



Autocoat BT

FOR PROFESSIONAL USE ONLY

Autocoat BT LV360 EP 2.1 is a two-component high solids corrosion inhibitive epoxy primer. LV360 Epoxy Primer 2.1 is a low VOC, high solids, HAPs-Free epoxy primer that can be applied as a wet on wet sealer or as a sandable primer surfacer. The ready to spray VOC is 2.1 lbs/gal and is supplied in black, white and grey.

	Safety Considerations Use suitable personal protection. AkzoNobel recommends the use of a fresh air supply respirator. Refer to the product Safety Data Sheet (SDS) for more complete safety information.			
Stick #2	Mixing 2 1 10%	LV360 Epoxy Primer EP 2.1 LV360 Epoxy Hardener 2.1 Flow Enhancer or CV Exempt Reducer (optional-use for improved appearance)		
	HVLP or C	Compliant Spray-Gun Set-Up:	Application Air Pressure:	
	1.4-1.7 mm		28-30 psi (1.7-2.2 bar) at the spray gun air inlet HVLP – 10 psi at the air cap maximum.	
	Application			
	Apply 1-2 single flowing coats			
	Flash Between Coats at 70°F (21°C)		Flash Before Topcoat at 70°F (21°C)	
<u>/†/†/</u>	10 minutes		30 minutes	
Ē	Air Drying at 70°F (21°C)		Force Drying at 140°F (60°C)	
	Dry to sand 6 hours		Dry to sand 1 hour	
	Re-Coatal	ole With:		
	• LV650	Topcoat		
	• LV650	Basecoat		

Read complete TDS for detailed product information.



North America

LV360 Primer EP 2.1™

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Description

Autocoat BT LV360 EP 2.1 is a two-component high solids corrosion inhibitive epoxy primer. LV360 Epoxy Primer 2.1 is a low VOC, high solids, HAPs-Free epoxy primer that can be applied as a wet on wet sealer or as a sandable primer surfacer. The ready to spray VOC is 2.1 lbs/gal and is supplied in black, white and grey.

Suitable Substrates

- Existing finishes
- Aluminum (Alodine)
- Aluminum (Autoprep)
- Steel
- · Galvanized steel

Do not apply Autocoat BT LV360 Primer EP 2.1 over Thermoplastic Acrylic Laquers

Properly degrease the substrate prior to sanding with M600, Ultra Prep AutoPrep, or equivalent cleaner. Other chemical cleaners and pre-treatments need to be pre-approved by AkzoNobel.

Products and Additives

Product	LV360 Primer EP 2.1 Grey LV360 Primer EP 2.1 White LV360 Primer EP 2.1 Black The LV360 Primer EP 2.1 Grey and Black are also supplied in 40 gallon drums. Please check the price list for details.	Item #398881 Item #398882 Item #483163
Hardeners	LV360 Primer Hardener EP 2.1	Item #398883
Activators	Flow Enhancer CV Exempt Reducer	Item #385098 Item #391191

The item numbers listed above are for 1 gallon containers. Several products are available in additional package sizes. Please reference the price list for additional information.

Basic Raw Materials

- LV360 Primer EP 2.1 Epoxy Resins
- LV360 Primer Hardener EP 2.1 Polyamide resins





Technical Data Sheet Primer 12.01.2015

LV360 Primer EP 2.1™

Substrate Preparation

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Pre-Cleaning	
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- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with Sikkens M600 or Ultra Prep AutoPrep surface cleaners.
 - Avoid saturating body filler with water or cleaners while washing the repair.

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Sanding Preparation	ı		
	Dry Sanding	Wet Sanding	Pre-Treatment
Existing Finishes	#P320 – #P400	#P500 – #P600	
Steel	#P80 then #P120	N / A	B1000 Metal Pre- Treatment
Galvanized Steel	#P120 – #P180 Or red scuff pad	N / A	
Aluminum	#P180 – Red Pad	N / A	Deoxidine 457 and Alodine 5700
Aluminum	#P180 – Red Pad	N / A	AutoPrep Pre- Treatment Wipes



Surface Cleaning – Prior to Paint Application

Clean with Sikkens M600 or Ultra Prep AutoPrep surfacer cleaner.

