

Sector: ACE

274/0296**with Hardener 045/0268**

Date of Issue: 17/06/2009

Technical Data Sheet

Buff High Build Two-Pack Epoxy Primer

A high performance two-pack epoxy primer designed to meet the exacting requirements of the agricultural and construction equipment markets.

Colour: Buff
Gloss: Matt

COMPOSITION DETAILS

Binder: Epoxy / Polyamide
Pigment: Inorganic
Solvents: Aromatic Hydrocarbons and Alcohols
Density: 1.35 ±0.05 kg/l Base
0.91 ±0.02 kg/l Hardener
1.24 ±0.04 kg/l Mixed
Weight Solids: 60.3 ±2% Base Component
33 ±2% Hardener
55 ±2% Mixed
Volume Solids: 40.2 ±2% Base Component
29.25 ±2% Hardener
37 ±2% Mixed
VOC Content: 558 g/l base
612 g/l hardener
Mix Ratio: 3 unit(s) 274/0296 to 1 unit(s) 045/0268 by Volume
100.0 unit(s) 274/0296 to 22 unit(s) 045/0268 by Weight
Pot Life: 4 - 6 hours @ 25° C

RECOMMENDED APPLICATION DETAILS

Dry Film Thickness: 40 - 100 microns
Wet Film Thickness: 107 - 267 microns
Theoretical Coverage: 9.4 m²/litre at 40 microns dry film (375 m²/litre at 1 micron dry). Assuming no losses.
Substrate: Steel
Surface Preparation: Designed for application to ferrous substrates which should be dry and free from all contamination such as oil, grease, rust, dirt etc. Substrate should preferably be gritblasted to 50-75 microns profile and / or treated with a suitable phosphate treatment.

It is also suitable for application to untinted or neutral shade rigid plastic mouldings (DCPD,

All information and data provided herein is, to the best of our knowledge, true and accurate and is given in good faith.

However no guarantee of results is implied as the conditions of use are beyond our control.

SMC, GRP etc). Inspect for visible porosity and fill as appropriate, then abrade surface as necessary. The surface should be free of release agents and other contaminants prior to painting and should be prepared if priming is outside the normal coating times.

Application Method: Airmix
Application Viscosity: RFU
Application Method 2: Airless Spray
Application Viscosity: RFU
Application Method 3: Conventional Spray or HVLP
Application Viscosity: 25 - 35" F4 @ 20°C **Thinner:** 046/0085
Cleaning Solvent: 400/0090

Application Notes: The use of plural component mixing equipment is recommended.
For shot blasted substrates dry film thickness should be a minimum of 50microns above shot profile. For non-shot blasted substrates dry film thickness should be a minimum of 60microns.

CURING

Force Dry - Flash Off: 10 minutes
- Cure: 30 minutes at 80°C
Overcoating: 274 line primers can be overcoated with a variety of finishes after a flash off time of 20 minutes at 20°C

At temperatures below 12°C the cure rate is insufficient for normal production conditions. Extra time should therefore be allowed before storing painted parts outside, even if they have been force dried. If painted parts are shipped in a primed condition, it is recommended that the primer is force dried according to the above schedule.

Information relating to application parameters and curing schedules will vary from plant to plant and for precise information relating to specific circumstances please contact your local

Health & Safety Data: Always follow any instructions on the containers and refer to the Product Safety Data Sheets before use. Safety data sheets are available from your local sales office.
Storage Conditions: The product should be stored out of direct sunlight and between temperatures of 0 and 30°C
Shelf life: 12 months in unopened containers
Flash point: 21-32°C ASTM D 93.

Product Reference: 274/0296

Date Of Issue: 17/06/2009

All information and data provided herein is, to the best of our knowledge, true and accurate and is given in good faith.

However no guarantee of results is implied as the conditions of use are beyond our control.