



TECHNICAL DATA SHEET

AP-4110

**PROTEC
EPOXY PRIMER**

PRODUCTS

Protec Epoxy Primer	AP-4110
Protec Epoxy Primer Hardener	AH-4120
Paraglaze Reducers	PS-6100 or PS-6200 or PS-6300

PRODUCT DESCRIPTION

Protec Epoxy Primer is a 2 pack adhesion promoting epoxy primer designed for use over bare metal surfaces and under spray polyester and hand applied body fillers to protect against corrosion. It has excellent adhesion to steel, aluminum, fibreglass and Zinc coated metals.

SUBSTRATES & PREPARATION



Bare steel after degreasing with R123 HD Wax & Grease Remover, sanding with P120 to P150 grit dry abrasive & conditioning with 971 Metal Conditioner & Degreaser.

Aluminium after cleaning and degreasing with R123 HD Wax & Grease Remover. The surface then needs to be abraded with a 50/50 mix of methylated spirits and clean water using a scouring pad such as Mirka Mirlon or equivalent. Final degrease again with R123 HD Wax & Grease Remover.

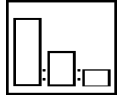
GRP Fibreglass that has been thoroughly cleaned with 978 Surface Cleaner, sanded with P150 to P240 grit dry abrasive and finally degreased with R123 HD Wax & Grease Remover.

Zinc coated metals can vary in alloy composition therefore it is recommended that you carry out an adhesion test before completing any major work. As a minimum Zinc substrates should be cleaned and degreased with R123 HD Wax & Grease Remover. The surface then needs to be abraded with a 50/50 mix of methylated spirits and clean water using a scouring pad such as Mirka Mirlon or equivalent. Final degrease again with R123 HD Wax & Grease Remover.

Do not apply under or over Acrylic lacquer.

**All surfaces must be clean, dry and free from any contamination before priming.
Please see relevant cleaning product datasheets for more information.**

MIXING RATIO BY VOLUME



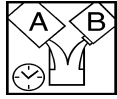
PRODUCT

AP-4110
AH-4120
PS-6100 or PS-6200 or PS-6300

PARTS

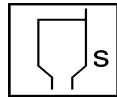
5
1
0-15%

POTLIFE



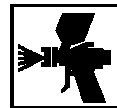
30 Minutes at 20°C

SPRAY VISCOSITY @ 20°C



17-20 Seconds (DIN4)

SPRAYGUN SETUP



1.4mm - 1.7mm

SPRAY PRESSURE

HVLP / RP

2 – 3 bar

CONVENTIONAL

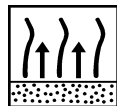
45 – 55 PSI / 300-380 KPA

NUMBER OF COATS & FLASH OFF



One coat
Flash off

Apply an even wet coat
25 Minutes at 20c



Make sure the product has flashed off 25 minutes before overcoating with a 2 pack primer

OVERCOAT WITH

Any Paraglaze, Quickline or Carmaster 2 pack primer. *Wet on wet primers can also be used over epoxy primer but do not directly apply basecoats or topcoats to epoxy primers.* **Note: This product must be primed within 72 hours, after 72 hours the product must be sanded and re-coated. The vehicle must be kept dry and free of moisture and contaminants during this period.**

TOTAL DRY FILM BUILD

20 - 25 um

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Material Safety Data Sheets for full Health and Safety details.

This primer hardener contains isocyanate and therefore particular safety precautions must be taken.

Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.

Good ventilation and extraction must be provided in the working environment.

Wear suitable protective equipment to prevent skin contact with this material.

When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus. Do not smoke whilst using this material.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.

Before using refer to Material Safety Data Sheet obtainable from Protec Pty Ltd.

Follow all directions and warnings fully and carefully. Otherwise do not use this product

Protec Pty Ltd. 97–105 Bedford Street, Gillman, S.A. 5013 Australia

EMERGENCY RESPONSE NUMBER: Australia: 1800 883 254

Protec Pty Ltd. 5 Monahan Rd, Mt Wellington, Auckland, New Zealand

EMERGENCY RESPONSE NUMBER: New Zealand: 0800 000 096