

# DULUX<sup>®</sup> AUTOSPEED<sup>®</sup> 488 S0014 2K EPOXY PRIMER



Dulux Australia  
ABN 67 000 049 427

488 S0014 Dulux AUTOSPEED<sup>®</sup> 2K Epoxy Primer

## Product Name:

488-S0014 Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Epoxy Primer

## Product Description:

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Epoxy Primer is a two pack high build epoxy urethane primer that combines the benefits of epoxy toughness and hardness with urethane flexibility and durability. Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Epoxy Primer also has excellent rust inhibiting properties.

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Epoxy Primer is easy to sand and suitable for Dulux<sup>®</sup> AutoSpeed<sup>®</sup> PT Basecoat (440-Line), Dulux<sup>®</sup> AutoSpeed<sup>®</sup> PR 10:1 2K Topcoat (427-Line), Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K White 488-89289, Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Black 488-89843 and Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K 4:1 mixed colour (481-Line).

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K HS Primer (488-89287) and Dulux<sup>®</sup> AutoSpeed<sup>®</sup> Miracle HB (488-89907) Primer can be applied over Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Epoxy Primer.

## Substrates

All substrates must be thoroughly sanded and cleaned. It is recommended that Dulux<sup>®</sup> AutoSpeed<sup>®</sup> Prepwash 965-89784 is used for cleaning and degreasing of surfaces.

Suitably prepared surfaces:

- Existing finishes
- Polyester Filler
- Steel surfaces

## Product & Additives:

Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Epoxy Primer 488-S0014  
 Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K 4:1 Hardener- Normal 980-89291  
 Dulux<sup>®</sup> AutoSpeed<sup>®</sup> RP 4:1 Hardener- Fast 980-89794 Cold Temperatures/ Rapid Production  
 Dulux<sup>®</sup> AutoSpeed<sup>®</sup> 2K Thinner- Normal 920-89292  
 Dulux<sup>®</sup> AutoSpeed<sup>®</sup> RP Thinner - Fast 920-89819 Cold Temperatures/ Rapid Production  
 Dulux<sup>®</sup> AutoSpeed<sup>®</sup> Prepwash 965-89784



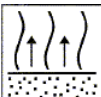




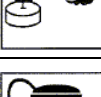
	<b>Mixing Ratio</b>	4 Part 488-S0014
	<b>Hardener</b>	1 Part 980-89291 Large Areas or 1 Part 980- 89794 Small Areas
	<b>Thinner</b>	10-20% 920-89292 or 920-89819 2 to 3 coats
	<b>Spray Viscosity</b> DIN Cup 4 @ 25°C	25 - 27 seconds
	<b>Gravity Feed</b>	<b>Fluid Tip:</b> CONVENTIONAL: 1.5 - 1.8mm HVLP: 1.5 - 1.9mm <b>Spraying Pressure:</b> 340 kPa. 70 kPa. Or refer to manufacturer's recommendations

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	<b>Suction Feed</b>	CONVENTIONAL: 1.7 - 2.0mm HVLP Gravity Feed: 1.8 - 2.2mm	340 kPa. 70 kPa. <small>Or refer to manufacturer's recommendations</small>
	<b>Application</b>	2 to 3 coats for a medium film build of 50 – 80 micron 3 to 4 coats for a high film build of approx. 100 micron	
	<b>Air Flash</b>	5 - 10 minutes air flash between coats. Minimum 30 minutes air flash when applying Dulux <sup>®</sup> AutoSpeed <sup>®</sup> 2K HS Primer (488-89287) or Dulux <sup>®</sup> AutoSpeed <sup>®</sup> Miracle HB Primer (488-89907) over Dulux <sup>®</sup> AutoSpeed <sup>®</sup> 2K Epoxy Primer.	
	<b>Baking/Drying</b>	5 hours @ 25°C when using Dulux <sup>®</sup> AutoSpeed <sup>®</sup> RP 4:1 Hardener-Fast (980-89794) or 6 hours @ 25°C when using Dulux <sup>®</sup> AutoSpeed <sup>®</sup> 2K 4:1 Hardener- Normal 980-89291.  45 mins @ 50°C	
	<b>Infrared</b>	<b>Short wave:</b> 8 mins <b>Medium wave:</b> 10 - 15 mins	
	<b>Sanding - Manual</b>	<b>Wet:</b> P600 - P800 Grit	
	<b>Sanding - Manual</b>	<b>Dry:</b> P400 - P600 Grit	
	<b>Sanding - Mechanical</b>	<b>Dry:</b> P400 - P600 Grit	
	<b>Spraying</b>	Use air fed mask at all times. Refer applicable AS/NZS Standards	
	<b>Pot Life</b>	When mixed, 2 hours @ 25°C	

### For Safe Handling:

Please refer to the Material Safety Data Sheet number: 697 for this product before use.

**In the event of an emergency contact: 1 800 033 111 (ALL HOURS)**

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### **For further information contact:**

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