Product Characteristics

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WPG (A Component)	14.4-15.9 lbs/gal
Volume Solids (RTS)	55% +/- 2%
Theoretical Coverage	888 ft2/gal @ 1mil 100% transfer efficiency
Gloss	Low
Color	Black, white, grey
Potlife @ 70°F (21হC)	4 hours

Mixing

: #2 Stick	2 1 Max 10%- 20%	Parts by volume LV360 Primer EP 2.1 Parts by volume LV360 Primer Hardener EP 2.1 Parts by volume Flow Enhancer or CV Exempt Reducer for improved leveling
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Tinting

Tinting of the primer can be done by adding a maximum of 5% by volume with Autocoat BT Toners.

Add toners before activating with hardener.

Viscosity When Mixed at 70°F (21°C)

	EZ ZAHN #2	35-45 seconds	
	Din #4 Cup	23-27 seconds	
$\zeta \gamma^{s}$	EZ Zahn #3	13-16 seconds	
		Viscosity is reported without the addition of Flow Enhancer or CV Exempt Reducer.	

Spray Gun Set-Up

 Consult spray gun manufactures instructions for specific spray gun pressure specifications.				
Spray Gun	Fluid Tip	Application Pressure	Fluid	
HVLP – Pressure Feed	1.0 – 1.2mm	Max 10psi	10 – 14 oz/min	
HVLP – Gravity Feed	1.2 – 1.4mm	Max 10psi		
HVLP – Siphon Feed	1.8 – 2.2mm	Max 10psi		
Pressure Feed	1.0 – 1.2mm	50 – 60psi	12 – 16 oz/min	
Siphon Feed	1.6 – 1.8mm	50 – 60psi		
RP Gravity Feed	1.4 – 2.2mm	30 – 35psi		
Electrostatic	1.2 – 1.7mm	35 – 65psi	12 – 14 oz/min	
Airless Spray	0.011 – 0.015in	1500 – 3000psi		
Air Assisted Airless	0.011 – 0.015in	700 – 900psi		

Application

Wet on wet primer sealer – Apply 1 medium flowing coats

As a transport coating - Apply 2 single flowing coats



Recommended application temperature is between $60^{\circ}F - 95^{\circ}F$ ($15^{\circ}C-35^{\circ}C$) and a maximum relative humidity of 90%.





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Film Thickness – Using Suitable Application

Primer Sealer – 1.2-1.4 mils of dry filmthickness

Primer Surfacer Sanded or Transport Primer – Minimum of 2.0 mils

Apply 1.2-1.4 mils per coat

Flash Times



10 minutes between coats at 70°F (21°C) 30 minutes final flash before topcoating at recommended filmbuild 70°F (21°C) 45-60 minutes final flash before topcoating at high build 70°F (21°C)

Drying / Curing Time

Drying times are stated a recommended application method, film thickness and object temperature.

	Object Temp	Before Topcoat	Dry to Sand
	70°F (21°C)	30 min	6 hours
(->)	100°F (38°C)	15 min	2 hours
	140°F (60°C)	10 min	1 hour

Recoating

LV360 Primer EP 2.1 at 1.2 -1.4 mil DFT can be topcoated after a final flash of 30 minutes at 70°F (21°C). For higher film thicknesses, allow a 45 – 60 minute final flash for optimum topcoat appearance.

Non-sanded LV360 Primer EP 2.1 must be topcoated within 3 months. After 3 months, LV360 Primer EP 2.1 must be sanded prior to topcoating.

Recoatable With

LV650 Topcoat LV650 Basecoat LV650 FormCoat LV650 SpeckCoat Do not apply polyester bodyfillers over LV360 Primer EP 2.1





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Cleaning of Equipment



Clean equipment following local and federal regulations. In compliant localities, use Sikkens LV Cleaning Solvent or high quality solvent borne gun cleaner. For national rule regions, use Sikkens Cleaning Solvent 790 or high quality lacquer thinner.

VOC / Regulatory Information

LV360 Primer EP 2.1 2.1 lb/gal 250 g/l

VOC is ready to spray at a mix ratio of 2:1 + 10% Flow Enhancer

Product Storage

Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (20°C).	
LV360 Primer EP 2.1	2 years
LV360 Hardener EP 2.1	1 year
Flow Enhancer	2 years

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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