Product Data
472 Rapid Epoxy Primer

PRODUCTS
472-5158      Rapid Epoxy Primer Pack “A”
472-9077      Rapid Epoxy Hardener pack “B”

Product Description
A premium quality, two pack, non-sanding, rapid cure epoxy primer suitable for use on broad area trucks, tankers, trailers, ute trays and horse floats suitable as a base for Protec 2-pack topcoats such as 606, 625, 620, 609, and 604.

Suitable Substrates
472 Rapid Epoxy Primer can be applied over correctly prepared bare steel surfaces, fiberglass, zinc coated steel, aluminium, polyester fillers and baked acrylic enamel.
  - It is not to be applied over acrylic lacquer, lacquer primer and putty or similar solvent sensitive coatings.

Preparation of Substrate
Existing paint should be sanded with P320 grade sandpaper.
Bare metal should be degreased with R123 Wax and Grease Remover then thoroughly sanded by mechanical means.
Fiberglass surfaces should be sanded with P320 grade paper.
Heavily rusted surfaces should be abrasively blast cleaned. NOTE: If abrasive blasting is necessary EX-428 Epoxy primer should be used.
Bare aluminium and zinc coated steel should be thoroughly abraded with a nylon abrasive pad.

Please note: Substrates other than those stated should be tested before use, to ensure that the performance of the product is suitable for the intended use.

Cleaning: Before and after any sanding operation, the substrate must be thoroughly degreased with Protec R123 Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax, etc.
Application Guide:

Mixing ratio: By volume:

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<tr>
<th>472-5158 pack “A”</th>
<th>100 parts</th>
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<tbody>
<tr>
<td>472-9077 pack “B”</td>
<td>100 parts</td>
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Thinning is not necessary

Spraygun Setup:

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<th>Conventional</th>
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<td>Suction</td>
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Spray Pressure:

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<th>45-65 psi</th>
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<td>350 - 450 kPa</td>
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Application:

| 1-2 full, wet, even coats allowing flash-off between coats. |

Flash Off Time:

| 3-5 minutes between coats @ 25 °C. (dependant of film build) |

Drying Times:

| Dust Free 5-10 minutes |
| Denib: 30 minutes |

Air Dry Only:

| Topcoat: 30 minutes |
| Wet on Wet application 30 minutes |

NOTE: If left longer than 4 hours, thoroughly sand entire surface.

Recoat:

Can be recoated with most Protec 2-pack topcoats after ½ hour drying at 25°C and 60% relative Humidity as a wet on wet application.
Performance Guidelines

- Drying times will vary dependent on temperature, flash off between coats, number of coats used.
- Is suitable for brush application on small areas.
- Volume Solids – 30.8%
- Recommended film Build: 30-40 microns
- For clean up use R202 Epoxy Reducer

Health and Safety

Please refer to Material Health and Safety Datasheets 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 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 20°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.