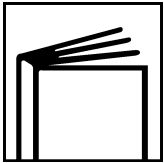




410-58180 CF BLACK EPOXY PRIMER

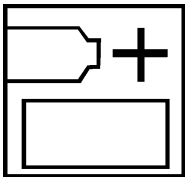
THESE PRODUCTS ARE FOR THE PROFESSIONAL PAINTING OF VEHICLES ONLY

PRODUCT DESCRIPTION



410-58180 CF Black Epoxy Primer is a 2-pack, chromate free, high performance undercoat which provides excellent adhesion to a variety of substrates. It is designed to provide smooth laydown for minimal sanding whilst still giving good film builds. This is an excellent undercoat for large flat panels, e.g. trucks, buses, and trailer manufacturing. It makes an ideal undercoat beneath Delfleet, 2K and Autothane CV.

PRODUCT AND ADDITIVES



Product	
410-58180	CF Black Epoxy Primer
980-34298	Epoxy Primer Catalyst
922-34178	Dulon Thinner

FEATURES AND BENEFITS



Features
Two Pack Epoxy Primer

Easy application

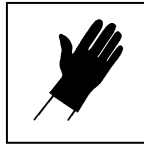
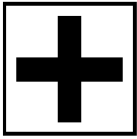
Wet-on-Wet capability

Benefits
Provides hard, tough surface with the ability to accept a variety of topcoats

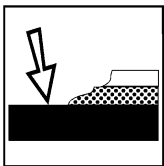
Provides a smooth finish to minimise any sanding.

Reduces booth time – one bake cycle and promotes excellent intercoat adhesion.

HEALTH AND SAFETY



SUITABLE SUBSTRATES



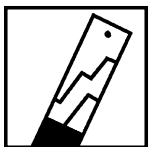
410- 58180 CF Black Epoxy Primer can be applied over the following substrates

Suitably prepared mild steel
Correctly prepared Stainless Steel
Chemically cleaned and abraded aluminium
Sanded and cleaned polyester fillers
Sanded and cleaned GRP (fibreglass)
Sanded and cleaned sound factory finishes and works primers (except alkyd)
Sanded and cleaned sound old finishes (except alkyd)
Sanded and cleaned Electrocoat

**Please Note:
product**

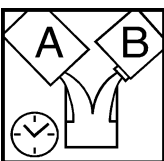
**Substrates other than those stated should be tested before use, to ensure that the
performance is suitable for its intended use.**

MIXING RATIO



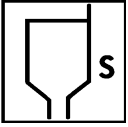
410- 58180 CF Black Epoxy Primer	1 part
980-34298 Epoxy Primer Catalyst	1 part
922-34178 Dulon Thinner	Up to 20% if needed.

POT LIFE



24 hours @ 25°C

SPRAYING VISCOSITY



15-17 seconds DIN4 @ 25°C

SPRAY GUN/SPRAYING PRESSURE (at the gun)



1.3-1.5 mm Gravity

2-3 bar / 30-45 PSI



1.4-1.8 mm Suction

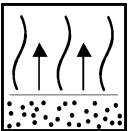
2-3 bar / 30-45 PSI

APPLICATION



Apply 2 even medium coats to give a dry film build of 25-30µm.

FLASH-OFF TIME



Allow 3-5 minutes between coats @ 25°C.

Allow longer flash off between coats in cooler conditions

If using as a wet on wet paint system, allow 30 minutes air dry

@ 25°C before topcoating. Maximum 24 hours @ 25°C.

DRYING, CURING & SANDING



4 hours @ 25°C.



40 minutes @ 60°C

POINTS TO NOTE



- Do not mix aged and freshly activated material together.
- 410- 58180 CF Black Epoxy Primer must not be used over alkyd primers such as 356-Line Fastbuild.
- 410-58180 CF Black Epoxy Primer must not be used under alkyd enamel topcoats.
- Do not use 410- 58180 CF Black Epoxy Primer when temperatures are below or likely to drop below 12°C or within 3 °C of the dew point.
- Clean all equipment immediately after use.
- In warmer conditions (above 25°C), the pot life will be shorter.

This product is for professional use only.

The information given in this sheet is for guidance only. Any person using the product without first making further inquiries as to the suitability of the product for the intended purpose does so at his own risk and we can accept no liability for the performance of the product or for any loss or damage (other than death or personal injury resulting from our negligence) arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Drying times quoted are average times at 25°C/68°F. Film thickness, humidity and shop temperature can all affect drying times.



**PPG INDUSTRIES AUSTRALIA PTY
LIMITED**

**McNaughton Road
Clayton VIC Australia 3168**

Tel: 13 2424

Fax: 1800 800 819

**PPG INDUSTRIES NEW ZEALAND PTY
LIMITED**

**5 Vestey Drive Mt. Wellington
Auckland New Zealand**

Tel: 0800 320 320

Fax: 0800 320 322