



SDE EPOXY SURFACING HIGH BUILD PRIMER

PRODUCT DESCRIPTION

SDE EPOXY SURFACING HIGH BUILD PRIMER - is a two - component primer for use as a high build surfacing primer

SPECIFICATION DATA

Volume Solids:	53% (unthinned), 42% (thinned)
Specific gravity:	1.66
Base:	Light Grey
Converter:	Dark Grey
Equipment Cleaning	SDE Thinners

THEORETICAL COVERAGE:

Application Methods	Number of Coats	Recommended per coat			Theoretical Coverage per Coat (at recommended DFT)
		225 µm 8.9 mil	95 µm 3.7 mil	105 µm 4.1 mil	
Conventional Spray Pressure Feed, Air Assisted Airmix	2				5.6 m ² /lt 227.3 ²ft/Gal

Recommended WFT is based on 20 % thinning with **SDE EPOXY Thinners**
 Minimum WFT = 200 µm and Maximum WFT = 250 µm (per Coat)
 After sanding, the minimum total DFT achieved must be 150 microns (6 mils).
 A third coat may be necessary to achieve the minimum DFT.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size and application environment.

VOC:

All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC may vary by batch and when tested via standard test methodology.

PRODUCT	AS SUPPLIED (WITHOUT REDUCER)			
	g/l	lb/gal	g/kg	lb/lb
Base	430	3.59	301	0.30
Converter	371	3.10	204	0.20
SDE Epoxy Surfacing Primer	401	3.35	207	0.21

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SURFACE PREPARATION:

The Surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary accordingly to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full scale preparation.

Product is only approved for use over approved fairing compounds. These should be sanded (finishing with P20) before application of SDE Epoxy Surfacing primer.

MIXING & REDUCTION:

Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full scale application is recommended.

Application Methods	Mix Ratio (Base:Converter)	Reducer	Recommended Thinning	Spraying Viscosity
Conventional Spray Pressure Feed	1:1 by Volume	SDE Thinners	20 %	-
Air Assisted Airmix	1:1 by Volume	SDE Thinners	10 %	-

APPLICATION:

Application equipment and parameters are given as a guide. Actual equipment choices will vary accordingly to application conditions, equipment choice/condition and other factors. Testing on a non critical area should be carried out prior to full scale application.

Product is not recommended for roll and tip application.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow rate	Air Pressure
Conventional Spray Pressure feed	1.40 – 1.80 mm 55 – 71 thou	-	225 – 250 cc/min	2.5 – 3 bar 36 – 44 psi
Air Assisted Airmix	0.48- 0.89 mm 19-35 thou	-	-	5 – 6 bar 73 – 87 psi

To minimise texture on application, conventional spray application is recommended.

Air Assisted air mix inlet air pressure recommendation is based on a pump @ 45:1 ratio.

RECOATABILITY & DRYING TIMES:

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings.

Drying	15°C (59°F)	23°C (73°F)	35°C (95°F)
Touch Dry	3.5 Hours	3 Hours	1.5 Hours
Hard Dry	7.5 Hours	5 Hours	2.5 Hours
Pot Life	6 Hours	6 Hours	6 Hours

Overcoated By	15°C (59°F)		23°C (73°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Self	3 Hours	5 Days	2 Hours	5 Days	1 Hour	5 Days
SDE Epoxy Primer	24 hours	5 Days	18 Hours	5 Days	12 Hours	5 Days

Maximum over coating times are without sanding. For best aesthetical result SDE Epoxy Surfacing primer should be sanded before over coating with SDE EPOXY Primer

WARNING NOTES:

Do not apply paint materials to surfaces less than 3°C (5°F) above dew point, or to surfaces warmer than 41°C (105°F).

Ambient temperature should be minimum 10°C (50°F) and Maximum 41°C (105°F).

NOTES:

The information given in this leaflet is based upon laboratory research, as well as extensive field work and application experience. All products are subject to standard conditions of sale which are available upon request. This information is based on **Safety Direct Egypt's** present state of knowledge and is intended to provide general information on **Safety Direct Egypt's** products and their methods of use.

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The information given in this data sheet represents test results & practical experience obtained under controlled conditions, and are correct to the best of our knowledge. However, as products are often used under different conditions, we can only guarantee the quality of our product, and reserve the right to change data without further notice.