
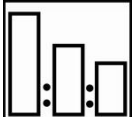
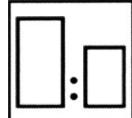


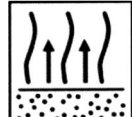





	North America	Technical Data Sheet
	<b>Primer Surfacer EP II™</b>	
<b>FOR PROFESSIONAL USE ONLY</b>		

**Description**

Primer Surfacer EP II is a gray, 4.6 lbs/gal, chromate-free epoxy primer that can be applied as a sprayable sanding surfacer, rollable sanding surfacer or primer sealer. This product provides good adhesion and corrosion resistance properties on all substrates. It can be used on both new panels and repair jobs.

**Sanding Application**


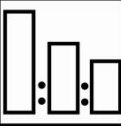



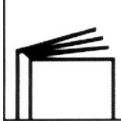
	<b>Safety Considerations</b> Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
 #12 Green	<b>100</b> <b>50</b> <b>40</b>	<b>Sprayable Mixture</b> Primer Surfacer EP II Primer Surfacer EP II Hardener High Performance Reducers
 #1	<b>100</b> <b>50</b>	<b>Rollable Mixture</b> Primer Surfacer EP II Primer Surfacer EP II Hardener
	<b>HVLP or Compliant Spray-Gun Set-Up:</b>  1.5-1.7 mm	<b>Application Air Pressure:</b> 25-32 psi (1.7-2.2 bar) at air inlet HVLP – 10 psi at the air cap maximum. Consult spray gun manufacturers' specifications.
	<b>Application</b> 1-3 coats	
	<b>Flash Between Coats at 70°F (21°C)</b>  5-10 minutes	<b>Flash Before Force Drying at 70°F (21°C)</b>  5-10 minutes
	<b>Air Drying at 70°F (21°C)</b> Three coat application 8 hours	<b>Force Drying at 140°F (60°C)</b> 45 minutes
	Final sanding step #P220 - #P320	
	Recoatable with all Sikkens primers, Autobase Plus and Autowave.	

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**Non-Sanding Application**

	<b>Safety Considerations</b> Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.	
 #2 Blue	<b>Mixing</b> <b>100</b> <b>50</b> <b>50</b>	Primer Surfacer EP II Primer Surfacer EP II Hardener High Performance Reducer Fast and Medium Only
	<b>HVLP or Compliant Spray-Gun Set-Up:</b>  1.3-1.8 mm	<b>Application Air Pressure:</b> 25-32 psi (1.7-2.2 bar) at air inlet HVLP – 10 psi at the air cap maximum. Consult spray gun manufacturers' specifications.
	<b>Application</b> 1 coats	
	<b>Air Drying at 70°F (21°C)</b> 45 minutes Must recoat within 48 hours	<b>Force Drying at 140°F (60°C)</b> 15 minutes
	Recoatable with all Sikkens urethane primers, Autobase Plus and Autowave.	

Read complete TDS for detailed product information.

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### Description

Primer Surfacer EP II is a gray, 4.6 lbs/gal, chromate-free epoxy primer that can be applied as a sprayable sanding surfacer, rollable sanding surfacer or primer sealer. This product provides good adhesion and corrosion resistance properties on all substrates. It can be used on both new panels and repair jobs.

### Suitable Substrates

- |  |  |
|--|--|
| <ul style="list-style-type: none"> <li>• Steel</li> <li>• Galvanized steel</li> <li>• Zinc coated steel</li> <li>• Aluminum</li> <li>• Direct application on cleaned OEM e-coat</li> </ul> | <ul style="list-style-type: none"> <li>• Existing finishes with the exception of soft thermoplastic acrylic finishes</li> <li>• Glass reinforced polyester laminates</li> <li>• Sikkens polyester putties and Polysurfacer</li> <li>• Wood</li> <li>• AutoPrep Pretreatment wipes</li> </ul> |
|--|--|

Primer Surfacer EP II will provide adequate adhesion and corrosion protection on steel, zinc coated steel and aluminum. Due to the many different kinds of aluminum it is not possible to guarantee all types as suitable substrate.

Do not apply apply Primer Surfacer EP II directly over Sikkens Washprimer.

Primer Surfacer EP II should only be applied on hard plastic substrates which have been preceded by Primer PO.

Do not apply to thermoplastics i.e. Deformable with heat.

