

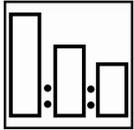
Primer Surfacer EP II

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



Use Sikkens measuring stick
No. 12 Green



Spray gun set-up:
1.5-2.0 mm

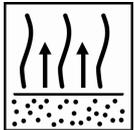
Application pressure:

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: P180-P280
See TDS S8.06.01



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.

Primer Surfacer EP II

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Read complete TDS for detailed product information



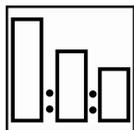
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Two-pack, VOC compliant, chromate-free epoxy primer-surfacer with good adhesion and corrosion resistance properties on all substrates within the Car Refinish market. For both new panels and repair jobs.

Non sanding application



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



Use Sikkens measuring stick
No. 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
Maximum layer thickness $\pm 25 \mu\text{m}$



30 minutes at 20°C

10 minutes at 60°C



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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.

Suitable substrates

Existing finishes
Steel
Zinc coated steel
OEM electro coat

Aluminum
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 EP II directly over Sikkens Washprimer.*

Primer Surfacer EP II should only be applied on hard plastic substrates which have been preceded by; Plastoflex Primer, 2K Plastic Primer.

*Do **not** apply to thermo plastics i.e.deformable with heat.*

Product and additives

Primer Surfacer EPII

Hardeners Primer Surfacer EPII Hardener

Reducer Autoclear LV Superior Reducer Fast

Basic raw materials

Primer Surfacer EPII: Epoxy resins
Primer Surfacer EPII Hardener: Amine resin



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Surface preparation



Surface cleaning, remove any surface contamination prior to sanding using an appropriate surface cleaner. *Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.*



Sanding; final dry sanding steps existing finishes; P180 – P280
Sanding; final dry sanding steps on steel; P80 – P180
Sikkens polyester bodyfillers and Polysurfacer; finished with; P180 – P280
For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Primer Surfacer EP II using appropriate surface cleaner. *Where bodyfiller or Polysurfacer is exposed, avoid contact with water (e.g. waterborne degreaser).*

Stir before use



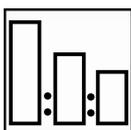
Stir Primer Surfacer EP II thoroughly before mixing.

Mixing Primer Surfacer EP II

If necessary, Primer Surfacer EP II can be tinted with up to 5 parts by volume with; Autocryl Plus LV MM toners.

Primer Surfacer EP II mixed with any of the topcoat MM colours must be stirred thoroughly before adding the Primer Surfacer EP II Hardener.

Mixing



Sanding

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

Wet-on-wet (non sanding)

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

Spray gun set-up / application pressure



Spray gun

Sanding

Gravity feed

Fluid tip-set-up

1.5-2.0 mm

Application pressure

28-30 psi (1.7-2.2 bar) at the spray gun air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

Non Sanding

Gravity feed

1.3-1.6 mm

28-30 psi (1.7-2.2 bar) at the spray gun air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

For maximum build use a large fluid tip and lower application pressure.

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 application:

Apply one coat over the total sanded area. Next apply the 2nd and 3rd coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.

Allow each coat to flash off naturally until the surface is completely matt, this also supports to achieve higher film build.. Do not force-dry by air support. Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow.

For maximum build use a large fluid tip and lower application pressure.

Non sanding application:

Apply one full coat



If Primer Surfacer EP II will be applied by brush, mix the Primer Surfacer EP II only with Primer Surfacer EP II Hardener, do not add Reducer.

Film thickness

By using the recommended application;

Sanding, 3 coats: 90-105 µm

Non sanding, 1 coat: 30-35 µm

If any putty/bodyfiller or Polysurfacer is to be applied, apply over 1 coat of Primer Surfacer EP II with an maximum layer thickness of approximately 25 µm.

Drying time sanding



16 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 must not reach a temperature above 100°C while curing.

For additional infra red drying information; see TDS S9.01.01



Final sanding step in case of any primer filler/surfacer application; P320

- Initial sanding steps may be executed with a coarser sanding grit; P220
- Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.
- For detailed surface preparation see TDS S8.06.02

Primer Surfacer EP II

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Drying time non sanding



30 minutes at 20°C

10 minutes at 60°C

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

Drying time in case of polyester bodyfiller application



16 hours at 20°C

Drying times relate to recommended application of maximum 1 coat (25 µm) Primer Surfacer EP.



5 minutes low power

10 minutes high power

Allow 5 minutes flash off prior to infra red curing
The panel must not reach a temperature above 100°C while curing.
For additional infra red drying information; see TDS S9.01.01



Polyester bodyfiller application

Abrade the Primer Surfacer EPII surface after curing with minimum P220 for optimum adhesion.

Polysurfacer; follow similar procedure as with polyester bodyfiller.

See putty/polyester bodyfiller/Polysurfacer TDS documents for product application and sanding procedures.



Surface cleaning; remove any surface contamination prior to the application of any primer filler/surfacer using an appropriate surface cleaner. *Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).*

Recoatable with

Primer Surfacer EPII is recoatable with all Sikkens primers fillers/surfacers and topcoats.

Material usage

By using the recommended application the theoretical material usage is:

- Sanding (90 µm): +/- 4.5 m²/liter
- Non sanding (30 µm): +/- 13.5 m²/liter

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

Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

VOC

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

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The VOC content of this product in ready to use form is max. 535 g/liter

Product storage

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

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

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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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