



EX-408 PRIMERS for Australian Defence Force using 414-9806

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 to be in compliance with:

AP-S0154/6 - EX-408 ZP Primer NIRR Beige 408-5208, EX-408 ZP Primer Grey 408-6098

AP-S0502/5 - EX-408 Multipurpose Epoxy Primer Grey 408-6916

NIRR = Near Infra Red Reflectance

PRODUCTS

EX-408 Pack A		408-5208 EX-408 NIRR BEIGE 408-6098 EX-408 GREY 408-6916 EX-408 GREY
EX-408 Pack B		414-9806 EX-408 WOW EPOXY HARDENER
Reducers	<i>Normal conditions</i>	EXR20 Epoxy Reducer Normal
	<i>Hot conditions</i>	EXR30 Epoxy Reducer Slow
		<i>235 Epoxy Electrostatic Reducer</i>
	<i>Very hot conditions or large equipment</i>	EXR40 Epoxy Reducer Extra Slow
		<i>247 Epoxy Electrostatic Extra Slow Reducer</i>
Cleaner		AA-6822 PROTEC® Heavy Duty Wax & Grease Remover

SUBSTRATES & PREPARATION



Substrates should be prepared in accordance with AP-S0154 and AP-S0502 specifications. Specifications can be found at: <https://vs.csiro.au/apas/>

SUBSTRATE



Ferrous Metals

Non-Ferrous Metals

PREPARATION

Abrasive blast clean to AS 1627.4 Class 2.5, apply primer within 4 Hours of blasting.

Metal pretreatment by zinc phosphating.

Abrasive blast clean to AS 1627.4 Class 2.5, apply primer within 4 Hours of blasting.

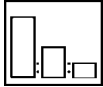
Metal pretreatment by suitable conversion coating. Note that the different types of conversion coatings can influence the adhesion of the primers. PPG recommends that any systems using a conversion coating on non-ferrous substrates should be tested and approved by PPG before production commences.

Other Substrates

Consult with a PPG Commercial Performance Coatings Technical representative. Lab testing may be required to confirm the best preparation and painting process to meet the APAS specifications.

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. Use spray/pump bottles to apply cleaning solvent to avoid contamination.

MIXING RATIO BY VOLUME



PRODUCT

EX-408 Pack A

414-9806

Reducer

PARTS

4

1

20 - 40%

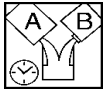
Refer to EX-408 Reducer Guide for suggested reducer selection for application temperature.

Mix Pack A and Pack B. Stir thoroughly.

Add reducer and stir thoroughly.

EX-408 with 414-9806 4:1:10-30% 15-22 sec DIN 4 cup at 25°C

POT LIFE



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

SPRAYGUN



CONVENTIONAL

SETUP

- GRAVITY 1.6 mm - 1.8 mm
- SUCTION 1.8 mm - 2.0 mm

SPRAY PRESSURE

- CONVENTIONAL 2.0 - 2.5 bar (200 - 300 kPa, 30 - 36 psi)

PRESSURE POT

- SATA 1000K 1.3 mm - 1.7 mm
- SATA 3000K 1.3 mm - 1.7 mm

APPLICATION & FLASH OFF



SPRAY: CONVENTIONAL

May be applied by conventional or airless spray.

- AP-S0154: APPLY 2 TO 3 WET, EVEN COATS FOR 408-5208 NIRR BEIGE AND 408-6098 GREY, DRY FILM THICKNESS 50 - 75 MICRONS.

- AP-S0502: APPLY 1 TO 2 WET, EVEN COATS FOR 408-6916 GREY, DRY FILM THICKNESS 35 - 50 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.

SPECIAL NOTE FOR NEAR INFRA-RED (NIRR) SYSTEMS

When applying coatings for conventional AP-S0154/3 paint systems it is usual to apply the primer to the whole vehicle or piece of equipment, then topcoat with any one of the camouflage colours. The disruptive pattern is then achieved by application of the other camouflage colours over the top of the first colour.

Do not use the above procedure for Near Infra-Red Reflectance. When painting NIRR systems, apply the NIRR primer over the whole vehicle or piece of equipment, then for AP-S0154/9 apply the NIRR Brown to the entire object, for AP-S0502/1 apply the NIRR Camouflage Green to the entire object. The other camouflage colours can then be applied to complete the camouflage pattern. Refer to the Polyurethane topcoat data sheets for more information.

