TRUEPREP EPS-10 ETCH PRIMER

TDS55-649UP

DESCRIPTION	EPS-10 Etch Primer is a single pack etch primer, based on vinyl/butyral resin. Applied directly to metal surfaces it delivers a smooth satin sheen which provides excellent adhesion to mild steel surfaces.
TYPICAL USES	Gives excellent adhesion to various metals, such as aluminium, copper and its alloys, Galvanized Steel, Steel plate, structural Steel and Zinc metal spray. May be used under various topcoats. May also be applied to suitably prepared old, varnished surfaces and smooth cementitious surfaces, or ver suitably prepared ACM and Powder-coated surfaces.
ENVIRONMENT	Interior/ Exterior
PERFORMANCE	Excellent adhesion to aluminium, ferrous and nonferrous metals. Suitable for interior and exterior use. Chromate free.
LIMITATIONS	Chromate treated galvanised steel may present adhesion problems. It is recommended that a small area be tested before priming. Do not apply in temperatures below 8oC. Do not apply over existing coatings or damp surfaces.
TECHNICAL DATA	Resin: Vinyl/Butyra Product Type: Etch Primer Solvent: EPOTEC 103 Thinner Appearance: Light Grey Colour: Light Grey Primer: Not applicable Durability: Excellent Thining and Clean Up: Cotec 103 Thinner Pack Size: 4, 10 L Vol Solids: 37 percent Touch Dry: 20 minutes @20°C Recoat Time: 2 Hours @20°C Number of Coats: 1 Theoretical Coverage: 14 m^2/litre/coat Wet Film Thickness: 83 microns Dry Film Thickness: 31 microns
SPREAD RATE	12-14 - m^2/litre/coat Practical spreading rates will vary depending on such factors as application method, ambient conditions and surface porosity and roughness.
PRODUCT CODES	55-647UP

SURFACE PREPARATION

Powdercoated Steel-Aged Unpainted Good

Do not paint over previous painted surfaces. This specification applies only if the substrate is in good, aged condition, i.e., perhaps chalked and faded and no signs of delamination but colour or sheen refinishing.

Always prepare a test area prior to commencing the project. The test area should be prepared using the full procedure as below. Once test area is completed, leave to cure for one week and check for adhesion using Washi #2 Medium adhesion tape, with cross hatch method. If adhesion is good, proceed as below:

1 Identify the substrate. If Powder coated Aluminium or ACM Panel that has not been previously painted proceed to step 2.

2. All surfaces must be clean, and free of dirt, grease and any other surface contaminants. A thorough clean of all surfaces with TRUEPREP SURFACE CLEAN followed by water blast is recommended.
Then clean the surface to be painted with Prepwash/Prepsol (Wax n Grease Remover) wipe on wipe off method using clean white rags. Clean repeatedly until the entire surface to be painted is completely clean and contaminant free.

3. Where practicable dustless DA Sand the surface with P320 grit, Dust extraction is highly recommended to contain dust onsite and prevent surface contamination post spraying. If DA sanding isn't possible, hand or block sand to fully de-gloss all of the surfaces will suffice, particularly for aluminium joinery. Alternatively De-Gloss surfaces with Medium-Course Scotch-brite pad. (Scotch Brite can be used when cleaning (2 above) to save time if sanding is not practicable). The critical action here is to achieve an adequate key to the surface of the powder coating whilst retaining the integrity of the powder coated steel.

4. Repairs: treat as per Automotive process finishing with P320 grit. Fill any defects (if any) with Automotive filler suitable for non-Ferrous Metal. DA Sand and dust ,

5. Clean and prepare for Primer. Clean with compressed air or tack cloth. Regularly fold tack cloth to ensure clean cloth to surface for total removal of sanding dust.

6. Detail mask lifting window rubbers and Sealed Joints, if possible, use Washi #6 Tape. Note: When Painting paint under it not around it.

7. Etch prime substrate with EPS-10 ETCH PRIMER, allow to dry. Note: apply with Pressure Pot, HVLP or Airless with fine finish tip. Work and apply product in the shade. Super-hot surface temperature can compromise how the coating looks visually and can affect performance. (Unless you are in cold climates when you need direct sun to keep the surface above 10)

8. Dustless DA , or hand sand to P400 grit to de-nib.
a. if any mild filling is required follow with Dulux Autosolve 1K primer surfacer / filler.
b. Allow to dry and Dustless DA or hand sand to P400 grit.
c. Tack Rag clean prior to applying topcoats.

Ferrous Metals-New Unpainted

Thoroughly degrease and clean the surface as per AS 1627.1 standard. Apply TRUEPREP SURFACE CLEAN by pump spray or brush. Refer to TDS for application and dilution rates. Use water blasting to remove all cleaning products and contaminants.

Ensure all weld sections are thoroughly clean from weld splatter, flux and weld splatter. Weld splatter must be removed carefully by means or mechanical grinding or blasting. Ensure there are no areas of rough welding. All internal and external corners need to be grinded to provide a minimum radius of 2mm.

Abrasive blast clean to AS 1627.4 Class 2.5 or equivalent standard to achieve a blast profile of 25-45 microns. Apply our specified primer within 4 hours after blast cleaning to prevent flash rusting and other contamination.

