

# EP Series Chromate Free Epoxy Primers

## as a Primer-Surfacer



<b>Products</b>	EP569 Gray Chromate Free Epoxy Primer EP669 White Chromate Free Epoxy Primer EP769 Black Chromate Free Epoxy Primer EP869 Red Chromate Free Epoxy Primer  851 Prep and Wash 900 Pre-Kleano 901 Pre-Paint Solvent Cleaner 910 Universal Prep Cleaner AM900 Aero-Max Pre-Kleano PA897 Epoxy Activator
<b>Cleaning</b>	See Undercoat Section - Cleaning the Vehicle Surface
<b>Pretreatments</b>	N/A
<b>Mixing Ratio</b>	<b>4:1</b>  4 parts EP Primer 1 part PA897
<b>Application</b>	2 to 3 medium wet coats 5 to 10 minutes flash between coats Apply a light guide coat. Over-reduced Diamont Basecoat of a contrasting color works well. Mix 9 parts UR reducer with 1 part Diamont Color for the guide coat or use AM210 Aero-Max Satin Black.
<b>Drying</b>	<b>20°C/68°F</b> 8 to 10 hours <b>60°C/140°F</b> 30 minutes <b>70°C/160°F</b> 20 minutes <b>Infra Red short wave</b> 10 to 13 minutes
<b>Sanding/ Polishing</b>	Wet Sand - P400 to P600 grit Dry Sand - P320 to P400 grit Remove sanding residue with 900, 901, 910 or AM900.
<b>Notes</b>	



# EP Series Chromate Free Epoxy Primers

## as a Primer-Surfacer Technical Data



### Characteristics

EP569, EP669, EP769 and EP869 Epoxy Primers offer excellent adhesion and corrosion protection when used over steel, aluminum, zinc coated or galvanized metals. EP primers can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers). EP primers must be activated with PA897 Epoxy Activator.

### Technical Data

<b>Viscosity</b>	20-22 sec. #4 Ford cup
<b>Fluid Tip (HE Gravity)</b>	1.4-1.9 mm
<b>Fluid Tip (HVLP Gravity)</b>	1.5-1.8 mm
<b>Air Pressure (HVLP/HE)</b>	6-10 psi at air cap
<b>Number of Coats</b>	2 to 3 medium wet coats
<b>Thickness</b>	2.0-2.5 mils
<b>Pot Life</b>	24 hours @ 20°C/68°F
<b>Coverage</b>	337 sq ft/gal @ 2.0 mils
<b>VOC as Applied</b>	516 gms/ltr (4.3 lbs/gal)

### Things to DO:

- Do use the appropriate NIOSH/MSHA respirator. Consult product label for details.
- Do measure the amount of activator - DO NOT ESTIMATE.
- Do wet sand with P400 to P600 grit wet sandpaper after EP primers has dried for 8 to 10 hours.
- Do use EP primers within 24 hours of being mixed.

### Things NOT to DO:

- Do not use 809 Fisheye Eliminator.
- Do not use flex agents in EP primers.
- Do not use HR5 Jet5 in EP primers.
- Do not use if shop temperature is below 15°C/60°F.
- Do not use over ANY solvent sensitive finishes such as acrylic lacquer.
- Do not use over flexible parts.