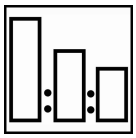
Primer Surfacer EP II

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



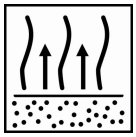
100 Primer Surfacer EPII
50 Primer Surfacer EPII Hardener
40 Autoclear LV Superior Reducer Fast/Plus Reducer

Use Sikkens measuring stick
12 Green

Spray gun set-up:
1.5-2.0 mm

Application pressure:
28-30 psi (1.7-2.2 bar) at the air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

1-3 x 1 coat



Between coats:
5-10 minutes at 70°F (20°C)

Before curing:
5-10 minutes at 70°F (20°C)

8 hours at 70°F (20°C)
3 coat application

45 minutes at 140°F (60°C)

Final sanding step: P220-P320
See TDS S8.06.01

Recoatable 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

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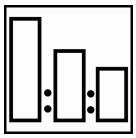
Non sanding application



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

Use Sikkens measuring stick
2 Blue

Spray gun set-up:
1.3-1.6 mm

Application pressure:
28-30 psi (1.7-2.2 bar) at the air inlet
HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

1 coat

45 minutes at 70°F (20°C)

15 minutes at 140°F (60°C)

Recoat within 48 hours at 70°F (20°C)

Recoatable with all Sikkens primer fillers/surfacers and topcoats

Use suitable respiratory protection
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Suitable substrates

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

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 EPII directly over Sikkens Washprimer.*

Primer Surfacer EPII should only be applied on hard plastic substrates which have been preceded by;
1K All Plastic Primer, 2K Plastic Primer or Primer PO.
*Do **not** apply to thermo plastics i.e.deformable with heat.*

Product and additives

Primer Surfacer EPII

Hardeners Primer Surfacer EPII Hardener

Plus Reducers
Plus Reducer Fast; spot and panel repairs, temperature range: 60°F-75°F (15°C-25°C).
Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 70°F-85°F (20°C-30°C).
Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 80°F-95°F (25°C-35°C).
Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 95°F (35°C).

Reducer Autoclear LV Superior Reducer Fast

Basic raw materials

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

Primer Surfacer EP II

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Surface preparation

Surface cleaning, remove any surface contamination prior to sanding using an appropriate 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; P120 - P220
Sikkens polyester bodyfillers and Polysurfacer; finished with;P180 - P220
For detailed surface preparation see TDS S8.06.02

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

Stir before use

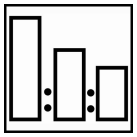
Stir Primer Surfacer EPII thoroughly before mixing.

Mixing Primer Surfacer EPII

If necessary, Primer Surfacer EPII can be tinted with up to 5 parts by volume with either;
Autocryl, Autocryl Plus, Autocryl LV or Autocryl Plus LV MM toners.

Primer Surfacer EP II mixted with any of the topcoat MM colours must be stirred thoroughly before adding the Primer Surfacer EP II Hardener.

Mixing



Sanding

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

100	Primer Surfacer EPII
50	Primer Surfacer EPII Hardener
40	Plus Reducers

Wet-on-wet (non sanding) VOC compliant

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

Wet-on-wet (non sanding) non compliant

100	Primer Surfacer EPII
50	Primer Surfacer EPII Hardener
50	Plus Reducers

Primer Surfacer EP II

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Spray gun set-up / application pressure

Spray gun	Fluid tip-set-up	Application pressure
Sanding		
Gravity feed	1.5-2.0 mm	28-30 psi (1.7-2.2 bar) at the spray gun air inlet HVLP max 8-10 psi (0.6-0.7 bar) at the air cap
Non Sanding		
Gravity feed	1.3-1.6 mm	28-30 psi (1.7-2.2 bar) at the spray gun air inlet HVLP max 8-10 psi (0.6-0.7 bar) at the air cap

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

Pot-life

Sanding:	4 hours at 70°F (20°C).
Non sanding:	6 hours at 70°F (20°C).

Application

Sanding application:
Apply one coat over the total sanded area. Next apply the 2nd and 3rd coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.

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.

Non sanding application:
Apply one full coat.

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

Drying time sanding

8 hours at 70°C (20°C). 2 hours at 100°F (40°C). 45 minutes at 140°F (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 must not reach a temperature above 212°F (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*

Primer Surfacer EP II

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Drying time non sanding

45 minutes at 70°C (20°C). 15 minutes at 140°F (60°C).

Recoat with 48 hours at 70°C (20°C).

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

Drying time in case of polyester bodyfiller application

16 hours at 70°F (20°C).

Drying time relate to recommended application of maximum 1 coat (± 1 mil/25 µm) Primer Surfacer EPII.

5 minutes low power 10 minutes high power

Allow 5 minutes flash off prior to infra red curing
The panel must not reach a temperature above 212°F (100°C) while curing.

Polyester bodyfiller application
Abrade the Primer Surfacer EPII 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 EPII is recoatable with all Sikkens primers fillers/surfacers and topcoats.

Film thickness

		µm
Sanding	Per coat	30-35
	Per 3 coats	90-105
Roller application	Per coat	na
	Per 3 coats	na
Non Sanding (wet-on-wet)	Per coat	25-30
	Per 1 coats	25-30

Application of maximum 1 coat of +/- 25 µm is recommended prior to polyester bodyfiller application.

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Theoretical Coverage

	m²/liter
Ready for use mixture at 1 µm dry film thickness **Sanding**	± 388
Ready for use mixture at 1 µm dry film thickness **Non sanding (wet-on-wet)**	± 370

Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

VOC

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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