



TECHNICAL DATA SHEET

EPOXY PRIMER (4:1)

PRODUCT DESCRIPTION

Spray Chief's Epoxy Primer (4:1) is a two pack chromate free epoxy-polyamide primer that has excellent adhesion to any metal substrate. The unique formula produces a primer, which is very easy to sand and is suitable for any topcoat. It has very good anti-corrosive properties, with outstanding flexibility, chemical and water resistance.

PRODUCT AND ADDITIVES

- Spray Chief Epoxy Primer (4:1)
- Spray Chief Epoxy Primer Hardener
- Spray Chief 2K Thinner


SUITABLE SUBSTRATES

- Sound existing finishes.
- Steel, Aluminium, Galvanised and Fibreglass surfaces.
- Stainless Steel Grade 316

MIXING RATIO





- 4 parts Spray Chief Epoxy Primer (4:1) by volume.
- 1 part Spray Chief Epoxy Primer Hardener by volume
- If needed a 10 - 20% reduction can be made with Spray Chief 2K Thinner.

SPRAY GUN AND PRESSURE

SPRAY GUN & PRESSURE:	<ul style="list-style-type: none"> Use gravity fed gun Tip: 1.8 – 2.0 mm Pressure: 350 – 400 kPa Fan Size: 15 – 20 cm 	
--------------------------	---	---

APPLICATION

- Stir thoroughly before use.
- All surfaces must be thoroughly sanded and cleaned with a suitable Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with a suitable Rust & Metal Conditioner.
- Two to three, even coats are needed to obtain a 40 - 50 Micron Dry Film Thickness.

SPRAYING VISCOSITY:	<ul style="list-style-type: none"> 17 - 19 seconds B4 cup at 25°C. 	 17-19 SECONDS
FLASH-OFF TIME:	<ul style="list-style-type: none"> 5 minutes between coats at 25°C. 	
DRYING:	<ul style="list-style-type: none"> 3 - 4 hours at 25°C for a Dry Film Thickness of 40 – 50 Micron. Low Bake for 30 - 40 minutes at 50°C. 	
SANDING:	<ul style="list-style-type: none"> Wet sand thoroughly with either P600 - P800 before applying finish coat. 	

TECHNICAL INFORMATION

COLOUR:	Grey, White and Black
COVERAGE:	8 m ² /L @ 50 Micron Dry Film Thickness.
POT LIFE:	6 hours at 25°C.
VOC:	Grey: 454 g/L, White: 449 g/L, Black: 454 g/L, Hardener: 520 g/L
PACKAGING:	1.25LT KIT, 5LT KIT
ITEM CODE:	A16/EP41 (Hardener: A16/EPOXYH)
SHELF LIFE:	12 Months

SAFETY PRECAUTIONS

Please refer to the relevant Safety Data Sheet before using this product.

The above information is reliable and accurate to the best of our knowledge at the time of preparation. Any recommendations or suggestions made are without warranty or guarantee. Users assume all responsibility since the conditions of use are beyond our control.

REVISED: 23 February 2014

REPLACES ISSUE: