

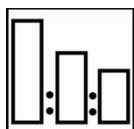
Primer Surfacer EP

FOR PROFESSIONAL USE ONLY

Description

Two-pack, 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
50 Primer Surfacer EP Hardener
30 Plus Reducers



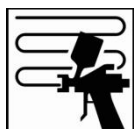
Use Sikkens measuring stick

1 Black

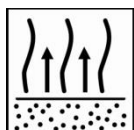


Spray gun set-up:
1.2-1.5 mm

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



2-3 x 1 coat



Between coats:
8-12 minutes at 25°C

Before curing:
8-12 minutes at 25°C



5 hours at 25°C
2-3 coat application

60 minutes at 60°C



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



Recoat with all Sikkens primer 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

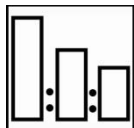
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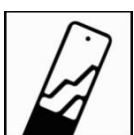
Description

Two-pack, 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
50 Primer Surfacer EP Hardener
30 Plus Reducers



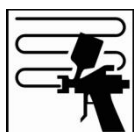
Use Sikkens measuring stick

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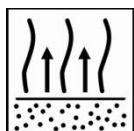


Spray gun set-up:
1.2-1.5 mm

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



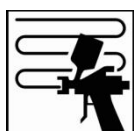
1 coat



Prior to topcoat application
20 minutes at 25°C

Prior to putty application
45 minutes at 25°C

Note: Flash-off time will need to be extended if maximum 1 coat \pm 25 μ m Primer Surfacer EP is exceeded.



Recoat with all Sikkens primer surfacers and topcoats



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Primer Surfacer EP

FOR PROFESSIONAL USE ONLY

Description

Two-pack, 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

- Steel
- Zinc coated steel
- Aluminium
- Sanded OEM Electrocoat
- Sikkens Polyester bodyfillers and Polysurfacer
- Glass Reinforced Polyester laminates (GRP)
- Wood
- Existing finishes with the exception of soft (thermoplastic, acrylic) finishes

Notes:

Primer Surfacer EP 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.

Do **not** apply Primer Surfacer EP directly over Sikkens Washprimers.

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

Do **not** use elasticizer in Primer Surfacer EP.

Product and additives

Primer Surfacer EP

Hardeners Primer Surfacer EP Hardener

Plus Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.
Reducers 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; to use in extremely hot temperatures, temperature range: above 35°C.

Basic raw materials

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

Primer Surfacer EP

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Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using Sikkens M700 or M600 surface cleaner.
Pre-clean the surface with warm water and detergent, rinse sufficiently with clean water.



Sanding; final dry sanding steps existing finishes; P220 - P320
Sanding; final dry sanding steps on steel zinc coated stell; P120 - P220
Sikkens polyester bodyfillers and Polysurfacer; finished with;P220 – P320
For detailed surface preparation see TDS S8.06.02



Surface cleaning, remove any surface contamination prior to the application of Primer Surfacer EP using Sikkens M700 or M600 surface cleaner. Where bodyfiller or Polysurfacer is exposed, avoid contact with water (e.g. waterborne degreaser).

Stir before use

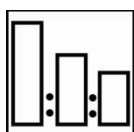


Stir Primer Surfacer EP thoroughly before mixing.

Mixing Primer Surfacer EP

- If necessary, Primer Surfacer EP can be tinted with up to 2.5 parts by volume with Autocryl Plus or Autocryl Plus LV MM toners
- Primer Surfacer EP mixed with any of the topcoat MM colors must be stirred thoroughly before adding the Primer Surfacer EP Hardener.

Mixing



100 Primer Surfacer EP
50 Primer Surfacer EP Hardener
30 Plus Reducers

Spray gun set-up / application pressure



Spray gun	Fluid tip-set-up	Application pressure
Sanding		
Gravity feed	1.2-1.5 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	1.2-1.5 mm	1.7-2.2 bar at the spray gun air inlet HVLP max 0.6-0.7 bar at the air cap

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

Primer Surfacer EP

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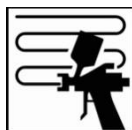
Pot-life

8 hours at 20°C.

Application

Sanding application:

Apply 2-3 single coats, allowing a flash-off time of 8 to 12 minutes between coats.



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.



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

Drying time for sanding



5 hours at 25°C. 2 hours at 40°C. 60 minutes at 60°C.
Drying times at 40 µm filmbuild



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

Drying time in case of topcoat application



Recoat with topcoats after:
20 minutes at 25°C. 10 minutes at 40°C 10 minutes at 60°C.

Dry times relate to recommended application of maximum 1 coat ± 20-25 µm Primer Surfacer EP.

Primer Surfacer EP

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Drying time in case of polyester bodyfiller application



45 minutes at 25°C.

30 minutes at 40°C.

15 minutes at 60°C.

Drying time relate to recommended application of maximum 1 coat ± 20-25 µm Primer Surfacer EP.



Short wave: 5 minutes low power 10 minutes high power

Medium wave: 5 minutes low power 12 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 EP surface after curing with minimum P220 for optimum adhesion.

Polysurfacer; follow similar procedure as with polyester bodyfiller.

See product TDS documents for specific 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 EP is recoatable with all Sikkens primers fillers/surfacers and topcoat. When the highest quality is required, it is advised to precede Sikkens topcoats with Sikkens primer fillers/surfacers.

Note: If a drying time of 8 hours at 20°C is exceeded, Primer Surfacer EP must be flatted prior to be recoated with a finish.

Film thickness

Per coat ± 25 µm

Theoretical coverage

Ready for use mixture at 20 µm dry film thickness ± 19.5 m²/liter

Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

VOC

The VOC content of this product in ready to use form is max. 541 g/liter.

Product storage

Primer Surfacer EP

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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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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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