



## EPO EPOTEC PRIMER SURFACER

### PRODUCT DESCRIPTION

EPO Epotec Primer Surfacer is a polyamide cured two-component epoxy primer surfacer, suitable for use on metal, wood, masonry and fibreglass.

### PRODUCTS

#### PRIMER SURFACERS

EPO-N61 Black  
EPO-G55 Grey Green  
EPO-N14 White

#### HARDENERS

414-9105 Epotec Primer Hardener OR  
EPH 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

*Very hot conditions or Extra large equipment*

EXR50 Epoxy Reducer Ultra Slow

#### CLEANER

AA-6822 *Protec* Heavy Duty Degreaser

### SUBSTRATES & PREPARATION



EPO Epotec Primer Surfacer 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

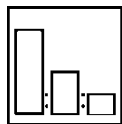
Treat with 971-9119 *Protec* Metal Conditioner. Do not allow the solution to dry, but wipe off with clean cloths. Rinse well with water to remove excess acid then wipe dry with clean cloths.  
*Apply primer immediately after preparation of the clean surface.*

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.

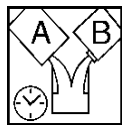
Aluminium	<p>Thoroughly clean using AA-6822 <i>Protec</i> Heavy Duty Degreaser and, if necessary, using a high grade scouring pad to remove heavy areas of grease and imperfections - all of this is to be done in a wipe on wipe off motion using clean rags.</p> <p>Once dry, thoroughly abrade the surface 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; <b>failure to do this will allow the aluminium to re-oxidise and the cleaning will have to be repeated.</b></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



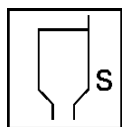
PRODUCT	PARTS
EPO Epotec Primer Surfacer	4
EPH Epotec Primer Hardener	1
EXR Epoxy Reducers	0 - 20%

### POTLIFE



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

### SPRAY VISCOSITY



<i>CONVENTIONAL, HVLP</i>	18 - 25 seconds (DIN 4) at 25°C
<i>AIRLESS, AIR ASSISTED AIRLESS</i>	25 - 32 seconds (DIN 4) at 25°C

### SPRAYGUN



#### CONVENTIONAL, HVLP

##### SETUP

- *GRAVITY / SUCTION* 1.8 mm - 2.0 mm

##### SPRAY PRESSURE

- *CONVENTIONAL* 2.0 - 2.5 bar (200 - 300 kPa, 30 - 36 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



<i>CONVENTIONAL, HVLP</i>	2 - 3 wet, even coats
<i>AIRLESS, AIR ASSISTED AIRLESS</i>	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



Must be recoated after overnight cure under normal conditions, sand surface well with Startline P320 - P360 Grit Sandpaper, do NOT use this primer as a Wet on Wet. Recommendations are based on 25°C ambient temperature.

## 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<sup>2</sup>/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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Clayton, VIC 3168 Australia**

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**Protec Pty Ltd. 5 Monahan Rd, Mt Wellington  
Auckland, New Zealand**

**EMERGENCY RESPONSE NUMBER, New Zealand: 0800 000 096**

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*Startline* is a registered trademark of PPG Industries Australia Pty Ltd.