

DUREPON® SANDABLE PRIMER

Two Pack Sandable Epoxy Primer

PC 203

- FEATURES**
- FAST CURE
 - NON INHIBITIVE PIGMENTATION
 - EXCELLENT SANDING PROPERTIES
 - EXCELLENT ADHESION TO A WIDE RANGE OF SUBSTRATES

USES DUREPON® SANDABLE PRIMER is recommended on non-ferrous metals, hardwood, MDF, primed steel and a range of composite materials as the primer or intermediate coat for high performance epoxy, polyurethane and enamel topcoats where a very smooth, high quality finish is required.

SPECIFICATIONS

RESISTANCE GUIDE

WEATHERABILITY	Will yellow with time. Will chalk on exposure to UV. Not intended for use without a topcoat.	SOLVENTS	Resists splash and spillage of most hydrocarbon solvents, refined petroleum products and most common alcohols
HEAT RESISTANCE	Up to 120°C dry heat	WATER	Excellent resistance to fresh and salt water but not suitable for immersion
SALTS	Excellent resistance to neutral and alkali salts	ALKALIS	Good resistance to splash and spillage of most common alkalis
ACIDS	Good resistance to splash and spillage of weak inorganic acids	ABRASION	Excellent abrasion resistance when fully cured.

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION	Two pack sandable epoxy primer	APPLICATION CONDITIONS			
FINISH	Low Sheen		Min	Max	
COLOUR	White	Air Temp.	10°C	45°C	
		Substrate Temp.	10°C	45°C	
		Relative Humidity		85%	
COMPONENTS	Two	COATING THICKNESS (MICRONS)			
VOLUME SOLIDS	52%		Min	Max	Recommended
VOC LEVEL	<420 g/L	Wet film per coat (µm)	100	145	120
FLASH POINT	4°C	Dry film per coat (µm)	50	75	60
POT LIFE	8 hours (4 litre kit, 25°C)	SUITABLE SUBSTRATES	Prepared polyester composites, MDF, primed steel, aluminium and most other non-ferrous metals		
MIXING RATIO V/V	Part A : 4 Part B : 1	PRIMERS	Duremax® GPE ZP		
THINNER	Not required	TOPCOATS	Dulux® two pack and single pack topcoats		
PRODUCT CODE	410-89796 White 976-89797 Hardener	APPLICATION METHODS	Brush, roller, conventional or airless spray		

DRYING CHARACTERISTICS AT 60 µm DRY FILM THICKNESS*

Temperature	Humidity	Touch	Handle	Full Cure	OVERCOAT	
					Min	Max ¹
25° C	50%	30 Minutes	90 Minutes	7 Days	8 Hours	1 Week

* These figures are a guide only, as ventilation, film thickness, humidity, thinning and other factors will influence the rate of drying.

As with all two-pack sanding primers the longer the coating is left to cure, the harder it becomes, and the greater the effort required to sand the surface. For best results, sand **approximately 2 – 4 hours after application** (depending on ambient conditions and coating thickness). NOTE – Thinning is not recommended; addition of thinner will substantially delay drying and sandability.

¹ If the maximum overcoat interval is exceeded then the surface MUST be abraded to ensure maximum intercoat adhesion.

SPREADING RATE 8.6 square metres per litre equals 60 µm dry film thickness

ASSUMING NO LOSSES

NOTE: Practical spreading rates will vary depending on such factors as application method, ambient conditions, surface porosity and roughness.

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TYPICAL SYSTEMS

This is a guide only and not to be used as a specification. Your specific project needs must be discussed with a Dulux Protective Coatings Consultant.

SURFACE	ENVIRONMENT	PREPARATION GUIDE	SYSTEM	DFT (µm)
STEEL – NEW	Mild - Moderate (AS2312.1 Cat C2-3)	Abrasive blast clean AS1627.4 Class 2.5	1 st Coat Duremax® GPE ZP 2 nd Coat Durepon® Sandable Primer 3 rd Coat Luxathane® HPX	75 µm 60 µm 50 µm
HARDWOOD & MDF	Interior	Sand and dust down before and after first coat	1 st Coat Durepon® Sandable Primer 2 nd Coat Quantum® FX 3 rd Coat Quantum® Clearcoat	60 µm 55 µm 45 µm
HARDWOOD & MDF	Interior	Sand and dust down before and after first coat	1 st Coat Durepon® Sandable Primer 2 nd Coat Luxathane® HPX 3 rd Coat Luxathane® HPX	60 µm 50 µm 50 µm
ALUMINIUM	Exterior/Interior	Clean, degrease and abrade surface	1 st Coat Durepon® Sandable Primer 2 nd Coat Luxathane® HPX 3 rd Coat Luxathane® HPX	60 µm 50 µm 50 µm

