



EX-408 PRIMERS

PRODUCT DESCRIPTION

Commercial Performance Coatings EX-408 Primer is a zinc phosphate containing, polyamide cured epoxy primer, that provides a tough abrasion resistant film with good build characteristics.

It is designed for use on metal, wood, masonry and fibreglass.

PRODUCTS

EX-408 Pack A

408-2154 EX-408 BEIGE
408-5042 EX-408 RED
408-6098 EX-408 GREY
408-6683 EX-408 ASH GREY
408-6916 EX-408 GREY

EX-408 Pack B

414-9806 EX-408 WOW EPOXY HARDENER
414-9153 EX-9153 HARDENER

Reducers

Normal conditions

Hot conditions

Very hot conditions or large equipment

EXR20 Epoxy Reducer Normal
EXR30 Epoxy Reducer Slow
EXR40 Epoxy Reducer Extra Slow

Cleaners

971-9119 PROTEC® Metal Conditioner
AA-6822 *Protec* Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



Commercial Performance Coatings EX-408 Primer can be applied over the following substrates once they have been prepared as follows:

SUBSTRATE

Structural steel

New steel sheet

PREPARATION

Abrasive blast clean to AS 1627.4 Class 2.5, apply primer within 30 minutes of blasting.

Treat new steel sheet with 971-9119 *Protec* Metal Conditioner. Do not allow the solution to dry, but wipe off with clean cloths. Rinse well with water to remove excess acid then wipe dry with clean cloths. Apply primer immediately after preparation of the clean surface.

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Aluminium	Bare aluminium surfaces should be thoroughly cleaned using AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover before sanding. If necessary use a high grade scouring pad to remove heavy areas of grease and imperfections, all this is to be done in a wipe on wipe off motion using clean rags. Once dry, thoroughly abrade the surface using STARTLINE® P240 grit on an orbital sander or by hand rubbing using <i>Startline</i> P320. Once sanded the aluminium should be thoroughly blown down then cleaned with a 1:1 solution mix of 207 Methylated Spirits and clean water, using a wipe on wipe off action. This must be repeated until no residue shows on the cleaning cloths. The prepared aluminium must be primed within 6 hours or sooner after the preparation process; failure to do this will allow the aluminium to re-oxidise and the cleaning will have to be repeated.
Galvanised & Zinc Coated Steel	Remove all surface contamination such as oil, grease or dirt by thoroughly washing the surface with AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover. Sand the surface by mechanical means using P80 grit – P120 grit sand paper, then thoroughly blow down and clean the surface once again using AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover.
Stainless Steel	Remove all surface contamination such as oil, grease or dirt by thoroughly washing the surface with AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover and wipe dry with clean cloths. Abrade the surface using Startline P240 grit on an orbital sander or by hand rubbing using Startline P320 grit. Thoroughly blow down to remove dust and clean the surface again using AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover. Alternatively abrasive blast clean to AS 1627.4 Class 2.5, apply primer within 4 hours of blasting. NOTE: Stainless Steel will vary in grades and a test area is always recommended to test adhesion before final application.
Masonry, Brick & Concrete	Brush down to remove all dust and powdered materials by wire or power brush. Chemically neutralize the surface if efflorescence is present.
Timber	Ensure surface is clean and dry and sanded to a smooth finish
Fibreglass (GRP)	Wash surface thoroughly using a mixture of warm water and detergent to remove waterborne release agents. Rinse with clean water and wipe dry. Lightly dry sand entire surface with <i>Startline</i> P320 grit paper. Blow down then thoroughly clean the surface with AA-6822 <i>Protec</i> Heavy Duty Wax & Grease Remover, working in small areas then thoroughly wiping each section completely dry with clean cloths.

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Previously painted surfaces

Remove all loose and flaking paint, rust etc. with power/hand tool combination.

Spot prime all bare steel areas.

Before proceeding with the coating of any previously painted surface, a test patch should be done. Providing there has been no "frying" or other film defect, proceed as above.

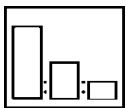
If any "lifting" or frying is evident, strip back to bare metal with 186 Superstrip Paint Remover.

Surfaces showing heavy scale or surface rust should be treated with 971-9119 *Protec* Metal Conditioner. Heavily rusted surfaces should be abrasively blast cleaned.

Before and after any sanding operation, the substrate must be thoroughly degreased using AA-6822 *Protec* Heavy Duty Wax & Grease Remover to remove all traces of dirt, oil, grease, silicone, wax etc.

For other primer options please consult the PPG Commercial Performance Coatings Technical Team.

MIXING RATIO BY VOLUME



PRODUCT

EX-408 Pack A

414-9806

Reducer

PARTS

4

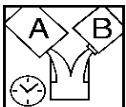
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0 - 40%

Mix Pack A and Pack B. Stir thoroughly and allow 10 minutes induction time.

Add reducer and stir thoroughly.

POT LIFE



Catalysed material is useable for up to 6 - 8 hours at 25°C

SPRAYGUN



CONVENTIONAL

SETUP

- GRAVITY 1.8 mm - 2.0 mm
- SUCTION 1.8 mm - 2.0 mm

SPRAY PRESSURE

- CONVENTIONAL 3.1 - 4.5 bar (310 - 450 kPa, 45 - 65 psi)

APPLICATION & FLASH OFF



SPRAY: CONVENTIONAL

APPLY 2 - 3 WET, EVEN COATS. DRY FILM THICKNESS 40 - 70 MICRONS.

Allow 10 - 15 minutes flash off between coats at 25°C.

Note: Do not apply at temperatures less than 10°C, when the relative humidity exceeds 85%, or if the surface temperature is within 3°C of the dew point.

Product is suitable for brush application on small surface areas.

BRUSH AND ROLLER APPLICATION

Mixed material is ready for use for brush application. Apply full even coats. Brushing may be eased depending on weather conditions by the addition of EXR30 Epoxy Reducer Slow or EXR40 Epoxy Reducer Extra Slow.

DRYING TIMES

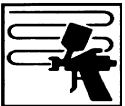


AIR DRY (25°C)

- TOUCH DRY: 1 - 2 hours
- HARD DRY: 16 hours

Note: Drying of EX-408 Primer is very dependent on temperature and humidity and it will not cure at temperatures below 5°C, or within 3°C of the dew point.

RECOAT



Can be re-coated as wet on wet application after 1 hour minimum dry time at 25°C.

After maximum recoat time of 72 hours at 25°C, a thorough sand with mechanical means is necessary followed by full re-priming.

TOTAL DRY FILM BUILD

40 - 75 µm

TECHNICAL PARAMETERS

VOLUME SOLIDS (RFU)	45 - 55%, depending on colour
COVERAGE	~11 metres squared per litre (m ² /L)
RESISTANCE PROPERTIES	
WEATHERING	Excellent when topcoated
ABRASION	Excellent
SOLVENT	Resists splash and spillage for common solvents
CHEMICAL	Good to dilute acids, excellent to alkalis
HEAT	Satisfactory up to 120°C Dry Heat
TOXICITY	Non toxic in dry films

EQUIPMENT CLEANING

After use, clean all equipment thoroughly with cleaning solvent or thinner.

HEALTH AND SAFETY

Please refer to Safety Data Sheets (SDS) for full Health and Safety details, as well as product can labels.

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 or her 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/77°F. Film thickness, humidity and shop temperature can all affect drying times.

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