### Products and Additives

<b>Product</b>	Primer Surfacer EP II	Item #547651
<b>Hardeners</b>	Primer Surfacer EP II Hardener	Item #547650
<b>Reducers</b>	Sikkens High Performance Reducer Fast -Spot and panel repairs, temperature range 60°F – 75°F (16°C – 24°C)	#391059 (Gal) # 553636 (Qt)
	Sikkens High Performance Reducer Medium -Spot and panel repairs and large areas temperature range 70°F – 85°F (20°C – 30°C)	#391062 (Gal) # 553637 (Qt)



**Primer Surfacer EP II™**

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	<p>Sikkens High Performance Reducer Slow -Larger areas and complete jobs temperature range 80°F – 95°F (27°C – 35°C) *Cannot be used with sealer mixture</p>	<p>#391064 (Gal) # 553638 (Qt)</p>
	<p>Sikkens High Performance Reducer Extra Slow -Specially developed reducer which can be used for extremely hot temperatures above 95°F (35°C) *Cannot be used with sealer mixture</p>	<p>#391066 (Gal) #553635 (Qt)</p>
	<p>*Item numbers are provided for 1 gallon containers. Additional container sizes are available.</p>	

**Basic Raw Materials**

- Primer Surfacer EP II – Epoxy resins
- Primer Surfacer EP II Hardener – Amine resin
- High Performance Reducers – Specialized solvent blends

**Substrate Preparation**

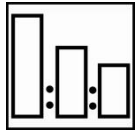
	<p><b>Pre-Cleaning</b></p>	<ul style="list-style-type: none"> <li>• If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.</li> <li>• Clean with Sikkens M600 or AutoPrep Ultra Prep Surface Cleaner.</li> <li>• Avoid saturating body filler with water or cleaners while washing the repair.</li> </ul>																																				
	<p><b>Sanding Preparation</b></p>	<table border="1" style="width: 100%;"> <thead> <tr> <th></th> <th style="text-align: center;">Dry Sanding</th> <th></th> <th></th> </tr> </thead> <tbody> <tr> <td>Existing Finishes</td> <td>#P220 to #P360</td> <td></td> <td></td> </tr> <tr> <td>OEM E-Coat</td> <td>Not Required</td> <td></td> <td></td> </tr> <tr> <td>Polyester Bodyfiller</td> <td>#P180 to #P220</td> <td></td> <td></td> </tr> <tr> <td>Steel</td> <td>#P80 then #P120</td> <td></td> <td></td> </tr> <tr> <td>Galvanized Steel</td> <td>#P120 to #P180</td> <td></td> <td></td> </tr> <tr> <td>Aluminum</td> <td>#P180 or Red Scuff Pad</td> <td></td> <td></td> </tr> <tr> <td>Gel-Coat</td> <td>#P220 to #P360</td> <td></td> <td></td> </tr> <tr> <td></td> <td></td> <td></td> <td></td> </tr> </tbody> </table>		Dry Sanding			Existing Finishes	#P220 to #P360			OEM E-Coat	Not Required			Polyester Bodyfiller	#P180 to #P220			Steel	#P80 then #P120			Galvanized Steel	#P120 to #P180			Aluminum	#P180 or Red Scuff Pad			Gel-Coat	#P220 to #P360						
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	<p><b>Surface Cleaning – Prior to Paint Application</b></p>	<ul style="list-style-type: none"> <li>• Clean with Sikkens M600 or AutoPrep Ultra Prep Surface Cleaner.</li> </ul>																																				

**Primer Surfacer EP II™**Primer  
03/30/2017**FOR PROFESSIONAL USE ONLY****Product Agitation****Stirring**

- Stir Primer Surfacer EP II thoroughly before mixing.

**Mixing Colors**

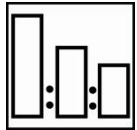
- Primer Surfacer EP II can tinted with Autocoat BT LV650 toners by adding up to 5% by volume to the primer. After adding the toner, mix the color thoroughly before adding the hardener.
- Primer Surfacer EP II cannot be tinted with Autobase Plus or Autowave toners.

**Mixing – Sprayable Sanding Mixture**

#12 Green

**Mixing**  
100  
50  
40

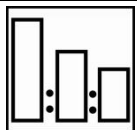
Primer Surfacer EP II  
Primer Surfacer EP II Hardener  
High Performance Reducers

**Mixing – Rollable Sanding Mixture**

#12 Green

**Mixing**  
100  
50

Primer Surfacer EP II  
Primer Surfacer EP II Hardener

**Mixing – Non Sanding**

#2 Blue

**Mixing**  
100  
50  
50

Primer Surfacer EP II  
Primer Surfacer EP II Hardener  
High Performance Reducer Fast and Medium only

**Mixing – Flexible Parts**


Primer Surfacer EP II cannot be flexed, therefore, the addition of Elast-O-Actif is not allowed. Application only on rigid parts is recommended. All raw plastic should be pre-coated with Primer PO prior to the application of Primer Surfacer EP II.

