

Technical Data Sheet

DUREPOX 2K PRIMER

DESCRIPTION	SUITABLE SUBSTRATES
<p>A unique highly pigmented free sanding 2-pack epoxy urethane primer formulated for the Automotive Refinish, Marine, Industrial and Aircraft industries. One of the great features of this two-pack product is its remarkable flexibility and adhesion to bare metal. As a 'top of the range primer', Durepox not only provides a workable stable base onto which two-pack systems may be confidently applied but is also excellent for preparing a solid foundation for top quality Alkyd, Nitro-cellulose and Acrylic Lacquer finishes.</p> <p>MAF Approved - Refer MQ1, Dairy approval. Regulatory Authority manual 15 for meat, fish, game and poultry, all areas.</p>	<p>Durepox can be applied over correctly prepared:</p> <ul style="list-style-type: none"> • Aged and fully cured Automotive finishes including Acrylic Lacquers and clear over base systems • Steel • Galvanised steel (after 81A 2-Pack Etch Primer) • Wood and MDF Board Composites • Aluminium after 81A 2-Pack Etch Primer • G.R.P. (Fibreglass) • Concrete • Polyester body fillers • Ideal isolator and sealer over aged enamels and difficult substrates. • Carbon Fibre. • Plastic bumpers

SPECIFICATION DATA	
<p>Product Type: Epoxy Urethane</p> <p>Colour: White, Black, Grey, Light Grey,</p> <p>Pot Life: Bright Red, Deep Red, Blue 4 hours with Durepox Hardener</p> <p>Induction Time: at 20°C 5 Minutes</p> <p>Density: 1.331kg/L</p> <p>Recommended D.F.T: 50 Microns</p> <p>Theoretical Coverage: 9m²/L @ 50 Microns D.F.T.</p> <p>V.O.C: 523 g/L</p> <p>Volume Solids: 37.82% (White)</p>	<p>Dry Time @ 20°C:</p> <ul style="list-style-type: none"> • Touch Dry: 1 Hour • Handle: 12 Hours • Sandable: 12 Hours • Self recoat @ 20°C: between 1 and 48 hours. (After 48 hours must be sanded to ensure intercoat adhesion) • Topcoat: between 2 hours and 36 hours, then any time after sanding, except lacquers which should be applied after Durepox has dried for at least 36 hours and dry sanded as application of many coats of products containing high proportions of solvents can cause uncured 2K products to react.

Lower temperatures will slow drying; adding of up to 5% by volume of **RAPC 62C Accelerator** to mixed primer and hardener will approximately halve curing and pot life times. Reduce addition to 1-2% when drying with IR lamps. Misuse of **62C Accelerator** can cause loss of adhesion and poor flow-out.

SURFACE PREPARATION
<p>Old Finishes: Wash with C-Power diluted 20 parts clean water to 1 part C-Power. Degrease with Wax & Grease Remover. Abrade with suitable grit abrasive paper and ensure surface is completely dry and dust free.</p> <p>Steel: Degrease thoroughly with Wax & Grease Remover, sand to eliminate all rust or corrosion and treat with Rustkill (refer data sheet). Wipe surface clean with Wax and Grease Remover. Allow drying. Apply first 81-Two Pack Etch Primer for optimum adhesion on large areas (refer data sheet). Allow a minimum 3 hours flash time before applying Durepox Primer</p>



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SURFACE PREPARATION cont.

Aluminium:

Degrease with Wax & Grease Remover. Mechanically abrade with P280 or P320 disc. Treat with Hydracos - acid wash (refer data sheet). Rinse with clean water, ensuring that all metal swarf and acid is removed and allow drying. Immediately after wipe surface clean with G.P Thinners. Apply first 81-Two Pack Etch Primer within 20 minutes of surface preparation. Allow a minimum of 3 hours flash time (24 hour maximum) before applying Durepox.

Galvanised Steel:

Degrease with Wax & Grease Remover. Mechanically abrade to remove rust and corrosion. Treat with Hydracos acid wash. Rinse with clean water. Immediately wipe surface clean with GP Thinners. Apply 81A 2-Pack Etch Primer within 20 minutes of surface preparation. Allow a minimum of a 3 hours flash time (24 hour maximum) before applying Durepox.

G.R.P (Fibreglass):

Wash with warm detergent solution e.g. C-Power solution. Degrease with Wax & Grease Remover. Abrade with 120-180 grit dry paper. Remove dust and wipe clean with Wax & Grease Remover.

Plastic Bumpers & Carbon Fibre:

Clean thoroughly with Wax & Grease Remover. Sand with 320 grit abrasive paper. Remove dust and wipe clean with Wax & Grease Remover. Apply one full coat of Durepox. Types of plastic vary, so adhesion should be tested prior to top coating.

Concrete:

Treat with Hydracos-acid wash (refer Data Sheet) or abrasive blast new concrete. Ensure surface is dry and free from dirt, grease and oil deposits. When Durepox is to be used as a single coat finish on interior floors in workshops, garages etc, consult **Resene Automotive and Performance Coatings** Technical Staff.

DIRECTIONS FOR USE

Strain mixed product prior to application.

Mixing Ratio: 4 parts Durepox Primer
(Volume) 1 part Durepox Hardener

Thinning: Up to 20% 400 Reducer

Spray Equipment:

- Conventional suction and gravity feed guns.
- Tip Size: 1.5 - 2 mm
- Spray pressure: 275-380KPA (40-55 p.s.i.)
- Number of coats: 2 coats (5-10 minutes flash between coats)

Although Durepox can be applied without thinning, best results are obtained by thinning up to 20% by volume with 400 Reducer. This allows for different gun set-ups and techniques, and assists flow and levelling.

Brush and Roller: 4:1 Durepox Hardener and 0 – 5% 400 Reducer.

Remarks: Do not use activated material beyond pot life time or by reducing it further to get the viscosity down again. This procedure results in poor flow and adhesion failures.



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HEALTH & SAFETY

For detailed information refer to Material Safety Data Sheet. Mixed product contains isocyanates. Inhalation of vapours or dust from sanding may cause respiratory sensitisation. Splashes to eyes will cause irritation. Contact with skin may cause irritation. Applicators should use protective clothing and respiratory equipment. Product is flammable, use and store away from heat and ignition sources

TRANSPORT & STORAGE

Sizes:	1L, 4L, 20L
Dangerous Goods:	3A
UN:	No 1263
Hazchem:	3(Y)E
Packing Group:	II
Shipment name:	PAINT Flammable
Flash point:	Below 23°C

DISCLAIMER

No warranty either expressed or implied is made by Resene Automotive and Performance Coatings in this document, which is a technical data information sheet. The description of the product and its properties is for the sole purpose of identifying the product and does not constitute a warranty that the product or its properties shall conform to that description, nor is the description of the product and its properties a warranty by Resene Automotive and Performance Coatings that the goods are suitable for a particular purpose.

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