



# Technical Data Sheet

## Epoxy Primer (4:1)

2K Epoxy Polyamide Primer

Date: 21<sup>st</sup> October 2016

Version:01

Product Name	
Full Product Name	<b>Epoxy Primer (4:1)</b>
Type of Product	2K epoxy polyamide primer
Description	Spray Chief Epoxy Primer (4:1) is a 2K epoxy-polyamide primer suitable for any topcoat. It is characterised by its excellent adhesion to most metal substrates, ease of sanding, outstanding flexibility and very good anti-corrosive properties, chemical and water resistance.

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
Epoxy Primer (4:1) Black	49.3	66.8	1.377	11.49	456.9	3.81
Epoxy Primer (4:1) Grey	49.1	70.1	1.518	12.67	454.4	3.79
Epoxy Primer (4:1) White	49.7	71.0	1.551	12.94	449.0	3.75
Epoxy Primer Hardener (EP41)	40.3	42.8	0.910	7.60	520.9	4.35
2K Thinner	0.0	0.0	0.882	7.36	881.9	7.36

Properties
<ul style="list-style-type: none"> <li>• Excellent flexibility</li> </ul>
<ul style="list-style-type: none"> <li>• Easy to sand</li> </ul>

Substrates
<ul style="list-style-type: none"> <li>• Aluminium, steel galvanised steel.</li> </ul>
<ul style="list-style-type: none"> <li>• Glass reinforces polyester (GRP)</li> </ul>
<ul style="list-style-type: none"> <li>• Sound existing finishes</li> </ul>



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### Substrate Preparation



**All Substrates**

All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept Rust & Metal Converter.

### Product Preparation

	<b>Mixing Ratio</b> 4:1 (by volume)	<b>Spray Chief Epoxy Primer (4:1)</b>		<b>Spray Chief Primer Hardener (EP41)</b>	
		4 parts		1 part	
	<b>Reducer</b>	10-20% (v/v) of Spray Chief 2K Thinner, if required			
	<b>Pot life</b> @ 25°C (77°F)	6 hours			
	<b>Spray viscosity</b> @ 25°C (77°F)	<b>BSB 4 Cup</b> <b>Ford 4 Cup</b>	17-19 s 15-17 s		
  	<b>Spray equipment</b>	<b>Gun type</b>	<b>Fluid tip</b>	<b>Spray pressure</b>	<b>Spray Distance</b>
		<b>Gravity feed</b>	1.3-1.4 mm 0.051-0.055"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
		<b>Suction feed</b>	1.3-1.4 mm 0.051-0.055"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch
		<b>HVLP</b>	1.2-1.3 mm 0.047-0.051"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch
	<b>Number of coats</b>	2-3	Apply two to three even full coats. Avoid heavy wet coats.		
	<b>DFT Recommended</b>	40-50 µm 1.6-2.0 mils			



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


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
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### Product Preparation cont

	<b>Flash off time</b> @ 25°C (77°F)	5 min between coats	
	<b>Drying</b>	<b>Air Dry</b> @ 25°C (77°F)	3-4 hours
		<b>Low Bake</b> @ 50°C (122°F)	30-40 min
	<b>Sanding</b>	Wet sand thoroughly with P600 - P800 before applying finish coat.	

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.

### Remarks

	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.

### Equipment Cleaning

Use recommended Spray Chief cleaner

### Dry Film Properties

After 7 days drying,  
**when compared to similar technology products.**

<b>Water resistance</b>	Excellent
<b>Chemical resistance</b>	Excellent
<b>Adhesion</b>	Excellent



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Colour	Black, Grey White
Theoretical Coverage	Approx. 8 m <sup>2</sup> /L (325 ft <sup>2</sup> /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature away from sunlight.

Product Packaging			
Product Code 1	Product Code 2	Product Name	Package Size
A16/EP41B	8807000	Epoxy Primer (4:1) Black	1.25L (Kit), 5L (Kit)
A16/EP41G	8806200	Epoxy Primer (4:1) Grey	1.25L (Kit), 5L (Kit)
A16/EP41W	8806000	Epoxy Primer (4:1) White	1.25L (Kit), 5L (Kit)
A16/EP41H	8819200	Epoxy Primer Hardener (EP41)	250mL, 1L
A16/2KTHIN	8949200	2K Thinner	1L, 4L, 20L

Safety
<p>For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.</p> <p>Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations</p>



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This Technical Data Sheet supersedes all previous issues.

Chilmix Pty Limited t/a Spray Chief Custom Paints  
ABN 28 069 967 362  
26-30 Charles Street, St Marys NSW 2760  
Sydney, Australia

ph. +61 (2) 9673 2555  
fax. +61 (2) 9623 1918  
sales@spraychiefcustompaints.com.au  
www.spraychiefcustompaints.com.au