
AUTOCOAT® LV EPOXY

DESCRIPTION: Autocoat LV Epoxy is a 3.5 VOC, high-solids, epoxy primer sealer that can be used two different ways:

- 1) As a non-sanding primer-sealer that can be top coated with Autocoat LV or Autobase® Plus or Autocoat LV (Solid color), providing good build, adhesion and corrosion resistance.
- 2) As a primer-surfacer that will be sanded for extra smoothness and maximum appearance.

*Check local VOC regulations before using Autocoat LV Epoxy as a primer surfacer.

PRODUCT & ADDITIVES:

PRODUCT: Autocoat LV Epoxy




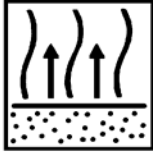


HARDENER: —Autocoat LV Hardener Epoxy.

REDUCERS: —Autocoat LV Reducer Epoxy.

BASIC RAW MATERIALS:

— Autocoat LV Epoxy: epoxy resins.
 — Autocoat LV Hardener Epoxy: modified polyamine resins.

APPLICATION:

- | | | | | | |
|----|---|--|----|--|---|
| 1. |  | Contains epoxy resins, ketone and other ingredients. When mixed with hardener, also contains polyamines. | 4. |  | 1-2X1
HVLP Siphon (1.8-2.2 mm)
HVLP Gravity (1.5-1.7 mm)
Max 10 psi (at air cap) |
| 2. |  | 3:1:1
—Autocoat LV Epoxy
—Autocoat LV Hardener Epoxy
—Autocoat LV Reducer Epoxy | 5. |  | 5 - 10 minutes at 70°F (20°C) |
| 3. |  | Use the Sikkens Measuring Stick # 9 (Grey). | 6. |  | (Wet-on-wet)
30 minutes at 70°F (20°C)
Maximum
7 hours at 70°F (20°C) |

AUTOCOAT® LV EPOXY**SUITABLE SURFACES:**

Sikkens Autocoat LV Epoxy can be applied over the following surfaces:

- Existing finishes, with the exception of thermoplastic acrylic lacquers, degreased and sanded with #P320 to #P400 grit paper dry or #P400 to #P500 grit wet.
- Steel, degrease and sand. Remove any mill scale by sandblasting if necessary, then final sand with #P80 then #P120 grit dry.
- Galvanized steel, degrease and sand with #P150 to #P180 grit dry.
- Aluminum, degrease and sand with #P150 to #P180 grit dry.
- Fiberglass, (unbroken gelcoat) degrease and sand with #P320 grit dry.
- Any premium polyester bodyfiller final sanded with #P180 to #P220 grit dry.

NOTE:

Do not apply this product to substrates that have been pre-treated with a chemical cleaner (metal prep).

MIXING RATIO:

Mix 3 parts by volume of Autocoat LV Epoxy with
1 part by volume of Autocoat LV Hardener Epoxy, with
1 part by volume of Autocoat LV Reducer Epoxy.
For easy and accurate mixing, use the Sikkens Measuring Stick #9 (Grey).

SPRAYING VISCOSITY:

25–28 sec. ZAHN cup #2 (23–26 sec. DIN cup #4) at 70°F (20°C).

POT LIFE:

1–1/2 hours at 70°F (20°C).

SPRAY GUN & PRESSURE:

	Fluid Tip	Spraying Pressure	Fluid Pressure
HVLP Gravity	0.059"–0.067" (1.5–1.7 mm)	max. 10 psi (at air cap)	
HVLP Siphon	0.071"–0.087" (1.8–2.2 mm)	max. 10 psi (at air cap)	
HVLP Pressure feed	0.039"–0.047" (1.0–1.2 mm)	max. 10 psi (at air cap)	8–10 psi (0.6–0.8 bar)
Airless spray	0.011"/ 65° 0.013"/ 80°		2000–4000 psi (140–160 bar)

APPLICATION METHOD:

As a wet-on-wet primer sealer, apply one medium flowing coat. On breakthrough areas of existing finish, to bare metal, apply an initial thin coat over these areas, allow a flash time of 5–10 minutes, continue with the one medium flowing coat.

As a primer surfacer that will be sanded, apply two single flowing coats allowing a flash-off time between coats.

NOTE:

In some VOC regulated areas, this product may not be used as a primer surfacer.

FLASH TIMES:

10 minutes at 70°F (20°C). After this time the applied Autocoat LV Epoxy should have a matt appearance.

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DRYING TIME:

Recoatable	50°F (10°C)	70°F (20°C)	100°F (38°C)	140°F (60°C)
Wet-on-wet	1 hour	30 minutes	15 minutes	10 minutes
To sand	24 hours	10 hours	2 hours	1 hour

NOTE:

The maximum recoat time without sanding is 7 hours at 70°F (20°C). After this time, allow the appropriate dry to sand time, as sanding is required before top coating.

RECOATABILITY: After the stated dry time for "Recoatability wet-on-wet", Autocoat LV Epoxy can be top coated as a wet-on-wet system with: Autocoat LV (Solid Color) and Autobase® Plus. After the stated "dry to sand" time, Autocoat LV Epoxy should be sanded, then it may be top coated with those Sikkens top coats listed.

SANDING:

After the stated "dry to sand" time, Autocoat LV Epoxy should be sanded with #P400 to #P500 grit paper dry or #P500 to #P600 grit wet before top coating.

FILM**THICKNESS:**

Approximately 1.2–1.4 mils per single flowing coat.

**CLEANING OF
EQUIPMENT:**

Clean equipment with Sikkens Low VOC Cleaning Solvent.

COVER RATE:

Approximately 140 sq. ft./liter of unmixed paint per single coat.

STOCK KEEPING:**COLOR:**

Grey.

**CONTAINER
SIZE:**

Autocoat LV Epoxy: 1 gallon (3.785 lt)
Autocoat LV Hardener Epoxy: 1 gallon (3.785 lt)
Autocoat LV Reducer Epoxy: 1 gallon (3.785 lt)

SHELF LIFE:

Autocoat LV Epoxy: 1 year if stored unopened at room temperature.
Autocoat LV Hardener Epoxy: 1 year if stored unopened at room temperature.
Autocoat LV Reducer Epoxy: 1 year if stored unopened at room temperature.

SAFETY ASPECTS:**READY TO
SPRAY VOC:**

3:1:1

3.5lb/gal

420g/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.