PROTEC AUTOMOTIVE PAINTS

TECHNICAL DATA SHEET

AP-4110 PROTEC® EPOXY PRIMER

PRODUCT DESCRIPTION

Protec Epoxy Primer is a 2 pack adhesion promoting epoxy primer designed for use over bare metal surfaces and under spray polyester and hand applied body fillers to protect against corrosion.

It has excellent adhesion to steel, aluminum, fibreglass and Zinc coated metals.

PRODUCTS

Protec Epoxy Primer	AP-4110
Protec Epoxy Primer Hardener	AH-4120
Paraglaze Reducer Low Temp	PS-6100
Paraglaze Reducer Standard	PS-6200
Paraglaze Reducer High Temp	PS-6300
Carmaster GP 2 Pack Reducer	CS-3800
Protec Heavy Duty Wax & Grease Remover	AA-6822
Protec Methylated Spirits	207

SUBSTRATES & PREPARATION

Protec Epoxy Primer can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE	PREPARATION
Bare Steel	*Degrease with AA-6822 Protec Heavy Duty Wax and Grease Remover, condition with 971-9119 Metal conditioner and Degreaser, abrade with Startline P240 (dry).*
Aluminium	P240 - P320 (dry), then use a 50:50 mixture of Water and 207 *Protec* Methylated Spirits with one rag to wipe on and another clean rag to wipe off. Prime within 6 hours
Zinc Coated Alloys	Scourer with a 50:50 mixture of Water and 207 *Protec* Methylated Spirits *Zinc coated metals can vary in alloy composition, therefore, it is recommended that an adhesion test is carried out before completing any major work.*
GRP & Fibreglass	P240 - P320 (dry)

Do not apply acrylic lacquer primers and topcoats over or under AP-4110 Protec Epoxy Primer.

Substrates other than those stated above should be tested before use, to ensure that the performance of this product is suitable for its intended use.

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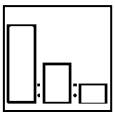
CLEANING

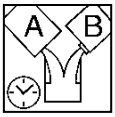
Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover.

MIXING RATIO BY VOLUME



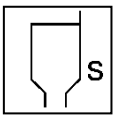
PRODUCT	PARTS
AP-4110	5
AH-4120	1
Paraglaze or Carmaster Reducer	0 - 15%

POTLIFE



Catalysed material is useable for up to 30 minutes at 25°C.

SPRAY VISCOSITY



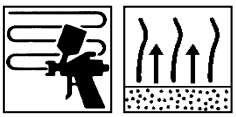
17 - 20 seconds (DIN 4) at 25°C.

SPRAYGUN SETTINGS *(GRAVITY)*

SETUP 1.4 - 1.7 mm

SPRAY PRESSURE
- HVLP / RP: 2 - 3 bar
- CONVENTIONAL: 3.0 - 3.8 bar

APPLICATION & FLASH OFF

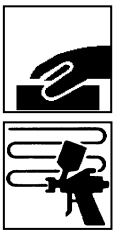


- COATS: Apply 1 even, wet coat

TOTAL DRY FILM BUILD

20 - 25 µm

TOPCOAT



TIME: 25 minutes, minimum, at 25°C

Must be topcoated within 72 hours, otherwise will require sanding and re-coating.

The vehicle must be kept dry and free of moisture and contaminants during this period.

Protec Epoxy Primer may be topcoated with the following:

- Two pack primers in the Paraglaze, Paraglaze CT and Carmaster ranges, or as advised by the *Protec* Technical Team

Protec Epoxy Primer may NOT be topcoated with the following:

- Topcoats and basecoats

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

Protec hardeners and activated products contain isocyanate and therefore particular safety precautions must be taken; please refer to SDS for full health and safety details.

This product is for professional use only.
The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his or her own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.
Drying times quoted are average times at 25°C/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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