



**HiChem Industries Pty Ltd.**  
73 Hallam South Road Hallam, Vic 3803  
Telephone (03) 9796 3400  
Facsimile (03) 9796 4500  
ACN 006-542-767



## PRODUCT INFORMATION SHEET

G:\SECURE\Product Information\INDUST\2PEP 41 25-10-05.DOC

# 2 PACK EPOXY PRIMER

### Description:

*HiChem 2 Pack Epoxy Primer* is a high performance, high build, sandable epoxy primer exhibiting excellent resistance to a wide range of chemicals.

### Uses:

*2 Pack Epoxy Primer 4:1* is intended for use both for structural maintenance and new building construction projects. Typically used on steel structures, industrial equipment and machinery such as found in manufacturing, automotive and chemical plants, hospitals, food processing plants, dairies, and abattoirs. It is specifically designed for use in aggressive environments. (Not recommended for immersed condition.) Consult HiChem for specific recommendations.

It may be applied to a variety of correctly prepared metal surfaces such as steel, aluminium and galvanised steel. It can be applied as a primer for a range of two pack topcoats.

### Properties:

- Excellent surfacing and sanding properties
- Fast cure to sanding time.
- Isocyanate-Free.
- Suitable under acrylic urethane, polyester urethane, epoxy and isocyanate free two pack topcoats..
- Excellent abrasion resistance.
- Excellent chemical resistance.
- Excellent adhesion to a variety of surfaces.
- Excellent corrosion resistance.

### Surface Preparation:

Steel: Abrasive blast clean the steel to AS 1627.4 class 2.5 minimum. Where blast cleaning is not practical use power tool cleaning. eg wire wheel or grinding.

Galvanised Steel and aluminium: Thoroughly clean and degrease with *Prepwash*. Abrade with coarse abrasive pad such. Clean again with *Prepwash*. In the case of aluminium, *2 Pack Epoxy Primer* must be applied no later than 3 hours after abrading.

### Application:

Stir the base paint thoroughly to obtain a smooth texture, before addition of hardener..

Mix 4 parts by volume of *2 Pack Epoxy Primer* with 1 part by volume of *2 Pack Epoxy Hardener*.

Thin before application, if required, with up to 20% by volume *2 Pack Thinners Fast (2PTF)*, *Normal (2PTN)*, or *Slow (2PTS)*.

Apply 1-2 double header coats as required. Allow flash off time of 10 minutes between coats. Two double header coats will achieve 75-100 microns dry film thickness.

Use conventional or airless spraying equipment. Brush may be used for smaller areas.

### Drying :

At 20°C for 75 micron dry film thickness (DFT): Touch dry at 3 hours. Dry to sand at 8 hours.

At 25°C for 75 micron dry film thickness (DFT): Touch dry at 2 hours. Dry to sand at 6 hours.

**Recoat Times:**

At 25<sup>0</sup>C for 75 micron DFT

With itself: minimum drying time overnight, maximum 1 week.

With topcoats: minimum drying time 2 hours, maximum 48 hours.

Note: If recoating after the maximum sand the cured film and reapply a thin coat (25-50 micron) of 2 Pack Epoxy Primer before proceeding.

**Coverage Rate (Theoretical):**

22 square metres per litre at 25 microns dry film thickness.

**Potlife:**

8 hours at 20<sup>0</sup>C. 6 hours at 25<sup>0</sup>C Shorter at higher temperatures

**Clean up:**

Use *Superglow Multipurpose Thinners*.

**Storage:**

Store unopened containers in a cool dry place. Keep tightly sealed.

**Safety:**

See material safety data sheet.

**Standard Packages and Product Codes:**

<b>Component</b>	<b>Size</b>	<b>Product Code</b>
2 Pack Epoxy Primer	20 litre	2PEP20
2 Pack Epoxy Primer	4 litre	2PEP4
2 Pack Epoxy Hardener	5 litre	2PEH5
2 Pack Epoxy Hardener	1 litre	2PEH1

*The information contained in the bulletin is presented in good faith based on thorough field and laboratory testing but without warranty. It is recommended that all products be tested by the end user to ensure the suitability of the product for particular application under the user-factory conditions.*