

# DULUX® FleetShield® 488 ULTRABUILD EPOXY PRIMER



Dulux Australia  
ABN 67 000 049 427

## Product Description

Dulux® FleetShield® ULTRABUILD Epoxy Primer is a two pack epoxy- polyamide primer that has excellent adhesion to metal substrates. Ultrabuild contains anti-corrosion pigmentation and has excellent water resistance.

Dulux® FleetShield® ULTRABUILD Epoxy Primer is easy to sand. The top coat may be applied after 2 hours without sanding at 20°C. The primer may be top coated with nax Premila and Fleetshield 2K products without sanding up to 5 days after application of the primer if the temperature is below 20°C. The primer will require sanding prior to application of a topcoat after five days.

For applications which require rapid processing, the use of ULTRABUILD HP Pt B 980-S0069 allows ULTRABUILD Epoxy Primer to be topcoated between 30 minutes and 5 days after primer application without sanding where temperatures do not exceed 20°C.

Ultrabuild Cold Cure Thinner is to be used for application conditions where the temperature will fall below 10°C during curing. **Note, 920-S0063 Cold Cure Thinner and 980-S0069 Ultrabuild HP Hardener are not compatible.**

Suitable Dulux® FleetShield® and nax Premila top coats include:

Dulux® FleetShield™ 2K Mixed colour, 428 line  
Dulux® FleetShield™ 2K White Base, 428S0204  
Dulux® FleetShield™ 2K Black Base, 42889843  
Dulux® FleetShield™ 2K Red Base, 428S0011  
Dulux® FleetShield™ 2K Yellow Base, 428S0062  
Nippon nax Premila 80001K Basecoat (40N-Line)  
Dulux® AutoSpeed® CV 2K 2:1 mixed colour (488-Line)

### Substrates

All substrates must be thoroughly prepared and cleaned. For metal substrates, it is recommended that the surface be abrasive blasted or thoroughly sanded prior to the application of the primer. Polyester filler can be applied over sanded Ultrabuild, and Ultrabuild can be applied over polyester filler.

It is recommended that Dulux® AutoSpeed® Prepwash 965-89784 is used for cleaning and degreasing of surfaces.

Suitably prepared surfaces:

- Sound existing finishes
- Steel, 316 grade Stainless steel, Aluminium and galvanized surfaces
- Fibreglass
- ABS plastic
- Polyester filler

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## Product & Additives:

### Part A

Dulux® FleetShield® ULTRABUILD Epoxy Primer Pt A 488-Line

### Part B

Dulux® FleetShield® ULTRABUILD Pt B 980-S0058

Dulux® FleetShield® ULTRABUILD HP Pt B 980-S0069

### Thinners

Dulux® FleetShield® ULTRABUILD Cold Cure Thinner 920-S0063

Dulux® AutoSpeed® 2K Thinner- Normal 920-89292

Dulux® AutoSpeed® RP Thinner 920-89819

Dulux® AutoSpeed® 2K Thinner- Slow 920-89847

Please select thinner for Ultrabuild using the table below.

Temperature degrees ( C )	5-10	10-15	15-20	20-25	25-30	30-35
Ultrabuild Cold Cure Thinner, 920S0063						
RP thinner, 920-89819			Small area only			
2K Thinner- Normal 920-89292						Small area only
2K Thinner- Slow 920-89847						

	<b>Mixing Ratio</b>	4 Parts 488-S Ultrabuild Part A by volume
	<b>Hardener</b>	1 Part Ultrabuild Part B 980-S0058 by volume Or 1 Part Ultrabuild HP Part B 980-S0069 by volume for Rapid Processing
	<b>Thinner</b>	20% 920-89292 by volume 10-20% 920-S0063 by volume Cold Cure thinner <b>Note: 920-S0063 Cold Cure Thinner and 980-S0069 Ultrabuild HP Hardener are not compatible</b>
	<b>Spray Viscosity</b> DIN Cup 4 @ 25°C	25 seconds at 15% thinning
	<b>Gravity &amp; Suction Feed</b>	<b>Fluid Tip:</b> CONVENTIONAL: 1.4 – 1.8mm <b>Spraying Pressure:</b> 350-450 kPa. Or refer to manufacturer's recommendations
	<b>Pressure pot</b>	CONVENTIONAL: 1.1 – 1.8mm 350-450 kPa. Or refer to manufacturer's recommendations
	<b>Application</b>	1 to 2 even coats for a dry film build of 60-80 micron

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	<b>Air Flash</b>	10 - 15 minutes air flash between coats at 25°C.
	<b>Baking/Drying</b>	8 hours at 25°C 60 mins at 50°C
	<b>Sanding - Manual</b>	<b>Wet:</b> P600 - P800 Grit <b>Dry:</b> P400 - P600 Grit
	<b>Sanding - Manual</b>	
	<b>Sanding - Mechanical</b>	
	<b>Spraying</b>	Use air fed mask at all times. Refer applicable AS/NZS Standards
	<b>Pot Life</b>	When mixed, 6 hours at 25°C
	<b>Topcoat time - non sand</b>	ULTRABUILD HP Pt B 980-S0069 Minimum 30 Minutes Maximum 5 days <i>*recommendation at temperatures at or below 20°C</i>

## HBC Formulae

Ultrabuild White Part A 488-S0055 and Ultrabuild Black Part A 488-S0056 can be mixed to provide the HBC colours in the table below,

HBC colour	Ultrabuild White Part A 488-S0055 (Grams per litre)	Ultrabuild Black Part A 488-S0056 (Grams per litre)	Total (Grams per litre)
1	1759.00	-	1759.00
2	1580.45	158.04	1738.49
3	731.12	909.84	1640.96
4	264.56	1322.81	1587.37
5	-	1557.00	1557.00

## Ultrabuild Tintable Base

Ultrabuild Tintable Base may be tinted with up to 5% by weight nax Premila tinter, 40N line.

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## Ready for use charts:

### **Weight Mixing Ratios for 488-Line Fleetshield Ultrabuild Primer** **Using the Intelligent balance and adding by percentage addition**

**Note:** This order of addition must be maintained when using the intelligent balance.

HBC	Part A	Part B	Thinner
1	100.00%	12.80%	10.66-17.76%
2		12.95%	10.78-17.96%
3		13.72%	11.43-19.05%
4		14.19%	11.81-19.68%
5		14.46%	12.04-20.07%

The quantity of thinner added can be varied to suit your spraying conditions.  
See notes in Products & Additives regarding alternate thinners and hardener.

## For safe handling:

Please refer to the Material Safety Data Sheet number: 3000 for this product before use.

**In the event of an emergency contact: 1 800 033 111 (ALL HOURS) NZ 0800 734 607**

## For further information contact:

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