


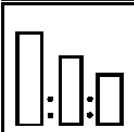


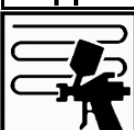
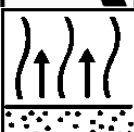




Primer Surfacer EP

FOR PROFESSIONAL USE ONLY

Quick reference

| | |
|---|--|
|  | Sikkens Solvent-M600 |
|  | P220-P320 |
|  | P600 |
|  | 100:50:30 Primer Surfacer EP Hardener EP Plus Reducer |
|  | 1 |
|  | 20-21 |
|  | (gravity feed) 2-3*1 1.2-1.5 mm 3-5 bar HVLV (gravity feed) 1.7-1.9 mm max 0.7 bar |
|  | 5-10 mins. |
|  | 30-45 min. 20°C |
|  | See T.D.S. 7.9 |

Description:

Quickdrying, two-pack, chromate-free epoxy primer-surfacer for vehicles, chassis, etc. Developed for new work and repairs. Gives good chemical resistance and rust-inhibition.

Product and Additives:

Primer Surfacer EP
Primer Surfacer EP Hardener
Plus Reducer

Basic Raw Materials:

Base paint: Epoxy resins
Hardener: Amine resin

Suitable Substrates:

- Existing finishes, with the exception of soft (thermoplastic acrylic) finishes
- Aluminum surfaces
- Steel surfaces
- Stainless steel surfaces
- Zinc-coated steel surfaces
- Zinc surfaces
- Polyester laminates
- Wood or plywood
- Sikkens polyester putties and Polysurfacer

Surface Preparation:

- Existing finishes: Degrease and dry sand with P320-grit (3M 255P Gold) or with P600 grit wet (3M 734 Black)
- Aluminum and stainless steel surfaces: Degrease, scuff with Scotch Brite Type A and degrease again.
 - Steel, zinc-coated steel, zinc and polyester: Degrease and dry sand with P220 grit (3M 255P Gold); if necessary, blast-clean steel surfaces as well.
 - Wood or plywood: Dry sand with P220-grit (3M 255P Gold) to achieve a smooth surface and no loose fibers are left on the surface.
 - Sikkens Polyester putties and Polysurfacer: Dry sand dry with P220-P320-grit (3M 255P Gold).

Note: Do not apply this product to substrates which have been pretreated with a chemical cleaner.

Sikkens representative should be contacted for suitability on aluminum. Due to the many different kinds of aluminum it is not possible to guarantee them all as a suitable substrate.

Tinting:

If necessary, Primer Surfacer EP can be tinted with up to 2½% parts by weight Autocryl Plus mixing color (without hardener).



Primer Surfacer EP

FOR PROFESSIONAL USE ONLY

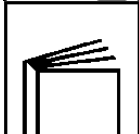


Sikkens polyester putties

All Sikkens primers / fillers
Autocryl Plus
Autobase Plus
Autowave



2.4.3



Mixing Ratio by volume:

100 parts of Primer Surfacer EP
50 parts of Hardener EP
30 parts of Plus Reducer
Use mixingstick No 1

Spraying Viscosity:

20-21 secs DIN Cup 4 at 20°C.

Potlife:

8 hours at 20°C.

Spray gun fluid tip and working pressure:

| | | |
|--------------------|--------------------------|-----------------------------|
| Spray Gun: | Fluid Tip: | Working Pressure: |
| Gravity feed: | 1.2-1.5 mm | 3-5 bar |
| Syphon feed: | 1.4-1.8 mm | 3-5 bar |
| HVLP gravity feed: | 1.7-1.9 mm | max. 0.7 bar at the air-cap |
| HVLP suction feed: | 1.8-2.2 mm | max. 0.7 bar at the air-cap |
| Pressure pot: | 1.1-1.2 mm | 4-6 bar |
| Airless spray: | 0.011"/65° 0.013"/80° | 140-160 bar |

Also suitable for ES spray application.

Application Process:

Apply 2-3 single coats, allowing a flash-off time of 5 to 10 minutes between coats.
If applied by brush, do not add any thinner.

Apply only **one** coat of Primer Surfacer EP 20-25 µm if next a Sikkens polyester putty or Polysurfacer will be applied!

Sikkens polyester putty or Polysurfacer can be applied after 45 minutes.

Film Thickness:

Approx. 20µm for each single wet coat.

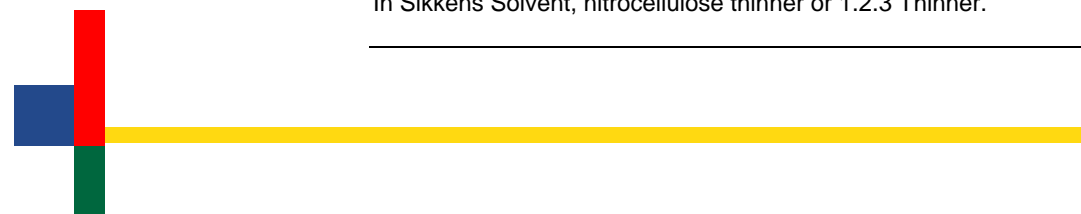
Material usage:

Taking into account a transfer efficiency of 70%, the theoretical material usage for one layer is 11 m²/l ready to spray mixture which calculates to 20 m²/l unthinned paint at 20µm.

Note: The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application method and application circumstances.

Cleaning of Equipment:

In Sikkens Solvent, nitrocellulose thinner or 1.2.3 Thinner.



Primer Surfacer EP

FOR PROFESSIONAL USE ONLY

Drying times:

| At 40 µm: | 10°C: | 20°C: | 40°C: | 60°C: |
|------------------------------------|---------|---------|---------|---------|
| Dust-dry: | 60 mins | 15 mins | 10 mins | 5 mins |
| Tack-free: | 2 hrs | 30 mins | 30 mins | 10 mins |
| Hard dry: | 8 hrs | 5 hrs | 2 hrs | 60 mins |
| Recoatable with putties after: | 2 hrs | 45 mins | 30 mins | 15 mins |
| Recoatable With topcoats after: | 30 mins | 15 mins | 10 mins | 10 mins |

Note: Can also be dried with I.R.(see t.i.s. 7.9).

Recommended Sandpaper grades:

See relevant topcoat information.

If sanded wet allow 30 minutes at 20°C drying time before topcoat application.

Recoatable with (Recoatability):

All current Sikkens preparatory products.

The following topcoats: Autocryl PLUS, Autobase Plus.

Note: If a drying time of 48 hours at 20°C. is exceeded, Primer Surfacer EP must be flatted prior to be recoated with a finish.

VOC:

Theoretical VOC: 600 g/l ready to spray mixture.

Shelflife:

Primer Surfacer EP: 2 years

Hardener EP: 1 year

Packaging:

1 l and 3 l cans

Color:

Light green.

HEALTH & SAFETY DATA concerning Primer Surfacer EP and additives:

For professional use only.(See **Material Safety Data Sheet**).

See text on the label of this product.

The user of this product is required to comply with the national statutory regulations for health and safety at work and waste disposal.



Primer Surfacer EP

FOR PROFESSIONAL USE ONLY

Akzo Nobel Car Refinishes

Adress: 510 Thomson Rd. #16-03 SLF Building Singapore 298135

Tel: +65-6254-8477

FOR PROFESSIONAL USE ONLY

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

Head Office

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. www.sikkenscr.com

