

## **Technical data**

## **Rustbuster Custom 421 Epoxy primer**

### **Product description**

Custom 421 is a two pack epoxy primer based on a high molecular weight epoxy resin.

### **Recommended use**

Anticorrosive primer to be used in a full coating system. Can be used on steel, galvanised steel or aluminium as well as GRP(polyester)

May be over coated with single or two pack coatings.

Colour;	Grey or Red
Solids:	51%
Specific gravity;	1.1 -1.3 (after mixing)
Flash point;	25 c (Setaflash)
Flexibility:	Good
Gloss:	Flat
Water resistance:	Very good
Chemical resistance:	Excellent
Solvent resistance:	Excellent
Abrasion resistance:	Very good
Application range:	80 – 120 microns wet film thickness / 40 – 60 microns dry film thickness
Application data:	By conventional spray, industrial airless or brush for smaller areas.
Mix ratio:	4 parts comp A (base) to be mixed thoroughly with 1 part comp B ( curing agent)
Pot life 23 c:	8 hours reduced at higher temp
Thinner cleaner:	Rustbuster No 17
Drying/cure times:	23c Surface dry 60 mins Hard dry 6.5 hours Re-coat min. 4 hours  Lower temperatures will retard the drying cure times, higher temperatures will improve the drying cure times. Flash until matt between coats.
Surface preparation:	D.A or power tool cleaned steel to St2 ( ISO 8601-1:1988/SS 05 5900) Blast cleaned steel to SA 2.5 (ISO 8501-1:1988/SS 05 5900) Aluminium D.A. sand with 120 abrasive GRP must be sanded and washed.

Previously painted:

Clean original paint surfaces to be painted with Rustbuster SP10 and water, rinse and wipe dry. Degrease all repair areas with a silicone remover. Applying to the area using a spray atomiser or lint free cloth. Wipe dry the silicone remover with another lint free cloth.

Dry sand with p280 – p320

Sand bare areas with grey Scotchbrite and silicone remover. Wipe off/dry any excess silicone remover with a lint free cloth. Wipe dry and tack wipe before priming.

Thinning:

Maximum thinner required is 20%, for primer filling 10% should be sufficient.

Using Polyester fillers:

Make sure the primer is cured. Dry sand with p280-p320. Take care not to break through the primer any breaches in the coating will need to be spot repaired before filling. Degrease with silicone remover. Wipe dry and tack wipe. The surface is now ready for filling. A further coat of Epoxy 421 can be applied over the finished filler prior to painting.

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