



# Technical Data Sheet

## Automotive Art Epoxy Primer LV 45-96



### General Information:

Automotive Art Epoxy Primer 2.1 VOC 45-96 provides excellent adhesion and corrosion resistance for properly prepared substrates such as steel, aluminum, fiberglass and rigid plastics. It can also be used as a sealer and can be refinished with any Automotive Art Top Coat.

### Substrates:

Apply on top of properly cleaned and treated bare steel, galvanized steel and Aluminum, OEM Finishes, body fillers, plastic adhesion promoters, wash primers or epoxy primers.

### Mixing Ratio:



<b>2:1 Primer Filler</b>	<b>2:1 + 25% Sealer</b>	<b>Part #</b>
<b>100%</b> by vol. Primer	<b>100%</b> by vol. Primer	45-96
<b>25%</b> by vol. Epoxy Hardener	<b>50%</b> by vol. Epoxy Hardener	30-36
No reducer required	<b>25%</b> by vol. Reducer	35-series

**Pot Life:** 8 hours at 20°C (68°F)

### Additives:



Not recommended.

### Air Pressure and Spray gun Setup:

	<u><b>Air Pressure</b></u>	<u><b>Nozzle Size</b></u>	
		<b>Primer Filler</b>	<b>Sealer</b>
<b>HVLP:</b>	21-29 psi (1.4-2.0 bar)	1.8 mm	1.3-1.4 mm
<b>Conventional:</b>	45-60 psi (3-4 bar)	1.8 mm	1.3-1.4 mm

Note: For best overall result, refer to spray gun manufacturer's recommendations.

### Application:



<b>Primer Filler:</b>	2-3 full coats
<b>Adhesion Promoter</b>	1 medium wet coat (wet on wet)
<b>Coat Thickness:</b>	1.5 – 3 mil (40 - 80 µm)

### Drying Times:



**Between Coats:** 10-15 minutes at 20°C (68°F)



At 20°C (68°F)	<u><b>Primer Filler</b></u>	<u><b>Adhesion Promoter</b></u>
<b>To Sand:</b>	8 hours	
<b>To Topcoat:</b>		45 min

### Surface Preparation:



- Remove all loose material and rust either by sanding or media blast.
- Clean surface with 20-95 Wax & grease remover.
- For bare steel please use P 80 - P180
- For Aluminum and softer substrates P 180 – P240

### Sanding:



P 400-800 Wet  
P 320-800 Dry by hand or D.A sander

### Packing & Shelf Life:

**Sizes:** 1L  
**Shelf life:** Under normal storage conditions minimum two years (unopened tins).

### Notes:

- Stir thoroughly
- Do not use on aluminum parts which are subject to movement or apply on riveted aluminium
- Do not use on anodized aluminum
- Do not attempt to treat corrosion with Automotive Art Epoxy Primer 45-96, first remove all lose material by sanding or media blast
- Do not use over flexible plastic parts or solvent sensitive paint finishes



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### Technical Data:

Volume Ratio	2:1	2:1+25%
Specific Gravity:	1.41 kg/l	1.41 kg/l
Flash Point:	15°C, (59°F)	15°C, (59°F)
Solids Vol %:	50%	50%
Solids Wt. %:	NA	NA
Coverage:	8-10 m <sup>2</sup> /L (per layer 50 µm )	8-10 m <sup>2</sup> /L (per layer 50 µm )
Viscosity DINCUP 4mm/20°C:	16 - 22 sec. Cup DIN 4	16 - 22 sec. Cup DIN 4
Gloss:	Matt	Matt
Color:	Grey	Grey
V.O.C. Actual:	196 g/l, (1.6 lbs/gal)	NA
V.O.C. Regulatory RTS (less water, less exempts):	263 g/l, (2.2 lbs/gal)	NA
V.O.C. Ready to Spray:	176 g/l, (1.5 lbs/gal)	NA
Applicable Use Category:	Primer Surfacer	Primer Sealer

See Material Safety Data Sheet and Labels for additional Safety Information and handing instructions.