

A867

TC505 Epoxy Primer Surfacer (D84)

A two pack epoxy primer surfacer with outstanding adhesion and sanding properties. Used primarily as a primer coat for fibreglass, epoxy, custom wood, particle board, concrete and fibrolite substrates where it is intended to use Modoglaze ST or Corroless RF60 topcoats.

PRODUCT FEATURES

- Outstanding adhesion to difficult surfaces
- Quick drying
- Easy to sand
- High opacity, white dull finish
- General purpose

Colour	A white dull finish
Appearance When Dry	Dull low sheen finish
Storage Temperature	Minimum 10°C Maximum 50°C
Shelf Life (months)	18 months
Flash point	4.4°C
Pack Size	1L, 4L pack. Mix Pack A white base 3.0 litres Pack B hardener 1.0 litre (3:1)

ESTIMATION

Percentage by Weight (mixed)	57%
Volume solids (mixed)	36%
Dry film thickness	Applied at a coverage rate of approximately 8m ² /litre. Dry film per coat 45 microns.

Note

When applying by spray application: Apply one tack coat followed after 20 minutes drying, with a double header spray application. Under most circumstances a tack followed by one application of a double headed wet coat to follow will provide sufficient product for the sanding and preparation prior to topcoats.

Wet film thickness per coat	125 microns
Theoretical Coverage	8m ² /litre @ 45 microns D.F.T

APPLICATION

SURFACE PREPARATION

Fibreglass and Gel Coat

Remove release agents and/or waxes by appropriate means.

Note: Depending on type, sand down surface to a dull finish with 120 grit wet and dry paper, rinse off before application of TC505. Remove waxy film from fibreglass or gel coat using Methylated Spirits prior to wet and dry sand.

Existing or Epoxy Finish

Scrub surface with Chemical Degreaser (A926) to ensure all grease, fat, oils etc have been completely removed then roughen surface by sanding with wet and dry 120 grit paper to a dull, smooth, flat finish.

Epoxy Composite/Epoxy Resin

Ensure resin system does not contain wax. Lightly sand if epoxy film has aged past 24 hours and apply one or two coats.

Note: If epoxy resin system is less than 24 hours since application, apply TC505 Epoxy Primer Surfacer directly. Check for wax use in the resin system.

Concrete/Fibre Cement Board

Ensure surface is clean prior to coating by removal of all dirt, mould, dust etc.

Aluminium

Where anti-corrosive properties are not required, scrub aluminium surface with Chemical Degreaser (A926) and completely remove with copious quantities of fresh water.

Note: Where corrosion resistance is required in chemical or marine environment use Corroless Epoxy 1. To ensure product is used in the appropriate situation contact the Industrial Division of Protective Paints.

Potlife (@ 25 deg.C) 4 - 6 hours 20°C
Mixing Mixing ratio Pack A Base 3: Pack B Hardener 1

Note: Ensure accurate mixing at all times by measuring volume in appropriate manner. When mixing agitate base with broad paddle stirring hardener into base until fully incorporated. Continue stirring for approximately 3 - 5 additional minutes before using product.

APPLICATION DETAILS

Min. Steel Temperature 5°C. Considerably slower curing at this temperature
Max. Relative Humidity 75%
Application Temperature Range 5°C – 50°C

METHODS

Brush, roller, spray.

Note: Spraying:

Apply tack coat allowing product to become touch dry before applying a double headed coat. Best used using air atomised equipment. If airless spray application is required refer to manufacturer of airless spray equipment ensuring spray nozzle of approximately 15 – 20 thou size and 40° angle preferred.

Thinners Use Corroless thinners No. 4 using a minimal amount to achieve good spray performance.

Cleaning Solvent
Max. Volume Thinners
Nozzle Orifice 15 – 20 thou
Fan Angle 30° - 50°
Nozzle Pressure Up to 2500 psi

DRYING CHARACTERISTICS

Temperature (deg. C) 20°C
Touch dry 1 - 2 hours
Handle dry 4 - 6 hours
Full cure 24 hours
Overcoating Normally overcoated with Corroless RF15, Corroless RF60, and Modoglaze ST.

Note: Always ensure clean, dull surface before overcoating with any of the above mentioned topcoats.

HEALTH AND SAFETY

Irritant Avoid contact with skin and eyes. Avoid breathing vapour or sanding dust.
When using this product it is recommended that full overalls, gloves, face mask and goggles be worn. Store container in a safe place when not in use.
Do not burn container.

FIRST AID

EYES

Flush with water for at least 15 minutes and seek medical advice.

SKIN

Wash contact areas with soap and water. Remove all contaminated clothing, and seek medical advice. Do not scrub.

INHALATION

Remove patient from further exposure, and keep patient warm and comfortable.

INGESTION

Do not induce vomiting. Rinse mouth with water. Seek medical advice as soon as possible.

**USE ONLY WITH ADEQUATE VENTILATION
KEEP OUT OF REACH OF CHILDREN****TRANSPORTATION AND DISPOSAL**

Class	3
Hazchem Code	•3YE; •3Y
UN No	1263
Packing Group No	II
Fire Extinguishing Media	CO ² , Foam, Dry Chemical
Fire Fighting Procedure	Fire fighters should wear self contained breathing apparatus. Fight fire from a protected location as product may explode on heating. The vapours are heavier than air, so may travel along the ground to accumulate in low areas. Fire may flash back along vapour trail, and can also react with oxidising agents. Spills should be cleaned up immediately by using sand or other non-flammable absorbent materials. Ensure material does not enter waterways. Dispose of empty containers in accordance with local by laws.

OTHER INFORMATION

This product may be used for a wide variety of surfaces. If the surface you propose to paint is not referred to, contact Protective Paints Technical Department for classification.

For further technical information please phone 0800 724 684.

RELIABILITY OF INFORMATION

All statements and technical information contained herein are based on tests we believe to be reliable but the accuracy thereof is not guaranteed. Since Protective Paints Ltd has no control over product application, purchasers and users must confirm the suitability of our products under their conditions to meet their own requirements.

ISSUE NUMBER: A867 (D84) (V2)

ISSUE DATE: 17 September 2013