
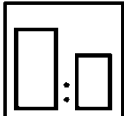


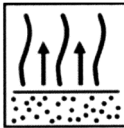

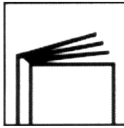
	North America	Technical Data Sheet
	Autocoat LV Epoxy CIP 3.5 VOC™	
	Primer 12.02.2015	
FOR PROFESSIONAL USE ONLY		


Description

A two-component high solids corrosion inhibitive epoxy primer. Autocoat LV Epoxy CIP is a low VOC, high solids, HAPs-Free epoxy primer sealer. The ready to spray VOC is 3.5 lbs/gal. Autocoat LV Epoxy CIP is a versatile product that can be applied in a couple of different methods:

1. As a wet on wet, non-sanded primer-sealer. Topcoated with Autocryl, Autocoat BTLV or Autocoat LV.
2. As a primer-surfacer that can be sanded for extra smoothness and maximum appearance prior to topcoating.
3. As a transport primer
4. As a sealer, re-coated over aged Autocoat LV Epoxy CIP (see recoatability)

	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%	Autocoat LV Epoxy CIP Autocoat LV Epoxy CIP Hardener Flow Enhancer or CV Exempt Reducer (optional-use for improved appearance)
	HVLP or Compliant Spray-Gun Set-Up: 1.4-1.7 mm	Application Air Pressure: 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) 10 minutes	Flash Before Topcoat at 70°F (21°C) 30 minutes
	Air Drying at 70°F (21°C) Before topcoat 30 minutes Dry to sand 6 hours	Force Drying at 140°F (60°C) Dry to sand 1 hour
	Re-Coatable With: <ul style="list-style-type: none"> • LV650 Topcoat • LV650 Basecoat 	

Read complete TDS for detailed product information.

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Suitable Substrates

- Existing finishes
- Aluminum (Alodine)
- Aluminum (Autoprep)
- Steel
- Galvanized steel
- Polyester Bodyfiller
- Fiberglass gelcoat

Do not apply Autocoat LV Epoxy CIP over Thermoplastic Acrylic Laquers

Sikkens Polysurfacer is an approved bodyfiller. Consult AkzoNobel for alternate bodyfiller approval.

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	Autocoat LV Epoxy CIP Grey	Item #382064
	Autocoat LV Epoxy CIP White	Item #382076
Hardeners	Autocoat LV Epoxy CIP Hardener	Item #384291
Activators	Flow Enhancer	Item #385098
	CV Exempt Reducer	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

- Autocoat LV Epoxy CIP – Epoxy Resins
- Autocoat LV Epoxy CIP Hardener – Polyamide resins


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Substrate Preparation

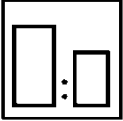
	Pre-Cleaning <ul style="list-style-type: none"> If needed pre-wash the repair with warm soap and water. Rinse completely with clean water. Clean with Sikkens M600 or Ultra Prep AutoPrep surface cleaners. Avoid saturating body filler with water or cleaners while washing the repair. 			
	 	Sanding Preparation		
		Dry Sanding	Wet Sanding	Pre-Treatment
Existing Finishes		#P320 – #P400	#P500 – #P600	
Steel		#P80 then #P120	N / A	B1000 Metal Pre-Treatment
Blasted Steel				
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
	Polyester Bodyfiller	#P180 - #P220		
	Fiberglass Gelcoat	#P180 - #P220		
	Surface Cleaning – Prior to Paint Application <ul style="list-style-type: none"> Clean with Sikkens M600 or Ultra Prep AutoPrep surfacer cleaner. 			

Product Characteristics

WPG (A Component)	13.7-14.5 lbs/gal
Volume Solids (RTS)	54% +/- 2%
Theoretical Coverage	832 ft ² /gal @ 1mil 100% transfer efficiency
Gloss	Low
Color	White and grey
Potlife @ 70°F (21°C)	4 hours

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Mixing

 #2 Stick	2 1 Max 10%	Parts by volume Autocoat LV Epoxy CIP Parts by volume Autocoat LV Epoxy CIP Hardener Parts by volume Flow Enhancer or CV Exempt Reducer for improved leveling


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	30-40 seconds
	Din #4 Cup	18-24 seconds
	EZ Zahn #3	11-14 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		

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Application

	Wet on wet primer sealer – Apply 1 medium flowing coats As a transport coating – Apply 2 single flowing coats Primer Surfacer (sanded) – Apply 2 single flowing coats Recommended application temperature is between 50°F – 95°F (10°C-35°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
Sandblasted surfaces – Minimum of 1.5 mils over blast profile
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)
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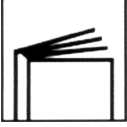
Drying / Curing Time

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

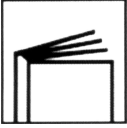
	Object Temp	Before Topcoat	Dry to Sand
	50°F (10°C)	1 hour	24 hours
	70°F (21°C)	30 min	6 hours
	100°F (38°C)	15 min	2 hours
	140°F (60°C)	10 min	1 hour

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Recoating

	<p>Autocoat LV Epoxy CIP 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.</p> <p>Non-sanded Autocoat LV Epoxy CIP must be topcoated within 3 months when stored at constant temperature without extreme conditions.</p> <p>After 3 months, Autocoat LV Epoxy CIP must be sanded prior to topcoating.</p>
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Recoatable With

	<p>LV650 Topcoat LV650 Basecoat LV650 FormCoat LV650 SpeckCoat</p> <p>Do not apply polyester bodyfillers over Autocoat LV Epoxy CIP</p>
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Cleaning of Equipment


	<p>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.</p>
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VOC / Regulatory Information

	Autocoat LV Epoxy CIP 3.5 lb/gal 420 g/l VOC is ready to spray at a mix ratio of 2:1 + 10% Flow Enhancer
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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).	
	Autocoat LV Epoxy CIP	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 carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of 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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