

EP Primer Grey 440



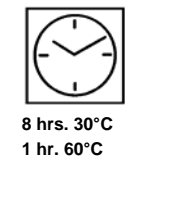
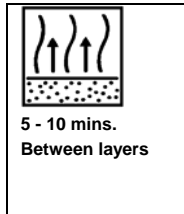
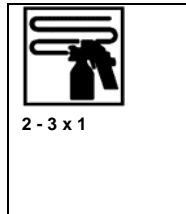
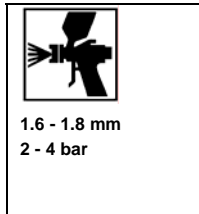
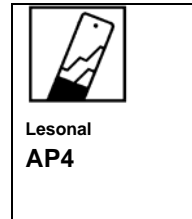
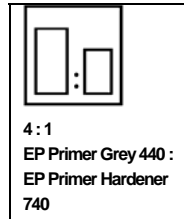
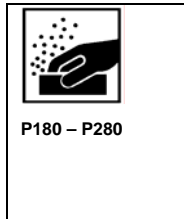
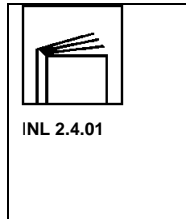
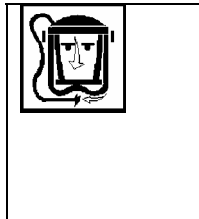
Technical Data Sheet



May 2007

INL 2.4.01

Description Two-component epoxy-based primer for general use in refinishing cars and other vehicles. It provides corrosion resistance and excellent leveling with superior gloss hold out.



Product & ancillary items

Product: Lesonal EP Primer Grey 440

Hardener: Lesonal EP Primer Hardener 740

Thinners Lesonal Multi Thinner 810 (any)

Basic Raw Materials Lesonal EP Primer Grey 440 – Epoxy Resins
Lesonal EP Primer Hardener 740 – Polyaminoamide Resins

Method of use

Suitable Substrates: Steel
Aluminum
Galvanized Steel
Lesonal 2K Putty 522

Substrate Preparation: Prior to any sanding work, thoroughly cleanse the surface of with Akzo Nobel Wax and Grease Remover. Apply using two clean cloths in a wipe-on, wipe-off process.

Original finishes – sand with P180 to P280 grit dry, or P600-P800 wet.
Steel – remove all traces of rust and abrade thoroughly until a clean surface is achieved.
Lesonal 2K Putty 522 – Final sanding with P280 grit dry.

After sanding work is completed and just prior to the application of primer, degrease again thoroughly with Akzo Nobel Wax and Grease Remover.

Mixing Ratio by Volume:	4 parts by volume – Lesonal EP Primer Grey 440		
	1 part by volume – Lesonal EP Primer Hardener 740		
	Mix in a parallel-sided mixing vessel, and stir well before use.		
Spraying Viscosity:	20 – 22 seconds at 20°C		
Potlife:	8 hours at 20°C		
Spray Gun Fluid Tip and Working Pressure:	<u>Spray Gun:</u>	<u>Fluid Tip:</u>	<u>Working Pressure:</u>
	Gravity Feed	1.6–1.8 mm	2–4 bar
	Suction Feed	1.8 mm	2–4 bar
	HVLP	1.7–1.9 mm	0.7 bar @ air cap
	Pressure Pot	1.1–1.2 mm	4–6 bar
Application Technique:	<p>Apply two or three coats; allow drying until matt between each coat. Generally this will take 5 – 10 minutes (this time will be very much influenced by factors such as temperature and air movement at the time of application).</p> <p>If the product is to be applied over a thermoplastic acrylic finish, it is recommended that a thin coat is applied first, and that care is also taken in applying subsequent coats. Flash off times between each coat should also be extended.</p>		
Film Thickness:	30 – 35 microns		
Equipment Cleaning:	Use Multi Thinner 810 (any) or Lesonal NC Thinner 820		
Drying Times:		<u>30°C</u>	<u>60°C</u>
	Touch Dry	8 mins.	4 mins.
	Tack free time	16 mins.	8 mins.
	Hard dry	8 hours	1 hour
	Dry to sand	8 hours	1 hour
Recommended Sanding Grades:	<u>Method</u>	<u>Sandpaper Grade</u>	
	Wet, by hand	P800 – P1000	
	Wet, by machine	P400 – P500	
	Dry, by hand	P360 – P400	
	Dry, by machine	P360 – P400	
Helpful Tips:	<p>Recoatable with Lesonal Fast Dry Primer 410, Lesonal 2K Primer 480, or Lesonal 2K Topcoat 320 within 48 hours after application of Lesonal EP Primer Grey 440. After 48 hours, prior sanding with P280 – P400 dry is necessary before applying the next coating.</p>		
Colour:	Light Grey		
Shelflife:	Lesonal EP Primer Grey 440 – 1 years		
	Lesonal EP Primer Hardener 740 – 1 year		

Health & Safety Data: These products are intended for professional use only. Please refer to can labels and Safety Data Sheets concerned for more specific information. The user of these products is required to comply with the national laws pertaining to Health & Safety disposal. *The above information is given in good faith, but without warranty, as the final results are also dependent upon factors of use which are outside our control.*