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Date Issued: 28 July, 2014

2PK PRIMER

Product Line: Part 'A': 7199. Part 'B': 72.

Product Code: Part 'A': 719904, 719920. Part 'B': 7201, 7205.

Description:

A two-pack polyamide cured epoxy coating designed as a high performance primer for use on clean ferrous metal, appropriately primed non-ferrous metals, prepared concrete or as an intermediate coat in a chemical resistant polyurethane coating system such as 2PK Polyurethane and 2PK Iso-free Acrylic.

Features

- Excellent adhesion to clean ferrous surfaces
- Buff colour for easy application and subsequent top-coating with bright colours
- Easy mix ratio
- User friendly in application

Surface Preparation

Surfaces must be clean, dry and free of all contamination.

Ferrous metals:

Surfaces must be clean, dry and free of all contamination including corrosion. Surfaces should ideally be grit blasted to AS1627.4 Class 2.5 or power tool cleaned to AS1627.2.

Non-ferrous metals:

Surfaces must be clean, dry and free of all contamination including corrosion. Degrease metals with Wax and Grease Remover or other approved product. Coat surfaces with Superlux Etch Primer – refer Technical Data Sheet for application details and re-coat times.

Concrete:

Concrete must be cured for 28 days prior to coating. All curing membranes and bond-breakers must be removed. Concrete to be free of loose particles, laitance and acid etched or lightly grit blasted.

Mixing Instructions

Stir each part thoroughly until uniform in colour and consistency.

The mix ratio is 3 parts by volume of 2PK Primer Part 'A' to 1 part by volume of 2Pk Primer Part 'B'. The packs as supplied are pre-measured for full kit mixing.

Mix the pre-measured two parts thoroughly after adding.

Allow the mixed product to stand for 10 minutes prior to using.

Application

2PK Primer is designed to be applied by spray. No thinning is generally required for pressure pot application or airless spray application. 2PK Primer may require slight thinning with Polyurethane Thinner for suction cup spray. Brush or roller application should be confined essentially to touch-up or small areas.

Airless spray: use tip orifice 0.012" to 0.013". Apply at 14 – 15 MPa atomising pressure.

Conventional high pressure spray: use 40 – 65 psi (280 – 450 kPa) air pressure. Pot pressure to suit spray gun set-up.

Do NOT apply 2PK Primer to substrates below 12°C or when the substrate temperature is expected to fall below 12°C during the drying stages. Do NOT apply 2PK Primer above 85% relative humidity.



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Typical recommended coating systems

Surface	Classification	Preparation	System		Dry Film Thickness	Recoat
Structural Steel	Premium system	Abrasive blast clean to AS1627.4 Class 2.5	First Coat Top Coat	2PK Primer 2PK Topcoat *	50 – 75 µm 30 – 35 µm	Min 16 hrs
Mild Steel	Premium system	Remove rust, clean and degrease with Wax & Grease Remover	First Coat Top Coat	2PK Primer 2PK Topcoat *	50 – 75 µm 30 – 35 µm	Min 16 hrs
Galvanised, zinc coated steel and aluminium	Premium system	Clean and degrease with Wax & Grease Remover. Lightly abrade aluminium with a nylon scourer.	First Coat Second Coat Top Coat	Etch Primer 2PK Primer 2PK Topcoat *	5 – 10 µm 40 – 60 µm 30 – 35 µm	Min 2 hrs Min 16 hrs

* Topcoat could be either 2PK Polyurethane or 2PK Acrylic
 Thin/cleanup Etch Primer with Etch Primer Thinners.
 Thin/ cleanup 2 PK Primer, 2 PK Polyurethane and 2 PK Acrylic with Polyurethane Thinners.
 Refer individual Technical Data Sheets/ MSDS for specific product above.

Cleaner

Use Polyurethane Thinner. Thoroughly clean all equipment promptly after use. Dried or cured material is difficult to remove.

Coverage

Approximately 8.5 square metres per litre to achieve 50 microns dry film thickness.

Solids

By weight: approximately 63%
 By volume: approximately 42%

Drying

Touch dry*: approximately 1 - 2hours
 Hard dry*: 16 hours.
 Recoat*: 16 hours

* At 25°C, 50% relative humidity and film thickness equivalent to 50 microns dry.
 Fully cured at around 7 days dependent on ambient temperatures. Curing below 15°C is slow.

Pot Life: Approximately 6 hours at 25°C.

Resistance Properties

Abrasion: Excellent
 Heat: Up to 120°C dry heat
 Solvent: Excellent
 Oil: Excellent
 Chemical: Alkali – excellent
 Acid – limited
 Solvents – very good
 Durability: Excellent when top coated.
 VOC (mixed, no thinning) 475 grams/ litre

Precautions

- 2PK Primer is a two pack product; and Part 'A' and Part 'B' must be mixed in the specified proportions prior to use.
- 2PK Primer contains flammable solvents. Keep away from heat and open flame.
- When applying in confined areas use an airline respirator.
- In common with other organic solutions, 2PK Primer should not be allowed to remain on the skin and normal hygiene standards should be observed when using this product.
- Refer the MSDS's for both the 2PK Primer Part 'A' and 2PK Primer Part 'B' prior to use.