

EP Primer Grey 440







Primer

24/10/2019

L2.04.01 AUS

DESCRIPTION

Two-component epoxy-based primer for general repairs use in refinishing cars, chassis and light commercial vehicles. It provides corrosion resistance and excellent leveling with superior gloss.

Mixing ratio		4 EP Primer Grey 440 1 EP Primer Hardener 740 1 Lesonal Multi Thinner 810 (any)
Equipment		Spray gun set-up: 1.5-1.8 mm Application pressure: 1.7-2.2 bar at the air inlet HVLP max 0.7 bar at the air cap
Application		2-3 x 1 coat Apply two or three coats; allow drying until matt between each coat.
Flash-off		Between coats 5-10 minutes at 20°C
Drying time		Drying: EP Primer Grey 440 30°C 60°C 8 hours 1 hour
Protection		Use suitable respiratory protection Akzo Nobel Car Refinishes recommends the use of fresh air supply respirator

Read complete TDS for detailed product information

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Two-component epoxy-based primer for general repairs use in refinishing cars, chassis and light commercial vehicles. It provides corrosion resistance and excellent leveling with superior gloss.

PRODUCT AND ADDITIVES

Product	Lesonal EP Primer Grey 440	
	Hardener	Lesonal EP Primer Hardener 740
	Thinner	Lesonal Multi Thinner 810 (any)
	Colour	Grey
Basic raw materials	Lesonal EP Primer Grey 440 ; Epoxy Resins Lesonal EP Primer Hardener 740 ; Polyaminoamide Resins	

METHOD OF USE

Suitable substrates	Steel Aluminum Galvanized Steel
Substrate preparation	<p>Prior to any sanding work, thoroughly cleanse the surface of any grease or wax with AkzoNobel Wax and Grease Remover. Apply using two clean cloths in a wipe-on, wipe-off process.</p> <p>Original finishes – sand with P180 to P280 grit dry, or P600-P800 wet. Steel – remove all traces of rust and abrade thoroughly until a clean surface is achieved. (See Helpful Tips below.) Lesonal 2K Putty 522 – Final sanding with P280 grit dry.</p> <p>After sanding work is completed and just prior to the application of primer, degrease again thoroughly with AkzoNobel Wax and Grease Remover.</p>

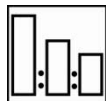
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Mixing



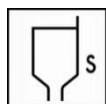
4 EP Primer Grey 440
 1 EP Primer Hardener 740
 1 Lesonal Multi Thinner 810 (any)
 Mix in a straight-sided mixing container and stir well before use.

Tinting

Can be tinted with the following products up to 15% by weight
 Lesonal Basecoat SB 120
 Lesonal 2K Topcoat MM 320
 Note: Tinting must be done before Lesonal EP Primer Grey 440 is mixed with
 Lesonal EP Primer Hardener 740

Viscosity

20-25 seconds at 20°C



Spray gun set-up / application pressure

Spray gun
 Gravity feed

Fluid tip-set-up
 1.5-1.8 mm

Application pressure
 1.7-2.2 bar at the spray gun air inlet
 HVLP max 0.7 bar at the air cap



APPLICATION TECHNIQUE

Application process & blending

Apply two or three coats; allow drying until matt between each coat. Generally this will take 5 – 10 minutes (this time will be very much influenced by factors such as temperature and air movement at the time of application).



If the product is to be applied over a thermoplastic acrylic finish, it is recommended that a thin coat is applied first, and that care is also taken in applying subsequent coats. Flash off times between each coat should also be extended.

Pot-life

8 hours at 20°C

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Drying times



Primer Hardener 740

30°C	Dust Free	8 mins
	Dry to sand	8 hrs
60°C	Dust Free	4 mins
	Dry to sand	1.5 hrs

Film thickness By using the recommended application: 30-35µm per coat.

Recommended sanding grades	Method	Sandpaper Grade
	Wet, by hand	P800 – P1000
	Wet, by machine	P400 – P500
	Dry, by hand	P360 – P400
	Dry, by machine	P360 – P400

Cleaning of equipment Use Multi Thinner 810 (any)

Product Storage Product shelf-life is determined when products are stored unopened at 20°C. Avoid extreme temperature fluctuation. Product shelf life data see TDS S9.02.01

Helpful Tips Recoatable with Lesonal 2K primer 480, or Lesonal 2K Topcoat 320 within 48 hours after application of Lesonal EP Primer Grey 440. After 48 hours, prior sanding with P280 – P400 dry is necessary before applying the next coating.

NOTE: When applying Lesonal 2K Primer 480 (as a high build) over the top of Lesonal EP Primer Grey 440, apply ONLY 1 COAT of Lesonal EP Primer Grey 440.

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