

## 408 EPOTEC PRIMER SURFACER

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Revised: Apr 2008

<b>DESCRIPTION</b>	A polyamide cured epoxy primer surfacer, for use on metal, wood, masonry and fibreglass as the base coat for 370 EPOTEC TWO PACK EPOXY ENAMEL and 600 DURATEC POLYURETHANE ENAMEL topcoats.
<b>PRODUCT No</b>	<ul style="list-style-type: none"><li>• 408 - 1011 Grey-Green</li><li>• 408 - 5169 Ceramic Beige</li><li>• 408 - 6063 Grey</li><li>• 408 - 7218 Black</li></ul>
<b>GLOSS</b>	<ul style="list-style-type: none"><li>• Matt</li></ul>
<b>APPLICATION</b>	<ul style="list-style-type: none"><li>• Mix 4 parts by volume 408 EPOTEC PRIMER SURFACER PACK A with 1 part by volume 414 EPOTEC PRIMER HARDENER PACK B. Mix well and stand for 10 minutes before use.</li><li>• <b>Brush &amp; Roller:</b> Mixed material is ready for use for brush application. Apply full even coats. When applying over a porous surface, thin the first coat 15% with R202 EPOTEC THINNER.</li><li>• <b>Spray Application:</b> May be applied by conventional or airless spray. Thin mixed material 20% with R202 EPOTEC THINNER. Apply as two wet-on-wet medium coats, allowing 10 minutes flash-off between coats.</li></ul>
<b>THINNING</b>	<ul style="list-style-type: none"><li>• No thinning is required for brush application, but use R202 EPOTEC THINNER for spray application.</li></ul>
<b>CLEAN UP</b>	<ul style="list-style-type: none"><li>• Clean equipment with R202 EPOTEC THINNER</li></ul>
<b>RECOAT</b>	<ul style="list-style-type: none"><li>• After overnight drying under normal conditions.</li><li>• Sand surface well with 320/360 grit paper.</li><li>• Approximate re-coat times:<ul style="list-style-type: none"><li>➢ At 30°C minimum 10 hrs – maximum 24 hrs</li><li>➢ At 20°C minimum 20 hrs – maximum 48 hrs</li><li>➢ At 10°C minimum 30 hrs – maximum 60 hrs</li></ul></li></ul>
<b>COVERAGE</b>	<ul style="list-style-type: none"><li>• 11 square metres per litre at 40 microns dry film thickness, assuming no losses, but actual spreading rates will be less, depending on such factors as surface profile, application method and conditions.</li></ul>
<b>POT LIFE</b>	<ul style="list-style-type: none"><li>• Mixed material is 10 hours under normal conditions. Do NOT return unused mixed material to the can.</li></ul>
<b>MIXING RATIO</b>	<ul style="list-style-type: none"><li>• 4 parts 408 EPOTEC PRIMER SURFACER - PACK A</li><li>• 1 part 414 EPOTEC HARDENER - PACK B by volume</li></ul>

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### DRYING TIME

Drying of Epotec Primer Surfacer is very dependent on temperature and it will not cure at temperatures below 5°C.

- Touch Dry 1-2 hours
- Hard Dry overnight under normal conditions

### SURFACE PREPARATION

- Wash all surfaces to be painted with R123 HD WAX & GREASE REMOVER, using frequent changes of clean cloths.
- Work in small areas and dry off thoroughly with clean rags, starting on top panels and working down.
- Ensure that all oil and grease deposits are removed.
- Acid and alkali contamination should be removed by thoroughly rinsing with clean water.
- Rust, mill scale, oxide deposits, loose flaking paint and other foreign matter should be removed.
- **STEEL:** (a) **Structural Steel** - Abrasive blast clean to AS1627.4 Class 2.5 Apply primer within ½ hour of blasting.  
(b) **New Steel Sheet** - Treat new steel sheet with 971 METAL CONDITIONER.
  - Do not allow the solution to dry, but wipe off with clean cloths.
  - Rinse well with water to remove excess acid then wipe dry with clean cloths. Apply primer immediately after preparation of a clean surface.
- **ALUMINIUM:** Degrease with R123 HD WAX & GREASE REMOVER and wipe dry with clean cloths before dry.
  - Scuff surface with a nylon abrasive pad.
- **MASONRY, BRICK & CONCRETE:** Brush down to remove all dust and powdered material by wire or power brush.
  - Chemically neutralise the surface if efflorescence is present.
- **TIMBER:** Ensure surface is clean and dry and sanded to a smooth finish.
- **FIBREGLASS, (GRP):** Wash surface thoroughly using a mixture of warm water and detergent to remove waterborne release agents.
  - Rinse with clean water and wipe dry.
  - Lightly dry sand entire surface with 320 grit paper.
  - Clean up with R123 HD WAX & GREASE REMOVER, working in small areas and wipe dry with a clean cloth.
- **PREVIOUSLY PAINTED SURFACES:** Remove all loose and flaking paint, rust etc. with power/hand tool combination.
  - Spot prime all bare steel areas.
  - Before proceeding with the coating of any previously painted surface, a test patch should be done. Providing there has been no “frying” or other film defect, proceed as above.
  - If any “lifting” or frying is evident, strip back to bare metal with 186 SUPERSTRIP PAINT REMOVER.

## 408 EPOTEC PRIMER SURFACER

### RESISTANT PROPERTIES

- **Abrasion:** Excellent
- **Chemical:** Excellent
- **Solvent:** Excellent
- **Durability:** Excellent When Top Coated
- **Heat Resistance:** Satisfactory Up To 150°C

### PACK SIZES

- PACK A: 1 Litre, 4 Litres
- PACK B: 250mL, 1 Litre

### PRECAUTIONS

408 EPOTEC PRIMER contains highly flammable solvents. Keep away from all sources of heat and naked flames. Keep containers closed at all times. Do not smoke whilst using this product. Use in a well ventilated area and avoid inhalation of vapour or spray mist. Where risk of inhalation exists, use combined organic vapour/particulate respirator. When spray painting, comply with the provisions of the respective State Spray Painting Regulations. Avoid prolonged or repeated skin contact and observe all normal hygiene standards.

### HEALTH AND SAFETY

Contains highly flammable volatile solvents. Keep away from all sources of heat and open flames. Do not smoke whilst handling. Wear suitable protective clothing to avoid contact with skin and eyes and avoid breathing vapour. Do not spray in confined or poorly ventilated areas without the use of approved air supplied breathing apparatus.

### FIRST AID

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| <b>Eyes</b>       | If splashed in eyes, irrigate with copious amounts of clean water for 15 minutes. Seek medical aid if irritation persists.   |
| <b>Skin</b>       | If splashed on skin, wash affected area thoroughly with soap and water. If irritation persists seek medical aid. Remove all contaminated clothing and launder before re-use. |
| <b>Inhalation</b> | If affected by exposure to vapours, remove from area, keep at rest and seek medical aid if symptoms persist.   |
| <b>Ingestion</b>  | If swallowed, give glass of water to drink and seek medical assistance. <b>DO NOT</b> induce vomiting.   |

*Consult separate Material Safety Data Sheet for more detailed Health and Safety information.*