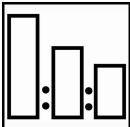


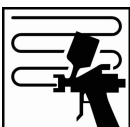
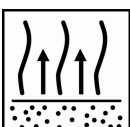
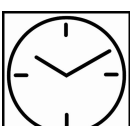

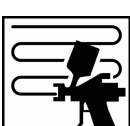



Primer Surfacer EP II

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 Reducers	
	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
	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-P320 See TDS S8.06.02	
	Recoat 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

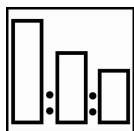
Primer Surfacer EP II

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.

Non Sanding application



100 Primer Surfacer EPII
50 Primer Surfacer EPII Hardener
50 Autoclear LV Superior Reducer Fast



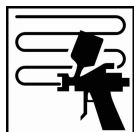
Use Sikkens measuring stick

2 Blue

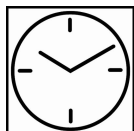


Spray gun set-up:
1.3-1.6 mm

Application pressure:
1.7-2.2 bar at the air inlet



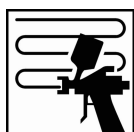
1 coat



45 minutes at 20°C

15 minutes at 60°C

Recoat within 48 hours at 20°C



Recoatable with all Sikkens primer fillers 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

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.

Suitable substrates

Existing finishes	Aluminium
Steel	Glass Reinforced Polyester laminates (GRP)
Zinc coated steel	Polyester bodyfillers
Direct application on a cleaned OEM Electrocoat	Polysurfacer
Sanded OEM electrocoat	Wood
Carbon Fibre	

*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; 1K All Plastic Primer, 2K Plastic Primer

Product and additives

Primer Surfacer EP II

Hardeners Primer Surfacer EP II Hardener

Plus (Sanding version only)

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

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

FOR PROFESSIONAL USE ONLY

Surface preparation



Remove contamination using an appropriate cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Final dry sanding steps P180 – 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



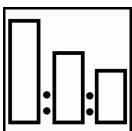
Stir Primer Surfacer EP II thoroughly before use.

Tinting

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 / Plus Reducers
Use measuring stick 12

Non Sanding VOC compliant

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

Use measuring stick 2

Primer Surfacer EP II

FOR PROFESSIONAL USE ONLY

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 ba) at the spray gun air inlet

Non Sanding

Gravity feed

1.3-1.6 mm

1.7-2.2 bar at the spray gun air inlet

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

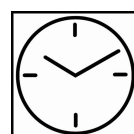
Non sanding application:

Apply one full coat.



When applied by brush, mix the Primer Surfacer EPII only with Primer Surfacer EPII Hardener.

Drying time sanding



8 hours at 20°C.

2 hours at 40°C.

45 minutes at 60°C.

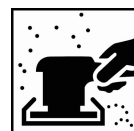
Drying times relate to recommended application (3 coats) and object temperature.



Allow 5 minutes flash off prior to infra red curing

The panel temperature should not exceed 100°C.

For additional 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; P180-P280
- For detailed surface preparation see TDS S8.06.02

Primer Surfacer EP II

FOR PROFESSIONAL USE ONLY

Drying time non sanding



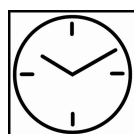
45 minutes at 20°C.

15 minutes at 60°C.

Recoat with 48 hours at 20°C.

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

Drying time in case of polyester bodyfiller application



16 hours at 20°C

Drying time relate 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
Abrade the Primer Surfacer EPII surface after curing with minimum P180 for optimum adhesion.

Polysurfacer; follow similar procedure as with polyester bodyfiller.
See product TDS documents for specific product application and sanding procedures.



Remove contamination using an appropriate cleaner.

Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).

Recoatable with

All Sikkens primers fillers & topcoats.

Film thickness

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

Primer Surfacer EP II

FOR PROFESSIONAL USE ONLY

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 Solvents 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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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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