

# **DUREPON®** Sandable Primer

# Non Inhibitive Sandable Epoxy Primer

**PC 203** 

**FEATURES** 

- NON TOXIC PIGMENTATION
- **EXCELLENT SANDING PROPERTIES**

EXCELLENT ADHESION PROPERTIES FOR A WIDE RANGE OF SUBSTRATES

**USES** 

DUREPON® Sandable Primer is recommended on non-ferrous metals, hardwood and MDF as the primer or intermediate coat for high performance epoxy, polyurethane and enamels topcoats where a high quality finish is required.

#### **SPECIFICATIONS**

#### **RESISTANCE GUIDE**

**HEAT RESISTANCE** Up to 120°C dry heat.

**WEATHERABILITY** Epoxy coatings may yellow with time.

On exterior exposure some chalking may also occur. This will not detract from the protective properties of the

coating. Use a weatherable topcoat if required for appearance.

**SOLVENTS** Resists splash and spillage of most hydrocarbon solvents, refined

petroleum products and most common

alcohols.

**ACIDS** Suitable for splash and spillage

exposure to solutions weak

inorganic acids.

**ALKALIS** Excellent resistance to splash and spillage

of most common alkalis.

**SALTS** Excellent resistance to neutral and alkali

salts.

**WATER** Excellent resistance to fresh and salt water

when suitably topcoated. Not suitable for

immersion.

**ABRASION** Excellent when fully cured.

# TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack sandable epoxy primer	APPLICATION CONDITIONS	i	Min	Max
FINISH COLOUR	Low Gloss White			10°C 10°C	45°C 45°C 85%
COMPONENTS SOLIDS BY VOLUME	Two 52%				
VOC LEVEL	<450 g/L		Min	Max	Recom.
FLASH POINT	4°C mixed	Wet film per coat (microns)	100	145	120
POT LIFE	8 hours (4L, 25°C)	Dry film per coat (microns)	50	75	60
MIXING RATIO (V/V)	Part A: 4 Part B: 1	SUITABLE SUBSTRATES	Prepared polye	ster comp	osite,
		I			

**THINNER** Not Required

PRODUCT CODE 410-89796 White Part A

976-89797 Hardener

MDF, aluminium and most non-

ferrous metals.

Single and two pack products **TOPCOATS** 

Brush, roller, conventional or **APPLICATION METHODS** airless spray.

### Drying characteristics at 60 microns dry film thickness

						Ove	ercoat	
_	Temperature	Humidity	Touch	Handle	Full Cure	Min	Max*	
	25° C	50%	30 Min	90 Min	7 Days	8 Hours	1 Week	

These figures are given as a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying. For the best results it is recommended that this coating is sanded approximately 2 - 4 hours after initial application, this is dependent on climatic conditions and coating thickness. As with all two-pack sanding primers the longer the coating is left before sanding it will continue to harden and therefore the ease of sanding will be affected.

NOTE - Thinning is not recommended. Addition of thinner will substantially delay drying and sandability

TYPICAL SPREADING RATE AT RECOMMENDED DRY FILM BUILD

A spreading rate of 8.6 sq. metres per litre corresponds to 60 microns dry film thickness assuming no losses. Practical spreading rates will vary depending on such factors as method and conditions of application and surface roughness.

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<sup>\*</sup> If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

# **DUREPON®** Sandable Primer

PREPARATION GUIDE

## **TYPICAL SYSTEMS**

**SURFACE** 

(The typical systems are offered as a guide only and are not to be used as a specification. It is recommended that the specific needs of a project be discussed with a Dulux Protective Coatings Consultant.)

**SYSTEM** 

**DRY FILM THICKNESS** 

SURFACE	PREPAR A	ATION GUIDE		SYSTEM	DRY FILM THICKNESS		
STEEL	Abrasive blast AS1627.4 Class 2.5		1st Coat 2nd Coat 3rd Coat	DUREMAX® GPE ZP DUREPON® Sandable Primer LUXATHANE® R	75 Microns 60 Microns 50 Microns		
	Sand and dust down before and after first coat.		1st Coat 2nd Coat	DUREPON® Sandable Primer QUANTUM® FX QUANTUM® Clearcoat	60 Microns 55 Microns 45 Microns		
			1st Coat 2nd Coat	DUREPON® Sandable Primer EPIGLOSS® 4 Finish	60 Microns 50 Microns		
ALUMINIUM	Clean, degrease and abrade surface		1st Coat 2nd Coat 3rd Coat	DUREPON® Sandable Primer LUXATHANE® R LUXATHANE® R	60 Microns 50 Microns 50 Microns		
SURFACE PREPA	RATION	for the primer selected. The materials. Not recommended MDF and hardwood: Sand the Non ferrous metals: Round of the Non ferrous metals.	primer surfact of for direct aphoroughly and off all rough was accordance	remove all dust. welds, sharp edges and remove wel with AS1627.1. Abrade the surface	and other loosely adhering d spatter. Remove grease,		
APPLICATION				s are uniform. Use of a power mixe y using a power mixer and allow to s			
BRUSH/ROLLER		coats may be required to atta		to the prepared surface. When brustied thickness.	shing and rolling additional		
CONVENTIONAL S	SPKAY	Thinning NOT Required.  Typical Set-up  Graco Delta Gun:  Pressure at Pot:  Pressure at Gun:	70-100	(239542) kPa (10-15 p.s.i.) J kPa (55-60 p.s.i.)			
AIRLESS SPRAY				as a Graco 30:1 President with a fluivering 550-690 kPa (80-100 p.s.i.) a			
conditions may nearest Dulux® parameters state mixed material r dependent upon humidity above		conditions may require varianearest Dulux® representation parameters stated in this dimixed material must not be dependent upon temperatu humidity above 85% or will	lustrial product designed for use by experienced Protective Coating applicators. Where y require variation from the recommendations on this Product Data Sheet contact your representative for advice prior to painting. Do not apply in conditions outside the ated in this document without the express written consent of Dulux® Australia. Freshly I must not be added to material that has been mixed for some time. The rate of cure is on temperature. Do not apply at temperatures below 10°C. Do not apply at relative re 85% or when the surface is less than 3°C above the dewpoint. Thinning is not addition of thinner will substantially delay drying and sandability.				
CLEAN UP Clean all equipment		Clean all equipment with Dul	lux® Epoxy Th	ninner (920-08925) immediately after	use.		
OVERCOATING		'X' cut or cross-hatch method contaminants. High-pressure	ds. If it lifts, re water wash	y a method appropriate for the coating emove it. The surface must be free of at 8.3 to 10.3 MPa (1,200 - 1,500 p.s e required depending on surface con	foil, grease and other s.i.) to remove loosely		
SAFETY PRECAU STORAGE	TIONS	Store as required for a flamn	nable liquid C	Sheet and any precautionary label lass 3 in a bunded area under cover n. Keep containers closed at all times	. Store in well-ventilated		
HANDLING As go ris		As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.					
USING		Use with good ventilation and mists exists, wear combined	d avoid inhalation of spray mists and fumes. If risk of inhalation of spray organic vapour/particulate respirator. When spray painting, users should f the respective State Spray Painting Regulations.				
FLAMMABILITY This product is flammable. NOT SMOKE. Fight fire with			All sources of ignition must be eliminated in, or near the working area. DO n foam, CO <sub>2</sub> or dry chemical powder. On burning will emit toxic fumes. welding surfaces coated with this paint. Grind off coating before welding.				
		, word initial and it of furites if v	Tolding Sunat	200 Coatou With this paint. Office Off	saming boloto wolding.		

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