NOTE: If application is by brush or roller, additional coats will be necessary to achieve the minimum DFT and full opacity

SURFACE PREPARATION	Durepon® Sandable Primer is not recommended for direct application to ferrous metals. Specifiers should follow the guidelines for surface preparation from the data sheet for the primer selected. The primer surface must be free from grease, oil, dirt and other contaminants. Non-ferrous metals: Round off all sharp edges. Remove grease and other contaminants in accordance with AS1627.1. Whip blast with fine non-metallic media to provide a key. Remove all dust with compressed air. Alternatively, degrease and abrade the surface with a non-metallic abrasive pad wetted with Gamlen CA 1 (a free-rinsing, alkaline detergent) and water. Rinse thoroughly with fresh water. MDF and hardwood: Sand thoroughly and remove all dust by vacuum or compressed air.		
APPLICATION	Mix each can thoroughly using a power mixer until the contents are uniform. Mix the contents of both packs together thoroughly using a power mixer and allow to stand for 10 minutes. Remix thoroughly before application.		
BRUSH/ROLLER	Apply even coats of the mixed material to the prepared surface. When brushing and rolling additional coats may be required to attain the specified thickness.		
CONVENTIONAL SPRAY	Do not thin Typical Set-up	Graco AirPro: Pressure at Triton 308: Pressure at Gun:	1.4mm (239542) 70-100 kPa (10-15 p.s.i.) 380-410 kPa (55-60 p.s.i.)
AIRLESS SPRAY	Standard airless spray equipment such as a Graco Xtreme 30:1 with a fluid tip of 13-15 thou (0.33-0.38mm) and an air supply capable of delivering 550-690 kPa (80-100 p.s.i.) at the pump. Thinning is not required.		
PRECAUTIONS	This is an industrial product designed for use by experienced Protective Coating applicators. Where conditions may require variation from the recommendations on this Product Data Sheet contact your nearest Dulux® representative for advice prior to painting. Do not apply in conditions outside the parameters stated in this document without the express written consent of Dulux® Australia. Freshly mixed material must not be added to material that has been mixed for some time. The rate of cure is dependent upon temperature. Do not apply at temperatures below 10°C. Do not apply at relative humidity above 85% or when the surface is less than 3°C above the dewpoint. Do not thin. Addition of thinner will substantially delay drying and sandability.		
CLEAN UP	Clean all equipment with Dulux® Epoxy Thinner (920-08925) immediately after use.		
OVERCOATING	Degrease with Gamlen CA 1 according to the data sheet. Test adhesion of existing coating by standard cross hatch adhesion test. If the coating fails, remove it. High-pressure water wash at 8.3 to 10.3 MPa (1,200-1,500 p.s.i.) to remove chalk and dust. Abrade surface to provide a good key for the new coating. Epoxies must be abraded if recoated outside the recoat window.		
SAFETY PRECAUTIONS	Read Data Sheet, SAFETY DATA SHEET and any precautions on container labels. SAFETY DATA SHEET is available from Customer Service (13 23 77) or www.duluxprotectivecoatings.com.au		
STORAGE	Store as required for a flammable liquid Class 3 in a bunded area under cover. Store in well-ventilated area away from sources of heat or ignition. Keep containers closed at all times.		
HANDLING	As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational work practice. Eye protection approved to AS1337 should be worn where there is a risk of splashes entering the eyes. Always wash hands before smoking, eating, drinking or using the toilet.		
USING	Use with good ventilation and avoid inhalation of spray mists and fumes. If risk of inhalation of spray mists exists, wear combined organic vapour/particulate respirator. When spraying, users must comply with their respective State Spray Painting Regulations.		
FLAMMABILITY	This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fight fire with foam, CO ₂ or dry chemical powder. On burning will emit toxic fumes.		
WELDING	Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.		

COMPANY INFORMATION

Dulux Protective Coatings a division of

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PACKAGING, TRANSPORT AND STORAGE

PACKAGING	Available in 4 litre packs
TRANSPORTATION WEIGHT	1.36 kg/litre (Average of components)
DANGEROUS GOODS	Part A: Class 3 UN 1263
	Part B: Class 3 UN 1263

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