KURUMA EPOXY PRIMER 4:1

Rev.01/26

Product Description

Kuruma Epoxy Primer 4:1 is excellent adhesion on steel, aluminium, galvanized steel, other light metals and ABS Plastic. It has excellent chemical resistance and high solids product. Can be applied NC lacquer, acrylic lacquer, 2K urethane primer and putty on Kuruma Epoxy Primer 4:1.

Substrate preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Mixing Ratio

- Two Component System

	Weight	Volume
Kuruma Epoxy Primer 4:1 Part A	100	100
Kuruma Epoxy Primer 4:1 Part B	16	25
Thinner	30-40	30-40

Mix Part A and Part B, strictly follow mix ratio recommendations before and stir for 2-3 minutes until the mixture is homogeneous before application.

- Pot life 8 hour after mixing @30^{0}C

Thinner

Kuruma Standard Thinner No.20

Viscosity For Spray

Viscosity Cup	Viscosity (sec) @ 30 oC
Ford Cup No.4	15 - 17

Spray gun Gravity Feed

Set-up Full pattern, Flow - 2.5 turns from fully closed set-up

Nozzle size 1.4 - 1.8 mm. (Please refer to spray gun manufacturer)

Spray pressure 1.5 - 2.0 Bar

Number of spray coats Recommended apply 2 coats

- Light to medium first coat
- Full wet second coat
- Dry film thickness 65 to 70 Microns

Flash-off time Between coat : 3 - 5 mins

Drying time

Drying time	Air dry (30 ^{o}C)
Surface dry	25 - 30 mins
Sanding	6 - 8 hrs
Full cure	7 days

Handling and Storage

The product must be stored in accordance with national regulations. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition.

Shelf life

- 48 months at <40 ^{0}C

Safety and Disposal

- Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.
- For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Safety Data Sheet.