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**AUTOSURFACER® EP**


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**DESCRIPTION:** A gray color, multi-functional, chromate-free epoxy primer, which can be used as a medium build primer surfacer or a wet-on-wet primer sealer. Autosurfacer EP offers excellent chemical resistance and rust inhibition. Autosurfacer EP is the perfect choice for vehicle restorations, or when a primer is desired prior to the application of bodyfillers.

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**PRODUCT & ADDITIVES:**

**PRODUCT:** Autosurfacer EP

**HARDENERS:** Autosurfacer EP Hardener

**REDUCERS:**




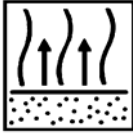


- High Performance Reducer Fast: a cool temperature reducer.
- High Performance Reducer Medium: a medium temperature reducer.
- High Performance Reducer Slow: mainly used for overall refinishing.
- High Performance Reducer Extra Slow: a very slow reducer for large areas and overall refinishing in very warm weather. Temperature of 90°F (32°C).

**BASIC RAW MATERIAL:**

Autosurfacer EP: epoxy resins  
 Autosurfacer EP Hardener: polyamide resins

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**APPLICATION:**

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|----|---|--|----|---|--|
| 1. |  | Contains epoxy resins. When mixed with hardener, also contains polyamides.           | 4. |  | 1 coat as sealer<br>2-3 coats as primer surfacer<br>HVLP Siphon 1.8–2.2 mm<br>HVLP Gravity 1.3–1.5 mm<br>Max 10 psi (at the air cap) |
| 2. |  | 100:50:30<br>Autosurfacer EP<br>Autosurfacer EP Hardener<br>High Performance Reducer | 5. |  | 5–10 minutes at 70°F (20°C)  |
| 3. |  | Use the Sikkens Measuring Stick #1 (Black).  | 6. |  | (Wet-on-Wet)<br>15–30 minutes at 70°F (20°C)<br>(Sanding)<br>Overnight at 70°F (20°C)  |
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**SUITABLE SURFACES:**

Autosurfacer EP can be applied over the following surfaces:

- Existing finishes, degreased and sanded with #P360 to #P400 grit paper dry or #P500 to #P600 grit wet.
- Any premium polyester bodyfiller, final sanded with #P220 to #P360 grit dry paper.
- Kombi Putty sanded with #P500 to #P600 grit wet or #P360 to #P400 grit dry.
- Steel, degreased and sanded with #P80 then #P120 grit dry.
- Galvanized steel, degrease and sand with #P120 to #P180 grit dry.
- Aluminum degreased and sanded with #P150 to #P180 grit dry.
- Fiberglass and SMC degrease and sand with #P320 to #P360 grit dry.

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**AUTOSURFACER<sup>®</sup> EP**


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- NOTE:** Do not apply this product to substrates that have been pre-treated with Sikkens Washprimers.
- MIXING RATIO:** 100 parts by volume of Autosurfacer EP  
 50 parts by volume of Autosurfacer EP Hardener  
 30 parts by volume of High Performance Reducer  
 For easy and accurate mixing, use the Sikkens Measuring Stick #1 (Black).
- MIXING NOTE:** Mix the epoxy material and the hardener together, stir, then add the reducer and stir thoroughly.
- SPRAYING VISCOSITY:** The proper spraying viscosity is achieved by using the proper mixing ratio. 13–16 seconds DIN cup #4 at 70°F (20°C).
- POT LIFE:** After the components have been mixed, the pot life is:  
 8 hours at 70°F (20°C).
- NOTE:** At the beginning of each application, thorough stirring of the mixed product is recommended.

**SPRAY GUN  
& PRESSURE:**

	<b>Fluid Tip</b>	<b>Spraying Pressure</b>
Siphon Feed	(1.6–1.8 mm)	40–50 psi
Gravity Feed	(1.3–1.4 mm)	40–50 psi
HVLP Gravity	(1.3–1.5 mm)	max 10 psi at the air cap

**APPLICATION  
METHOD:**

- As a wet-on-wet sealer.** Apply one medium flowing coat.
- As a primer surfacer that will be sanded.** Apply 2-3 medium flowing coats, allowing 10-15 minutes flash-off time between coats.
- As a substrate for polyester products, Polysoft, etc.** Apply one single coat over the damaged area. Allow this to dry for 30 minutes at 70°F (20°C), (or up to 5 hours) before applying a polyester filler. (Please see "Recoatibility" section.)

**AUTOSURFACER® EP**

**DRYING TIMES:**

	<b>70°F (20°C)</b>	<b>140°F (60°C)</b>
Recoatible wet-on-wet	15 minutes	N/A
To sand	12 hours	45 minutes
Recoatible with polyester products	30 minutes	10 minutes

**SANDING:**

After the stated "Dry to Sand" time, Autosurfacer EP should be sanded with #P400 to #P500 grit paper dry or #P600 to #P800 grit wet before topcoating.

**RECOATABILITY:**

After the stated flash time, Autosurfacer EP can be recoated with Sikkens topcoats and Sikkens primer surfacers for up to 48 hours without sanding. After 48 hours, sanding will be required to insure intercoat adhesion.

Recoatible with polyester products after the stated dry time. Autosurfacer EP can be coated with a polyester product, such as Polysoft or Polystop LP. Making it an ideal damage repair system on steel, galvanized steel and aluminum. After the polyester product and the Autosurfacer EP have dried, sand the polyester material until satisfied with the repair. For further priming, any Sikkens primer/primer surfacer may be applied that is recommended for the substrates exposed. All Sikkens primers may be applied over sanded Autosurfacer EP.

**STOCK KEEPING:**

**COLOR:** Medium Grey

**CONTAINER**

**SIZE:** Autosurfacer EP: 1 quart (946 ml) and 1 gallon (3.785 lt)  
Autosurfacer EP Hardener: 1 pint (473 ml) and 1 gallon (3.785 lt)

**SHELF LIFE:** Autosurfacer EP: Two years when stored unopened at room temperature.  
Autosurfacer EP Hardener: One year when stored unopened at room temperature.

**SAFETY ASPECTS:**

**READY TO  
SPRAY VOC:**

Autosurfacer EP (100:50:30): 4.6 lb/gal 500 g/liter

**NOTICE:**

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.