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Ferrous Metals-Aged Unpainted Good
Thoroughly degrease and clean the surface as per AS 1627.1 standard. Apply TRUEPREP SURFACE CLEAN by pump spray or brush. Refer to TDS for application and dilution rates. Use water blasting to remove all cleaning products and contaminants.

Inspect the substrate prior to applying any coating system to ensure there is no contamination present and no surface defects exists. If there is either contaminants or defects are present, rectification process is required prior to any coating is applied.

Ensure all weld sections are thoroughly clean from weld splatter, flux and weld splatter. Weld splatter must be removed carefully by means or mechanical grinding or blasting. Ensure there are no areas of rough welding. All external corners need to be grinded to provide a minimum radius of 2mm.

Abrasive blast clean to AS 1627.4 Class 2.5 or equivalent standard to achieve a blast profile of 25-45 microns. Apply our specified primer within 4 hours after blast cleaning to prevent flash rusting and other contamination.

Ensure there is no deterioration in the condition of the surfaces to be painted, between the preparation stage and the actual application of the primer.

Non-Ferrous Metals-Aged Unpainted Good
If any areas of moss or mould infestation exist, treat them with our Trueprep Green Kill as per our TDS. Apply by flood coating to the surface and allow a minimum of 48 hours and preferably a week for sterilization before scrubbing or water-blasting for removal of the detritus.
For heavy infestations, an additional application may be needed.

Clean down using TRUEPREP SURFACE CLEAN by pump spray or brush. Additional scrubbing will assist in the breakdown and removal of any difficult contamination. Refer to TDS for application and dilution rates. Water blasting to remove all flaking paint, dirt, grease and contaminates. Allow to fully dry and test the surface has been degreased by wiping with clean cotton wool to ensure there is no residue. Repeat the process if necessary.

Inspect the substrate prior to applying any coating system to ensure there is no contamination present and no surface defects exists. If there is either contaminants or defects are present, rectification process is required prior to any coating is applied.

If there is any surface rust, wet sand the corroded areas and remove aluminium oxide layer. This will provide a better key for specified coating systems. Any pitted areas should also be wet sanded to a smooth finish. If there are sharp edges on the aluminium profile, this should be rounded off, to allow better adhesion and coating film build if possible.

Non-Ferrous Metals-New Unpainted
All surfaces must be clean, and free from dirt, grease, and any other surface contaminant. Clean with TRUEPREP SURFACE CLEAN - A powerful water based, biodegradable, degreaser. Formulated to remove grease and other contaminants. Refer to the TDS for all general information and application.
Allow to fully dry and test the surface has been degreased by wiping with clean cotton wool to ensure there is no residue. Repeat the process if necessary.

Inspect the substrate prior to applying any coating system to ensure there is no contamination present and no surface defects exists. If there is either contaminants or defects are present, rectification process is required prior to any coating is applied.

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Galvanised Steel and Zincalume-Aged Unpainted Good
If any areas of moss or mould infestation exist, treat them with TRUEPREP GREEN KILL, following instructions on TDS. Apply by flood coating to the surface and allow a minimum of 48 hours and up to four weeks for sterilization before scrubbing or water-blasting for removal of the detritus. For heavy infestations, longer dwell time or additional applications may be required.

Clean down using TRUEPREP SURFACE CLEAN applying by pump spray or broom. Additional scrubbing will assist in the breakdown and removal of any difficult contamination. Refer to TDS for application and dilution rates. Water blast or thoroughly rinse with high volume water to remove all dirt, grease and surface contamination.

Inspect the substrate prior to applying any coating system to ensure there are no surface defects exists. Repair as required.

All areas of rust or corrosion must be abraded using wire brushes, sandpaper, or Ultra-high pressure water blast to remove so little or no corrosion is left on the surface. Treat the entire surface TRUEPREP RUST KILL to remove residual rust, white rust and remaining surface contaminants and clean the metal prior to painting. Rinse clean as per manufacturers recommendations. If the substrate is not passivated in this way, it is likely that corrosion will occur under the new paint film.

When dry immediately apply specified coating system to prevent any contamination or further corrosion.

MIXING INSTRUCTIONS

Stir thoroughly before use.

APPLICATION

For corrugated iron add about 35% to the measured length x width, to get total flat area to be painted. For long run iron add about 45%.

Apply by brush, roller, spray or dip.
For concrete floors apply 2 coats. Allow 1 hour drying between coats.

SPRAY
Use conventional pot gun or airless spray, tip 308-513
HVLP 1.8-2.0mm.

BRUSH/ROLLER
Wooster Pro-dooz 6-8mm nap sleeve.

CLEAN UP
103 ETCH PRIMER THINNERS

APPLICATION NOTES

Do not over apply or apply in heat of day to hot surfaces.

THINNING

DO NOT OVER THIN. May be thinned only with 103 ETCH PRIMER THINNERS by 10-20%, if required for spray application.

SAFETY PRECAUTIONS

Wear Full PPE.

ENVIRONMENTAL

This formulation uses the latest technology with low toxicity, ensuring environmental issues are not compromised. DO NOT POUR paint or wash down storm water or water courses. ALWAYS dispose of in accordance with local Government regulations. Soak up spills with absorbent material and dispose of properly. If spraying use suitable respiratory protection. Refer to the MATERIAL SAFETY DATA SHEET

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