MEGA EPOXY PRIMER 4:1

Rev.01/26

Product Description

Mega 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 Mega 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
Mega Epoxy Primer 4:1 Part A	100	100
Mega 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

Mega Standard Thinner No.20

Viscosity For Spray

	Viscosity (sec) @30^{o}C
Ford Cup No.4	15 - 17

Spray gun

Gravity Feed

Set-up

Full pattern

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.