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

TYPICAL PROPERTIES AND APPLICATION DATA

CLASSIFICATION | Two pack sandable epoxy primer |
FINISH | Low Sheen |
COLOUR | White |

APPLICATION CONDITIONS

Air Temp. | Substrate Temp. | Relative Humidity |
10°C | 10°C | 85% |
45°C | 45°C |

COATING THICKNESS (MICRONS)

Wet film per coat (μm) | Min | Max | Recommended |
100 | 145 | 120 |

Dry film per coat (μm) |
50 | 75 | 60 |

SUITABLE SUBSTRATES
Prepared polyester composites, MDF, primed steel, aluminium and most other non-ferrous metals

PRIMERS
Duremax® GPE ZP

TOPCOATS
Dulux® two pack and single pack topcoats

APPLICATION METHODS
Brush, roller, conventional or airless spray

DRIED CHARACTERISTICS AT 60 μm DRY FILM THICKNESS

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Humidity</th>
<th>Touch</th>
<th>Handle</th>
<th>Full Cure</th>
<th>Overcoat</th>
</tr>
</thead>
<tbody>
<tr>
<td>25°C</td>
<td>50%</td>
<td>30 Minutes</td>
<td>90 Minutes</td>
<td>7 Days</td>
<td>8 Hours</td>
</tr>
</tbody>
</table>

*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

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

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.

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

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

| Pressure at Triton 308: | 70-100 kPa (10-15 p.s.i.) |
| Pressure at Gun: | 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.

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

As with any chemical, ingestion, inhalation and prolonged or repeated skin contact should be avoided by good occupational 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.

HANDLING

This product is flammable. All sources of ignition must be eliminated in, or near the working area. DO NOT SMOKE. Fire with foam, CO₂ or dry chemical powder. On burning will emit toxic fumes.

USING

Avoid inhalation of fumes if welding surfaces coated with this paint. Grind off coating before welding.

WELDING

FLAMMABILITY

COMPANY INFORMATION

Dulux Protective Coatings a division of DuluxGroup (Australia) Pty Ltd 1956 Dandenong Road, Clayton 3168 A.B.N. 67 000 049 427

DuluxGroup (New Zealand) Pty Ltd 150 Hutt Park Road, Lower Hutt, NZ A.B.N. 55 133 404 118

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