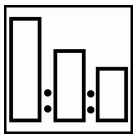
Primer Surfacer EP II

FOR PROFESSIONAL USE ONLY

Description

Two-pack, VOC compliant, chromate-free epoxy primer-surfacer with good adhesion and corrosion resistance properties on all substrates within the Car Refinish market. For both new panels and repair jobs.

Sanding application



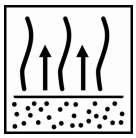
100 Primer Surfacer EP II
50 Primer Surfacer EP II Hardener
40 Autoclear LV Superior Reducer Fast/Plus Reducer

Use Sikkens measuring stick
12 Green

Spray gun set-up:
1.5-2.0 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap

1-3 x 1 coat



Between coats:
5-10 minutes at 20°C

Before curing:
5-10 minutes at 20°C

8 hours at 20°C
3 coat application

45 minutes at 60°C

Final sanding step: P220-P320
See TDS S8.06.02

Recoatable with all Sikkens primer fillers/surfacers and topcoats

Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

Read complete TDS for detailed product information

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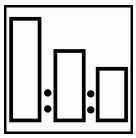
Two-pack, VOC compliant, chromate-free epoxy primer-surfacer with good adhesion and corrosion resistance properties on all substrates within the Car Refinish market. For both new panels and repair jobs.

Non sanding application



100 Primer Surfacer EP II
50 Primer Surfacer EP II Hardener
50 Autoclear LV Superior Reducer Fast / Plus Reducer

Use Sikkens measuring stick
2 Blue

Spray gun set-up:
1.3-1.6 mm

Application pressure:
1.7-2.2 bar at the air inlet
HVLP max 0.6-0.7 bar at the air cap

1 coat

45 minutes at 20°C

15 minutes at 60°C

Recoat within 48 hours at 20°C

Recoatable with all Sikkens fillers and topcoats

Use suitable respiratory protection
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator.

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Description

Two-pack, VOC compliant, chromate-free epoxy primer-surfacer with good adhesion and corrosion resistance properties on all substrates within the Car Refinish market. For both new panels and repair jobs.

Suitable substrates

Existing finishes
Steel
Zinc coated steel
Cleaned OEM electrocoat
OEM electrocoat (sanded)
Carbon Fiber
Aluminium
Glass Reinforced Polyester laminates (GRP)
Polyester bodyfillers
Polysurfacer
Wood

Primer Surfacer EP II will provide adequate adhesion and corrosion protection on steel, zinc coated steel *and aluminum. Do **not** apply this product to substrates which have been pretreated with a chemical cleaner. Due to the many different kinds of aluminum it is not possible to guarantee all types as suitable substrate.*

Direct applicable on non-sanded, thoroughly cleaned and degreased rigid OEM electro-coated parts

*Do **not** apply apply Primer Surfacer EPII directly over Sikkens Washprimer.*

Primer Surfacer EPII should only be applied on hard plastic substrates which have been preceded by 1K All Plastic Primer or 2K Plastic Primer

Product and additives

Primer Surfacer EP II

Hardeners Primer Surfacer EP II Hardener

Plus Reducers	Plus Reducer Fast:	spot and panel repairs, temperature range: 15°C-25°C
	Plus Reducer Medium:	spot and panel repairs and large areas, temperature range: 20°C-30°C
	Plus Reducer Slow:	larger areas and complete paint jobs, temperature range: 25°C-35°C
	Plus Reducer Extra Slow:	temperature range: above 35°C

Reducer Autoclear LV Superior Reducer Fast

Basic raw materials

Primer Surfacer EP II:	Epoxy resins
Primer Surfacer EP II Hardener:	Amine resin

Primer Surfacer EP II

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Surface preparation

Remove contamination using an appropriate cleaner

Final sanding step P220 - P320
For detailed surface preparation see TDS S8.06.02

Remove contamination using an appropriate cleaner.
Where bodyfiller or Polysurfacer is exposed, avoid contact with water (e.g. waterborne degreaser).

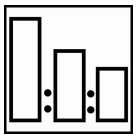
Stir before use

Stir Primer Surfacer EPII thoroughly before use.

Tinting

Primer Surfacer EPI can be tinted with up to 5 parts by volume of Autocryl, Autocryl Plus or Autocryl Plus LV MM toners.

Mixing



Sanding
100 Primer Surfacer EPII
50 Primer Surfacer EPII Hardener
40 Autoclear LV Superior Reducer Fast
Use measuring stick 12

100 Primer Surfacer EPII
50 Primer Surfacer EPII Hardener
40 Plus Reducers
Use measuring stick 12

Non sanding VOC compliant
100 Primer Surfacer EPII
50 Primer Surfacer EPII Hardener
50 Autoclear LV Superior Reducer Fast
Use measuring stick 2

Non sanding non compliant
100 Primer Surfacer EPII
50 Primer Surfacer EPII Hardener
50 Plus Reducers
Use measuring stick 2

Spray gun set-up / application pressure

Spray gun	Fluid tip-set-up	Application pressure
Sanding		
Gravity feed	1.5-2.0 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap
Non Sanding		
Gravity feed	1.3-1.6 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

Primer Surfacer EP II

FOR PROFESSIONAL USE ONLY

Pot-life

Sanding:	4 hours at 20°C
Non sanding:	6 hours at 20°C

Application

Sanding
Spot application:
Apply one coat over the total sanded area. Flash off until completely matt and apply the 2nd and 3rd coat within each preceding coat. Flash off until completely matt after each coat.

Panel application:
Apply 2-3 coats and flash off until completely matt after each coat.

Non sanding
Apply 1 full wet coat.

When applied by brush, mix Primer Surfacer EP II only with Primer Surfacer EP II Hardener.

Drying time sanding

8 hours at 20°C 2 hours at 40°C 45 minutes at 60°C

Drying times relate to recommended application (3 coats) and object temperature.

Allow 5 minutes flash off prior to infra red curing
The panel temperature should not exceed 100°C.
For additional information, see TDS S9.01.01

Drying time non sanding

45 minutes at 70°C (20°C). 15 minutes at 140°F (60°C).

Recoat with 48 hours at 70°C (20°C).

Drying times relate to recommended application (1 coat) and object temperature.

Primer Surfacer EP II

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Drying time in case of polyester bodyfiller application

16 hours at 20°C

Drying time relates to recommended application of maximum 1 coat (25 µm)

5 minutes low power — 10 minutes high power

Allow 5 minutes flash off prior to infra red curing
The panel temperature should not exceed 100°C.

Polyester bodyfiller application

Remove contamination using an appropriate cleaner.
Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Recoatable with

All Sikkens fillers and topcoats

Film thickness

		µm
Sanding	Per coat	30-35
	Per 3 coats	90-105
Non Sanding	Per coat	25-30

Theoretical Coverage

		m²/liter
Sanding:	Ready for use mixture at 1 µm dry film thickness	± 388
Non sanding:	Ready for use mixture at 1 µm dry film thickness	± 370

Cleaning of equipment

Sikkens Solvent or solvent borne Guncleaners

VOC

2004/42/IIb(c)(540)540
The EU limit value for this product (product category: IIB. c) in ready to use form is max. 540 g/liter of VOC.
The VOC content of this product in ready to use form is max. 540 g/liter.

Product storage

Product shelf-life is determined when products are stored unopened at 70°F (20°C).
Avoid extreme temperature fluctuation.

- *Product shelf life data see TDS S9.01.02*

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FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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