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Date Issued: 06 November 2023

2PK PRIMER

Product Line: Part 'A': 7197, 7198, 7199. Part 'B': 72.

Product Code: Part 'A': 71XX04, 71XX20, where XX stands for colour. Part 'B': 7201, 7204.

Description

A Two-pack polyamide cured general-purpose epoxy primer designed as a high-performance primer/intermediate coat for use on properly prepared ferrous and non-ferrous metals, concrete and other masonry substrates.

Features

- Excellent adhesion to wide range of properly prepared surfaces
- Available in grey for ease of application of subsequent topcoats with bright colours
- Can be over-coated with a wide range of products
- Easy mix ratio
- Easy application by brush, roller or spray

Surface Preparation

Surfaces must be clean, dry and free from 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.

Where added film build on metal surfaces is required, apply 2-3 wet on wet, even coats. Allow flash off time of 10 – 15 minutes between coats at 25°C.

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	Preparation	System	Dry Film Thickness µm	Recoat
Structural Steel	Abrasive blast clean to AS1627.4 Class 2.5	First Coat 2PK Primer Topcoat* 2PK Topcoat* 2PK	50 – 75 30 – 35	Min 16 hrs
Mild Steel	Remove rust, clean and degrease with Wax & Grease Remover	First Coat 2PK Primer Topcoat* 2PK Topcoat* 2PK	50 – 75 30 – 35	Min 16 hrs
Galvanised, zinc coated steel and aluminium	Clean and degrease with Wax & Grease Remover. Lightly abrade aluminium with a nylon scourer.	First Coat Etch Primer Second Coat 2PK Primer Topcoat* 2PK Topcoat* 2PK	5 – 10 40 – 60 30 – 35	Min 2 hrs Min 16 hrs
Concrete	Ensure full cure. Efflorescence or release agent or any other dust must be fully removed. The concrete must be thoroughly clean & dry.	First Coat 2PK Primer Second Coat 2PK Primer Usual No. of Coats 1-2 (dependant on substrate porosity etc.) Topcoat* 2PK Topcoat* 2PK	75-100 75-100 30- 35	

*Topcoat 2PK Acrylic Polyurethane
 Thin/cleanup Etch Primer with Etch Primer Thinner.
 Thin/ cleanup 2 PK Primer and 2 PK Acrylic Polyurethane with Polyurethane Thinner.
 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.



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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 SDS's for both the 2PK Primer Part 'A' and 2PK Primer Part 'B' prior to use.