

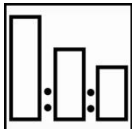
# Primer Surfacer EP

FOR PROFESSIONAL USE ONLY

## Description

Two-pack, 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 EP  
50 Primer Surfacer EP Hardener  
30 Plus Reducer



Use Sikkens measuring stick

**1** Black



Spray gun set-up:  
1.5-1.8 mm

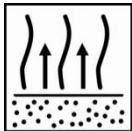
Application pressure:

1.7-2.2 bar at the air inlet

HVLP max 0.6-0.7 bar at the air cap



2-3 x 1 coat

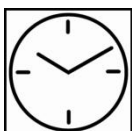


Between coats:

5-10 minutes at 20°C

Before curing:

5-10 minutes at 20°C



5 hours at 20°C  
3 coat application

60 minutes at 60°C



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



Recoatable with all Sikkens primer 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

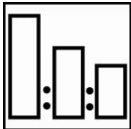
# Primer Surfacer EP

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## Description

Two-pack, 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.

## Non sanding application



100 Primer Surfacer EP  
50 Primer Surfacer EP Hardener  
30 Plus Reducer



Use Sikkens measuring stick

**1** Black

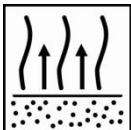


Spray gun set-up:  
1.3-1.6 mm

Application pressure:  
1.7-2.2 bar at the air inlet  
HVLV max 0.6-0.7 bar at the air cap



1 coat



Prior to topcoat application  
15 minutes at 20°C

Prior to putty application  
45 minutes at 20°C



Recoatable with all Sikkens primer surfacers and topcoats



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# Primer Surfacer EP

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## Description

Two-pack, 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.

## Suitable substrates

Existing finishes	Glass Reinforced Polyester laminates (GRP)
Steel	Polyester bodyfillers
Zinc coated steel	Polysurfacer
Aluminium	Wood

*Primer Surfacer EP 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.*

*Do **not** apply apply Primer Surfacer EP directly over Sikkens Washprimers.*

*Do **not** apply to thermo plastics i.e.deformable to heat.*

## Product and additives

Primer Surfacer EP

**Hardeners** Primer Surfacer EP Hardener

**Plus Reducers** Plus Reducer Fast; spot and panel repairs, temperature range: 15°C-25°C.  
 Plus Reducer Medium; spot and panel repairs and large areas, temperature range: 20°C-30°C.  
 Plus Reducer Slow; larger areas and complete paint jobs, temperature range: 25°C-35°C.  
 Plus Reducer Extra Slow; to use in extremely hot temperatures, temperature range: above 35°C.

## Basic raw materials

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

## Surface preparation



Surface cleaning; remove any surface contamination prior to sanding using Sikkens M700 or M600 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 zinc coated stell; P120 - P220  
 Sikkens polyester bodyfillers and Polysurfacer; finished with;P220 – P320  
*For detailed surface preparation see TDS S8.06.02*



Surface cleaning, remove any surface contamination prior to the application of Primer Surfacer EP using Sikkens M700 or M600 surface cleaner. *Where bodyfiller or Polysurfacer is exposed, avoid contact with water (e.g. waterborne degreaser).*

# Primer Surfacer EP

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## Stir before use



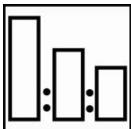
Stir Primer Surfacer EP thoroughly before mixing.

## Mixing Primer Surfacer EP

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

*Primer Surfacer EP mixed with any of the topcoat MM colors must be stirred thoroughly before adding the Primer Surfacer EP Hardener.*

## Mixing



100 Primer Surfacer EP  
50 Primer Surfacer EP Hardener  
30 Plus Reducers

## Spray gun set-up / application pressure



**Spray gun**  
**Sanding**  
Gravity feed

**Fluid tip-set-up**

1.5-2.0 mm

**Application pressure**

1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

**Non Sanding**  
Gravity feed

1.3-1.6 mm

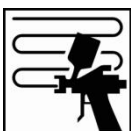
1.7-2.2 bar at the spray gun air inlet  
HVLP max 0.6-0.7 bar at the air cap

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

## Pot-life

8 hours at 20°C.

## Application



### Sanding application:

Apply 2-3 single coats, allowing a flash-off time of 5 to 10 minutes between coats.

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

# Primer Surfacer EP

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## Drying time for sanding



5 hours at 20°C.

2 hours at 40°C.

60 minutes at 60°C.

Drying times at 40 µm film built



Allow 5 minutes flash off prior to infra red curing  
The panel must not reach a temperature above 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*

## Drying time in case of topcoat application



Recoatable with topcoats after:

15 minutes at 20°C.

10 minutes at 40°C

10 minutes at 60°C.

Drying time relate to recommended application of maximum 1 coat ± 25 µm Primer Surfacer EP.

## Drying time in case of polyester bodyfiller application



45 minutes at 20°C.

30 minutes at 40°C.

15 minutes at 60°C.

Drying time relate to recommended application of maximum 1 coat ± 25 µm Primer Surfacer EP.



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 100°C while curing.  
*For additional infra red drying information; see TDS S9.01.01*



Polyester bodyfiller application  
Abrade the Primer Surfacer EP 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).*

# Primer Surfacer EP

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## Recoatable with

Primer Surfacer EP is recoatable with all Sikkens primers fillers/surfacers and topcoats.

Note: If a drying time of 8 hours at 20°C. is exceeded, Primer Surfacer EP must be flatted prior to be recoated with a finish.

## Film thickness

		µm
Sanding	Per coat	±25
	Per 3 coats	±75
Roller application	Per coat	na
	Per 3 coats	na
Non Sanding (w-o-w)	Per coat	±25
	Per 1 coats	±25

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

## Theoretical Coverage

	m <sup>2</sup> /liter
Ready for use mixture at 20 µm dry film thickness	± 11

## Cleaning of equipment

Sikkens Solvents or solvent borne Guncleaners

## VOC

The VOC content of this product in ready to use form is max. 600 g/liter.

## Product storage

Product shelf-life is determined when products are stored unopened at 20°C.  
Avoid extreme temperature fluctuation.  
o Product shelf life data see TDS S9.01.02

**Akzo Nobel Car Refinishes Australia Pty Ltd**  
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Tel: 0396441711

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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#### Head Office

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