

HAYMES PAINT INDUSTRIAL COATING SOLUTIONS

339 2K Epoxy Primer Base

Product Code: I339EPB

Product description

Haymes Paint 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. 339 2K Epoxy Primer can be used Wet on Wet and is tintable to all ICS colours.



Key Features

- ✓ Excellent anti-corrosive properties
- ✓ Excellent adhesion and durability
- ✓ Can be applied Wet on Wet
- ✓ Outstanding flexibility
- ✓ Easy to sand

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.

Product Name	Volume Solids %	Weight Solids %	Density g/mL	VOC g/L
339 2K Epoxy Primer	49.5	71.04	1.381	450.8

Surface Preparation



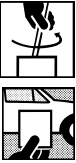








All Substrates



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



Special Notes:





- All surfaces must be thoroughly sanded and cleaned with Haymes Paint 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 Paint ICS 339 2K Epoxy Primer.		Haymes Paint ICS 339 Epoxy Primer Hardener.
		4 parts		1 part
	Reducer	10-20% (v/v) of Haymes Paint 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	2.0 mm	2.0 – 2.4bar 30 - 35psi	15 - 20cm 6 - 8inch
	Suction Feed	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. 1.6 – 2.0 mils	

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>Wet on Wet @ 25°C</td> <td>25-30 minutes before applying topcoat. Must be top coated within 48hrs, otherwise sanding will be required. Drying time listed may vary, depending upon film build, colour selection, temperature, humidity and degree of air movement.</td> </tr> <tr> <td>Low Bake @ 50°C</td> <td>30-40 min</td> </tr> </table>	Air Dry @ 25°C	3-4 hours	Wet on Wet @ 25°C	25-30 minutes before applying topcoat. Must be top coated within 48hrs, otherwise sanding will be required. Drying time listed may vary, depending upon film build, colour selection, temperature, humidity and degree of air movement.	Low Bake @ 50°C	30-40 min
	Air Dry @ 25°C	3-4 hours						
	Wet on Wet @ 25°C	25-30 minutes before applying topcoat. Must be top coated within 48hrs, otherwise sanding will be required. Drying time listed may vary, depending upon film build, colour selection, temperature, humidity and degree of air movement.						
Low Bake @ 50°C	30-40 min							
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.								

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

Dry Film Properties (after 7 days drying, when compared to similar technology products)	
Hardness	Excellent
Flexibility	Excellent
Chemical and water resistance	Excellent
Corrosion protection	Excellent
Durability	Excellent

Equipment Cleaning

Use Haymes Paint ICS Universal 2K Thinner.

Storage

Read the Safety Data Sheet (SDS) for this product for specific directions on storage (section 7 of the SDS) and transport (section 10 of the SDS). To obtain a copy of the SDS, go to the Haymes Paint website, <https://www.haymespaint.com.au/products/technical/product-data-sheets-and-safety-data-sheets/>, or contact Haymes Service Express on 1800 033 431. Containers must be secured and stored upright during transit. Protect from extremes of temperature. Store in a cool, dry, well-ventilated place and out of direct sunlight. Check regularly for leaks. Ensure the container label remains legible for future identification and usage.

Coverage

Approximately 8.0 m²/L @ recommended DFT.

Shelf Life: 36 months in an unopened container at room temperature away from sunlight.

Safety & First Aid

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public.

Read the Safety Data Sheet (SDS) for this product, prior to using this product. The SDS contains important information on how to use this product safely including hazards and precautions, personal protective equipment, storage and first aid in the event of an emergency. To obtain a copy of the SDS, go to the Haymes Paint website, <https://www.haymespaint.com.au/products/technical/product-data-sheets-and-safety-data-sheets/>, or contact Haymes Service Express on 1800 033 431.

If the product is swallowed, phone the Poisons Information Centre on 13 11 26 or contact a Doctor. Keep out of reach of children. Avoid contact with skin and eyes. Wear suitable, protective clothing, eye protection and impervious gloves when mixing and using.

Protect our environment

Do NOT pour any leftover product down the drain. Retain in a marked, sealed container for future use or disposal via chemical waste collection programs such as Paintback®. Visit www.paintback.com.au for details of your nearest depot. 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 an 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. Important safety information is available on the Safety Data Sheet available from Haymes Paint website www.haymespaint.com.au. Further information about other Haymes products recommended to be used in conjunction with this product are available from the website in the form of Product Data Sheets in relation to those products. We are continually updating materials and methods, so please ensure you have the latest information on the Haymes Paint website.

Disclaimer

The information provided in this Product Data Sheet is correct at the time of preparation, but is subject to change. It is your responsibility to check the Haymes Paint website at www.haymespaint.com.au to ensure that you have the most current Product Data Sheet. Product application and performance is affected by environmental conditions at the time of application and drying. Paint applied in conditions outside of what is recommended may dry more slowly or be less durable, or produce a less uniform appearance.

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Version	Version number	Date
Current	4.0	23/05/23
Supersedes	3.0	8/05/2023