

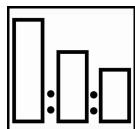
Primer Surfacer EP II

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



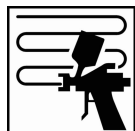
Use Sikkens measuring stick

12 Green

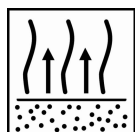


Spray gun set-up:
1.5-2.0 mm

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

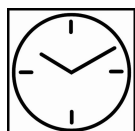


1-3 x 1 coat



Between coats:
5-10 minutes at 20°C

Before curing:
5-10 minutes at 20°C

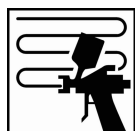


8 hours at 20°C
3 coat application

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

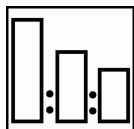
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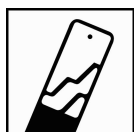
Description

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.

Non sanding application



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



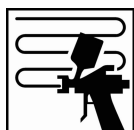
Use Sikkens measuring stick

2 Blue

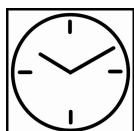


Spray gun set-up:
1.3-1.6 mm

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



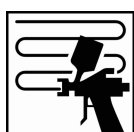
1 coat



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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Primer Surfacer EP II

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

*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 Primer Surfacer EP II directly over Sikkens Washprimer.*

Primer Surfacer EP II 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

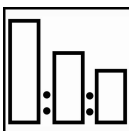


Stir Primer Surfacer EPII thoroughly before use.

Tinting

Primer Surfacer EPII 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

Non sanding VOC compliant

100 Primer Surfacer EPII
50 Primer Surfacer EPII Hardener
50 Autoclear LV Superior Reducer Fast
Use measuring stick 2

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

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 Sanding

Gravity feed

Fluid tip-set-up

1.5-2.0 mm

Application pressure

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

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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.

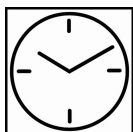
Non sanding

Apply 1 full wet coat.



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

Drying time sanding



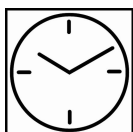
8 hours at 20°C 2 hours at 40°C 45 minutes at 60°C

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).

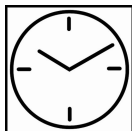
Recoat with 48 hours at 70°C (20°C).

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

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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

		m ² /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

Primer Surfacer EP II

FOR PROFESSIONAL USE ONLY

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Tel: +31(0)71308-6944

FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT

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.

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