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**Pot-Life When Mixed**


<b>Product Mix</b>	<b>70°F (21°C)</b>
Sanding mixture	4 hours
Non-sanding mixture	6 hours

**Spray Gun Set-Up**

	<b>Consult spray gun manufactures instructions for specific spray gun pressure specifications.</b>		
	<b>Spray Gun</b>	<b>Fluid Tip</b>	<b>Application Pressure</b>
	<b>Sanding Mixture Gravity Fed</b>	1.5-1.7 mm	25-32 psi (1.7-2.2 bar) at the spray gun inlet Max 8-10 psi (0.6-0.7 bar) at cap
	<b>Non-Sanding Mixture Gravity Fed</b>	1.3-1.8 mm	25-32 psi (1.7-2.2 bar) at the spray gun inlet Max 8-10 psi (0.6-0.7 bar) at cap

**Application**

	<p><b>Sanding Mixture Application:</b> Apply one coat over the total sanded area. Next apply the 2nd and 3rd coat within each preceding coat. Where a full panel application is required apply 2-3 coats over the total panel dependent on the required film build.</p> <p>Allow each coat to flash off naturally until the surface is completely matt; this also supports to achieve higher film build. Do not force-dry by air support. Flash-off between the coats is dependent on ambient temperature, applied layer thickness and airflow. For maximum build use a large fluid tip and lower application pressure.</p> <p><b>Non-Sanding Application:</b> Apply one full coat.</p>
	<p><b>Rollable Application:</b> If Primer Surfacer EP II will be applied by brush or roller, mix the Primer Surfacer EP II only with Primer Surfacer EP II Hardener, do not add Reducer.</p> <p>Apply one light coat over the total sanded area. Next apply the 2<sup>nd</sup> and 3<sup>rd</sup> coat within each preceding coat. Where a full panel application is required, apply 2-3 coats over the total panel. Use the edge of the roller to prime awkward areas such as door handles. Finally, squeeze remaining paint from roller and smooth off the repair. The rolling should be executed from the outside in and inward direction. Each additional coat should be started within the preceding coat area.</p>
	<p><b>Roller Type:</b> To achieve the smoothest, rolled film, a 3 inch foam roller with rounded ends is recommended. These can be found at many hardware and big box stores for purchase.</p>


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**Film Thickness – Using Suitable Application**


Sanding Mixture	1.2-1.4 mils (30-35 µm) per coat Maximum total filmbuild of 3.5-4.1 mils (90-105 µm)
Non-sanding Mixture	1.0-1.2 mils (25-30 µm) per coat

**Drying / Curing Time**



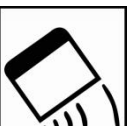

Drying times are stated a recommended application method, film thickness and object temperature.

		70°F (21°C)	100°F (40°C)	140°F (60°C)
	<b>Sanding mixture</b>	8 hours	2 hours	45 minutes
	<b>Non-sanding mixture</b>	45 minutes		15 minutes

Primer Surfacer EP II must be recoated within 48 hours at 70°F (21°C).

	<p>Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).</p> <ul style="list-style-type: none"> <li>· Allow 5 minute flash off before infra-red curing.</li> <li>· Cure 5 minutes on low power followed directly by a 10 minute full power cure.</li> </ul>
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**Drying / Curing Time when using polyester bodyfiller**

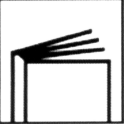
	<p>Drying time is related to recommended application of maximum 1 coat (+/- 1 mil) Primer Surfacer EP II.</p>
	<p>Drying / Curing with short wave light IR equipment and a surface distance of 20 – 27 inches (50 – 70cm). The object temperature must not reach a temperature above 212°F (100°C).</p> <ul style="list-style-type: none"> <li>· Allow 5 minute flash off before infra-red curing.</li> <li>· Cure 5 minutes on low power followed directly by a 10 minute full power cure.</li> </ul>
	<p>Polyester bodyfiller application Abrade the Primer Surfacer EP II surface after curing with minimum P220 for optimum adhesion. Polysurfacer; follow similar procedure as with polyester bodyfiller.</p>
	<p>Surface cleaning; remove any surface contamination prior to the application of any primer surfacer using an appropriate surface cleaner. Where bodyfiller is exposed, avoid contact with water (e.g. waterborne degreaser).</p>

**Sanding / De-Nibbing**


	<p>Final sanding step in case of any primer filler/surfacer application; P320 Initial sanding steps may be executed with a coarser sanding grit; P220 Respect a maximum 100 sanding grit step difference or less throughout the sanding procedure.</p>
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### Recoating

	Primer Surfacer EP II can be recoated with all Sikkens primers, Autowave and Autobase Plus.
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### Cleaning of Equipment

	Clean equipment following local and federal regulations using Sikkens Cleaning Solvent or high quality lacquer thinner.
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### Theoretical Coverage

	Theoretical coverage is dependent of many factors. These may include; the shape of the object, surface smoothness, application technique and other application variables among others. <ul style="list-style-type: none"> <li>• Sanding mixture: 631 Sq ft / gallon (15.5 M<sup>2</sup> / liter)</li> <li>• Non-sanding mixture: 603 Sq ft / gallon (14.8 M<sup>2</sup> / liter)</li> </ul>
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### VOC / Regulatory Information

	Primer Surfacer EP II ready to spray mixtures:
	Sanding mix at 100:50:40                      4.45 lbs/gal (533 g/L)
	Non sanding mix at 100:50:50 with Fast or Medium Reducer                      4.59 lbs/gal (550 g/L)
	Brushing mix at 100:50                      3.6 lbs/gal (434 g/L)

### Product Storage

	Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).	
	Primer Surfacer EP II	18 months
	Primer Surfacer EP II Hardener	1 year
	High Performance Reducers	4 years

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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