



Effective 3 November, 2008

# 840R

## VOC EPOXY PRIMER SURFACER

### Description

2-component chromate-free epoxy primer surfacer.  
Colour: off white.  
Composition based on epoxy resin.

### Products

840R	VOC Epoxy Primer Surfacer
845R	Epoxy Activator
AU370	Polyurethane Thinner
XB383	Standard Thinner
XB387	High Temperature Thinner

### Properties

- Very good corrosion and chemical resistance.
- Excellent adhesion on properly treated metal substrates.
- Recommended as a 1<sup>st</sup> coat over bare metals.
- Very good filling properties. Suitable for use over rough substrates e.g. gritblasted metals.
- High humidity resistance and good flexibility.
- Can be tinted with AM Centari<sup>®</sup> MasterTints<sup>®</sup> (up to max. 10 % by weight).
- Can be coated with DuPont Refinish 2K surfacers or DuPont Refinish topcoats.
- VOC compliant, conform with directive 2004/42/EC.

### Substrates

- Bare metals: steel, aluminium and galvanised steel.
- OEM finishes.
- Cured repair finishes.
- DuPont Refinish polyester putties.

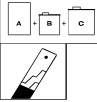









Effective 3 November, 2008

# 840R

## VOC EPOXY PRIMER SURFACER

### PRODUCT PREPARATION

	<b>Mixing ratio</b>	<b>Sanding primer surfacer</b>		<b>Non-sanding primer surfacer</b>	
		Volume	Weight	Volume	Weight
	840R	3	100	4	100
	845R	1	17.5	1	13
	AU370/XB383	1	17.5	-	-
	XB387	-	-	1.5	19.5
	<b>VOC</b>	< 540 g/l			
	<b>Pot life at 20°C</b>	8 hr			
	<b>Spray viscosity at 20°C</b>	<b>3:1:1</b>		<b>4:1:1.5</b>	
		<b>DIN 4</b>	16-20 s	16-19 s	
	<b>FORD 4</b>	16-21 s	16-20 s		
	<b>AFNOR 4</b>	18-23 s	18-22 s		
	<b>Spray equipment</b>	<b>Conventional guns</b>	<b>Fluid tip</b>	<b>Distance</b>	<b>Pressure</b>
		Gravity feed	1.4-1.6 mm	20-25 cm	3-4 bar
	Suction feed	1.6-1.8 mm	20-25 cm	3-4 bar	
	Pressure feed	1.1-1.4 mm	20-25 cm	3-4 bar	
	<b>Compliant guns (HVLPH/TE)</b>				
	Gravity feed	1.4-1.5 mm	15 cm	According to supplier's specifications	
	Suction feed	1.5-1.7 mm	15 cm		
	Pressure feed	1.1-1.4 mm	15 cm		
	<b>Number of coats</b>	1-2			
	<b>Flash time</b>	Between coats till flat.			
		Before recoating:		minimum	maximum
	2K surfacers		30 min	3 days	
	topcoats		1 hr	3 days	
	<b>DFT</b>	25-30 µ/coat			
	<b>Dry to sand at 20°C at 60°C</b>	O.N.			
		35 min			
	<b>IR drying*</b>	Distance	80 cm	* Guideline for short/medium wave IR equipment.	Not applicable.
		Half power	5 min		
		Full power	15-20 min		

This data relates only to the material designated herein and does not apply to use in combination with any other material or any process. The data is not to be considered as a warranty or quality specification and we assume no liability in connection with its use.



Effective 3 November, 2008

# 840R

## VOC EPOXY PRIMER SURFACER

### RECOMMENDED USE

#### Surface preparation

Bare metals (steel, galvanised steel, aluminium or surface treated aluminium)

1. Clean surface with a DuPont Refinish preparatory cleaner for bare metals. Wipe dry with a clean cloth.
2. Sand and eliminate all rust and corrosion.
3. Remove all traces of sanding dust, blowing oil-free compressed air.
4. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.

OEM and cured repair finishes

1. Clean surface with water and soap. Rinse and dry.
2. Degrease with a correct DuPont Refinish preparatory cleaner. Wipe dry with a clean cloth.
3. Sand surface:
  - a. mechanical with P280 - P320;
  - b. wet with P600.
4. Remove all traces of sanding dust, blowing oil-free compressed air.
5. Degrease with a correct DuPont Refinish final cleaner/degreaser. Wipe dry with a clean cloth.

#### Equipment cleaning

Use a correct DuPont Refinish solventborne gunwash.



Effective 3 November, 2008

# 840R

## VOC EPOXY PRIMER SURFACER

### RECOMMENDED USE (con'd)

#### Remarks

- For optimum surface preparation gritblast to Sa 2 ½.
- Activated material should not be returned to original can of non-activated material.
- 840R can be applied by brush if no reducer is added to the activated material.
- DuPont Refinish polyester putties can be applied over cured, sanded 840R.
- Material has to be stirred well before use.
- Close can of activator tightly immediately after use, as this product will react with humid air and water and lose its hardening effect.
- For mixing rod information, see specific TDS.
- Material has to be at room temperature (18-25°C) before use.
- ValueShade® 2 (VS2) is equal to 100 % of 840R.
- ValueShade® 3 (VS3) can be obtained by adding 1.5 g of AM5 to 100 g of 840R.
- ValueShade® 4 (VS4) can be obtained by adding 5 g of AM5 to 100 g of 840R.
- ValueShade® 5 (VS5) can be obtained by adding 10 g of AM5 to 100 g of 840R.

#### Product data

Package viscosity: 340 cp  
Theoretical coverage: 3:1:1 6,1-7,3 m<sup>2</sup>/l at recommended DFT - ready-to-spray  
4:1:1,5 12,1-14,5 m<sup>2</sup>/l at recommended DFT - ready-to-spray  
Directive 2004/42/EC: The EU limit value for this product (product category: IIB(c)) in ready to use form is maximum 540 g/l of VOC. The VOC content of this product in ready to use form is maximum 540 g/l.

Products	Packages (l)	Shelf life at 20°C (year)
840R	3,5	2
845R	1 - 5	2
AU370	1 - 5	2
XB383	1 - 5 - 20	2
XB387	1 - 5	2

#### Safety

Consult Safety Data Sheet prior to use. Observe the precautionary notices displayed on the container.