Further note, the NIRR Camouflage Black when applied may have a 'greenish' appearance on the edges where the paint film is thin. This effect is because of the very specialized pigmentation needed to achieve the high Infra Red reflection required of the product. If the film build is kept even this effect is minimized.

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.

FORCE DRY

Please contact your local PPG Representative to discuss baking times and temperatures, as these vary depending on metal thickness and oven performance.

RECOAT



Can be re-coated as wet on wet application after half 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 a final solvent clean with D837- DX330 Spirit Wipe. After 120 hours at 25°C a thorough sand with mechanical means is necessary followed by a final solvent clean with D837- DX330 Spirit Wipe and then full re-priming. Reprime should be a single coat using 40% reducer.

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. Use spray/pump bottles to apply cleaning solvent to avoid contamination.

TOTAL DRY FILM BUILD	WET FILM THICKNESS		
	50 - 75 µm	AP-S0154	120-180 µm
	35 - 50 µm	AP-S0502	90-130 µm

TECHNICAL PARAMETERS	VOLUME SOLIDS	VOC
Conventional Infra Red AP-S0154/6 408-6098 EX-408 GREY	46.60%	450g/L
Near Infra Red Reflection (NIRR) AP-S0154/6 408-5208 EX-408 NIRR BEIGE	50.60%	449g/L
Multipurpose Zinc Phosphate Primer Grey AP-S0502/5 408-6916 EX-408 GREY	49.4%	424g/L
Wet on Wet Hardener AP-S0154 and AP-S0502 414-9806 EX-408 WOW EPOXY HARDENER	42.2%	486g/L

COVERAGE (RFU)

APAS 0154	6 - 11 metres squared per litre (m ² /L)
APAS 0502	6 - 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

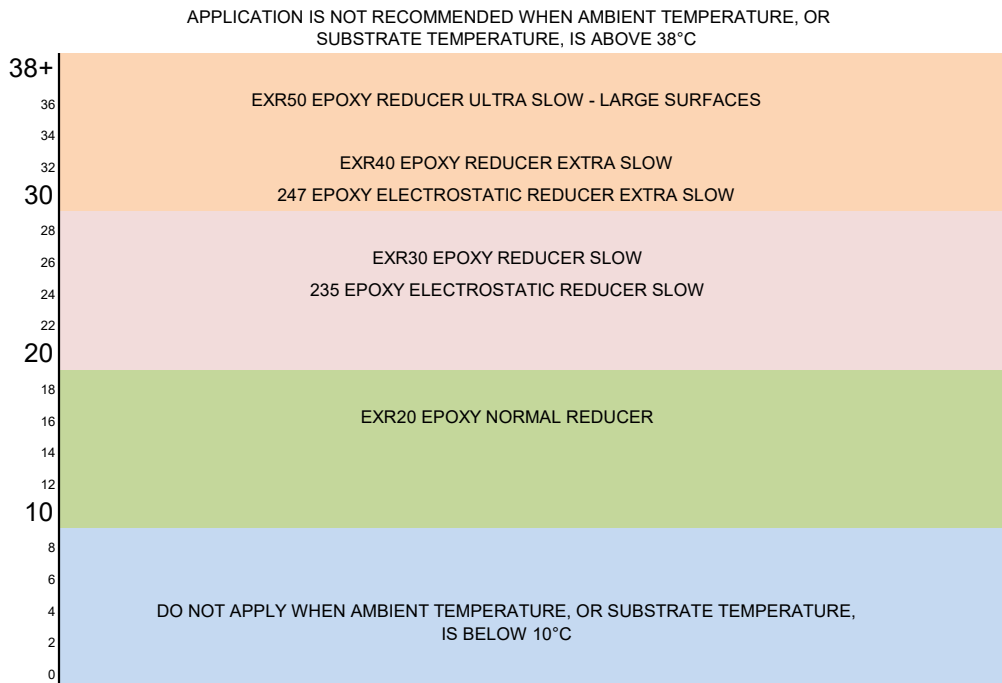
EQUIPMENT CLEANING

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

EX-408 REDUCER USAGE GUIDE

TEMPERATURE

RECOMMENDATION



This chart is provided as an approximate guide to when the different thinners should be used. Differences in application technique and the size of the components being painted will influence the optimum thinner choice. Do not apply when temperature is either below 10°C or within 3 degrees above the dew point or relative humidity exceeds 85%.

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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