat with 971-9119 *Protec* 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.

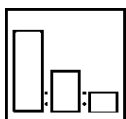
Galvanised & Zinc Coated Steel

Remove all surface contamination such as oil, grease or dirt by using AA-6822 *Protec* Heavy Duty Degreaser.

Sand the surface by mechanical means using *Startline* P80 - P120 grit sand paper, then thoroughly blow down and clean the surface once again using AA-6822.

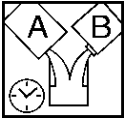
Aluminium	<p>Thoroughly clean using AA-6822 <i>Protec</i> Heavy Duty Degreaser and, if necessary, using a high grade scouring pad to remove heavy areas of grease and imperfections - all of this is to be done in a wipe on wipe off motion using clean rags.</p> <p>Once dry, thoroughly abrade the surface using STARTLINE® P240 grit on an orbital sander or by hand rubbing using <i>Startline</i> P320 grit.</p> <p>Once sanded, thoroughly blow down the surface then clean with a 1:1 mix of 207 <i>Protec</i> Methylated Spirits and clean water, using a wipe on wipe off action - this must be repeated until no residue shows on the cleaning cloths.</p> <p><i>Apply primer within 6 hours of this preparation process; failure to do this will allow the aluminium to re-oxidise and the cleaning will have to be repeated.</i></p>
Stainless Steel	<p>(a) Abrasive blast clean to AS 1627.4 class 2.5. <i>Apply primer within 4 hours of blasting.</i></p> <p>or (b) Degrease with AA-6822 <i>Protec</i> Heavy Duty Degreaser and wipe dry with clean cloths.</p> <p>Abrade the surface using <i>Startline</i> P240 grit on an orbital sander or by hand rubbing using <i>Startline</i> P320 grit.</p> <p>Clean the surface again using AA-6822.</p>
Masonry, Brick & Concrete	<p>Brush down to remove all dust and powdered materials by wire or power brush.</p> <p>Chemically neutralise the surface if efflorescence is present.</p>
Fibreglass (GRP)	<p>Wash surface thoroughly using a mixture of warm water and detergent to remove waterborne release agents, then rinse with clean water and wipe dry.</p> <p>Lightly dry sand entire surface with <i>Startline</i> P320 grit sand paper then blow down. Thoroughly clean the surface with AA-6822 <i>Protec</i> Heavy Duty Degreaser, working in small areas then thoroughly wiping each section completely dry with clean cloths.</p>
Previously Painted Surfaces	<p>Remove all loose and flaking paint, rust etc. with power/hand tool combination, then spot prime all bare steel areas</p> <p>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.</p> <p>If any “lifting” or frying is evident, strip back to bare metal with 186-9102 <i>Protec</i> Superstrip Paint Remover.</p>
<p>Surfaces showing heavy scale or surface rust should be treated with 971-9119 <i>Protec</i> Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.</p> <p>Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 <i>Protec</i> Heavy Duty Degreaser to remove all traces of dirt, oil, grease, silicone, wax etc.</p> <p><i>Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for it's intended use.</i></p>	

MIXING RATIO BY VOLUME



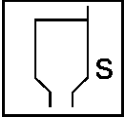
PRODUCT	PARTS
408 Epotec Primer Surfacer	4
414-9105	1
EXR Epoxy Reducers	0 - 20%

POTLIFE



Catalysed material is useable for up to 10 hours at 25°C

SPRAY VISCOSITY



CONVENTIONAL, HVLP 18 - 25 seconds (DIN 4) at 25°C

AIRLESS, AIR ASSISTED AIRLESS 25 - 32 seconds (DIN 4) at 25°C

SPRAYGUN



CONVENTIONAL, HVLP

SETUP

- GRAVITY / SUCTION 1.8 mm - 2.0 mm

SPRAY PRESSURE

- CONVENTIONAL 3.0 - 4.0 bar (300 - 400 kPa, 45 - 60 psi)

- HVLP / RP 2 - 3 bar



AIRLESS, AIR ASSISTED AIRLESS

SETUP

- TIP 0.007 - 0.015

- PUMP RATIO 32:1

SPRAY PRESSURE

- AIRLESS 100 - 140 bar

- AIR ASSISTED AIRLESS 70 - 100 bar

APPLICATION & FLASH OFF



CONVENTIONAL, HVLP 2 - 3 wet, even coats

AIRLESS, AIR ASSISTED AIRLESS 1 - 2 wet, even coats

Allow 10-15 minutes flash off between coats at 25°C

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 80%, or if the surface temperature is within 3°C of the dew point.

DRYING TIMES



AIR DRY (25°C) TOUCH DRY 1 - 2 hours

HARD DRY 16 hours

Note: Drying of 408 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.

RECOAT



Can be recoated after overnight under normal conditions, sand surface well with Startline P320 - P360 Grit Sandpaper.

TOTAL DRY FILM BUILD

40 - 50 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	36 - 41%, depending on colour
COVERAGE	7.2 - 10.1 metres squared per litre (m ² /L)
RESISTANCE PROPERTIES	
WEATHERING	Excellent when topcoated
ABRASION	Excellent
SOLVENT	Excellent to splash and spillage for common solvents
CHEMICAL	Excellent to splash and spillage for mild chemicals
HEAT	Satisfactory up to 105°C Dry Heat
IMMERSION	Good when suitably topcoated

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

Hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS 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 or her 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 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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