



FAST CURE EPOXY PRIMER 940

Fast Cure Two-Pack Epoxy Primer

Data Sheet: 940
Superseded 04/00
Revised 03/08

DESCRIPTION: Fast Cure Epoxy Primer 940 is a fast curing epoxy primer, which provides superior performance to conventional lacquer and acrylic primer surfacers.

- FEATURES:**
- ◆ Provides smooth recoating surface without sanding.
 - ◆ Can be recoated after 1 hour with most two-pack topcoats.
 - ◆ Can be used on steel, aluminium, zinc coated steel, fibreglass and aged polyurethanes and baked enamel.

APPLICATION AREAS: Recommended for use on heavy-duty fleet vehicles, which require the maximum of protection against corrosion and chemicals. Such vehicles include - Concrete Transporters, Chemical and Petrol Transporters, Passenger Buses, etc.

TYPICAL SPECIFICATIONS

Surface	Preparation	System		Dry Film Thickness
Mild Steel, Aluminium, Fibreglass.	Degrease, abrade & clean	1 st Coat: 2 nd Coat:	Fast Cure Epoxy Primer 940 Lusterthane 988 or Iso-free 977	20 - 25 µm 40 - 50 µm
Zinc Coated Steel	Degrease, abrade & clean	1 st Coat: 2 nd Coat: 3 rd Coat	Multi Etch 302 Fast Cure Epoxy Primer 940 Lusterthane 988 or Iso Free 977	6 - 12 µm 20 - 25 µm 40 - 50 µm

For surface preparation, application and technical details see over

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SURFACE PREPARATION

Steel, Aluminium: Thoroughly degrease, abrade and clean with 450 Cleaning Solvent. Ensure that surface is free of corrosion products or moisture.

MIXING RATIO: Mix 1 volume Part A with 1 Volume Part B.

MIXING INSTRUCTIONS: Stir Part A until of uniform consistency. Add Part B and thoroughly mix. Allow to stand 20 minutes before use. Ready for use but may be thinned with 304 Thinner.

APPLICATION

Conventional Spray: Apply at 20 -25 µm d.f.t. Do not apply Fast Cure Epoxy Primer 940 below 10 °C and above 85% relative humidity. A light scuff with fine Scotchbrite or 1200 wet or dry paper after 4 hours min. drying is recommended to remove contamination. After 72 hours, in order to obtain maximum adhesion, lightly abrade the surface and solvent wipe with Thinner 304.

THINNER: Thinner 304.

CLEANING: Clean equipment after use with Thinner 304.

THEORETICAL COVERAGE:

Theoretical 11.3 m² per litre @ 25 µm DFT
(Equivalent Wet Film Thickness 90 µm)

(Mixing and application methods must be taken into consideration when estimating practical coverage rates)

PRECAUTIONS

Fast Cure Epoxy Primer 940 contains flammable solvents. Keep away from heat and open flame. When applying in a confined space use an airline respirator. In common with other organic solutions Fast Cure Epoxy Primer 940 should not be allowed to remain on skin and normal hygiene standards should be observed when using this product. MSDS should be consulted before use.

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Colour:	Grey
Gloss:	Low lustre
Drying Time:	Approximate air drying time at 25°C and 50% relative humidity at 25 um DFT.
Touch Dry:	15 minutes
Recoating Time:	1 hour min., 72 hours max.
Solids:	By volume approximately 28% (mixed)
Weight per Litre:	Approximately 1.14 kg (mixed).
Shelf Life:	6 months minimum.
Pot Life:	72 hours at 25 °C maximum.
Flash Point:	Part A - below 23 °C . Classification 3.1 (PG II) Part B - below 23 °C . Classification 3.1 (PG II)
Durability:	Excellent when topcoated
Resistance Properties	
Abrasion:	Good
Heat:	Good
Solvent:	Good
Oil:	Good
Chemical:	

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