

HAYMES INDUSTRIAL COATING SOLUTIONS

339 2K Epoxy Primer Base

Product Code: I339EPB

Product description

Haymes 339 2K Epoxy Primer base is a chromate free, epoxy-polyamide primer surfacer characterised by excellent adhesion to any metal substrate. Its unique formulation, combined with anti-corrosive properties, outstanding flexibility, and chemical and water resistance, ensures the primer is easy to sand and is suitable for use under any topcoat. Used with Haymes ICS 300 system concentrates, 339 2K Epoxy Primer is available in all ICS colours.



Key Features

- ✓ Excellent anti-corrosive properties
- ✓ Excellent adhesion and durability
- ✓ Excellent chemical and water resistance
- ✓ Outstanding flexibility
- ✓ Easy to sand
- ✓ Suitable for use under all Haymes Industrial Coating Solutions Topcoats

| Volume Solids % | Weight Solids % | Density | | VOC | |
|--------------------|--------------------|---------|------------|-------|------------|
| | | g/mL | lbs/US Gal | g/L | lbs/US Gal |
| 49.5 | 71.04 | 1.557 | | 11.79 | |

Where to Use (Substrates)

Mild steel and steel alloy surfaces, stainless steel grade 316, aluminium, zincalume, zincanneal, galvanised steel, glass reinforced polyester (GRP & general types of fibreglass body parts) and previously painted surfaces in sound condition.

Surface Preparation



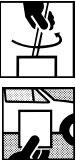








All Substrates



All surfaces must be thoroughly sanded and cleaned with Haymes Wax and Grease Remover prior to application.



Special Notes:





- All surfaces must be thoroughly sanded and cleaned with Haymes Wax & Grease Remover prior to application.
- Surfaces must be clean, bare, dry and free of dust, wax, grease, surface contamination and oxidation prior to painting.
- Use white or light-coloured primers under bright yellows, oranges and reds, if required.

The above systems are examples only. For further information, please contact Haymes Paint on 1800 033 431.

| Product Preparation | | | | |
|---|--|---|----------------------------|---------------------------------------|
|  | <ul style="list-style-type: none"> • Weigh the concentrates into the required base in accordance with the relevant colour formula. • A maximum of only 10% reduced concentrates is allowed and a maximum of 35% for all concentrates, in total. • Stir or shake for a minimum of 10 minutes. • Never leave the mixture stand for more than 30 minutes before mixing. | | | |
|  | Mixing Ratio 4:1 (by volume) | Haymes ICS 339 2K Epoxy Primer. | | Haymes ICS 339 Epoxy Primer Hardener. |
| | | 4 parts | | 1 part |
|  | Reducer | 10-20% (v/v) of Haymes ICS Universal 2K Thinner, if required. | | |
|  | Pot Life @ 25°C | 6 hours. | | |
|  | Spray viscosity @ 25°C | BSB 4 Cup | 17 to 19 s | |
| | | Ford 4 Cup | 15 to 17 s | |
| Spray Equipment | Gun type | Fluid tip | Spray pressure | Spray distance |
|  | Gravity Feed | 1.6-1.8 mm | 2.0 – 2.4bar 30 - 35psi | 15 - 20cm 6 - 8inch |
|  | Suction Feed | 1.5-2.0 mm | 2.0 – 2.4bar 30 - 35psi | 15 - 20cm 6 - 8inch |
|  | HVLP | 1.5-1.8 mm | 0.4 - 0.7bar 6 - 10psi | 15 - 20cm 6 - 8inch |
|  | Airless, Air Assisted, Electrostatic | Consult the spray gun manufacturer's instructions. | | |

| Product Preparation (continued) | | |
|---|------------------------|--|
|  | Number Of coats | 2-3 = Apply one coat followed by two even full coats. Avoid heavy wet coats. |
|  | DFT Recommended | 40-50 µm. |

| Product Preparation (continued) | | | | | |
|---|--|----------------|------------|-----------------|------------|
|  Flash off time @ 25C | 5 mins between coats. | | | | |
|  Drying | <table border="1"> <tr> <td>Air Dry @ 25°C</td> <td>3-4 hours.</td> </tr> <tr> <td>Low Bake @ 50°C</td> <td>30-40 min.</td> </tr> </table> | Air Dry @ 25°C | 3-4 hours. | Low Bake @ 50°C | 30-40 min. |
| Air Dry @ 25°C | 3-4 hours. | | | | |
| Low Bake @ 50°C | 30-40 min. | | | | |
| <p>This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.</p> | | | | | |

| Before Use | |
|---|--|
|  | <p>Stir all products thoroughly each time before use. Stir the mixture well after the weigh out of components.</p> |
|  | <p>Wet sand with P600-P800 before applying finish coat or dry sand with P400-P500 using an orbital sander.</p> |
|  | <p>Before application a colour comparison is STRONGLY recommended.</p> |
|  | <p>Surface temperature must always be a minimum of 3°C above dew point.</p> |

| Dry Film Properties (after 7 days drying, when compared to similar technology products) | |
|---|------------|
| Adhesion | Excellent. |
| Corrosion protection | Excellent. |
| Durability | Excellent. |

| Equipment Cleaning |
|--------------------------------------|
| Use Haymes ICS Universal 2K Thinner. |

| Storage |
|---|
| Store in a well-ventilated place. Keep cool. Store locked up. |

| Coverage |
|--|
| Approximately 8 m ² /L @ recommended DFT. |

Safety & First Aid

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

Protect our environment

DO NOT pour any leftover product down the drain. Retain in a marked, sealed container for future use or disposal via special chemical waste collection programs. Dried empty containers can be recycled and should be disposed of via recycling facilities.

Manufacturer's comment

This product has been designed as part of a totally integrated application system. Use with any other manufacturer's product(s) or failing to follow application instructions, could result in detrimental effects on product performance, for which Henry Haymes Pty. Ltd. cannot be held responsible. Further information is available in the form of Safety Data and Product Information Sheets from Haymes Paint www.haymespaint.com.au. We are continually updating materials and methods, so please ensure you have the latest information.

Disclaimer

The information provided is correct at the time of preparation; however, it is the responsibility of those using this information to check that it is current prior to specifying, recommending or using product contained in this information. Because use conditions and applicable laws may differ from one location to another and may change with time, those using this information are responsible for determining whether products and the information in this document are appropriate for their use and for ensuring that workplace and disposal practices are in compliance with applicable laws and other government enactments. Haymes Paint assumes no obligation or liability for the information in this document. No express warranties are given except for any applicable written warranties specifically provided by Haymes Paint. All implied warranties including those of merchantability and fitness for a particular purpose are expressly excluded.

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