

Date: 16th March 2022

Technical Data Sheet

Version: 04

Product Name	
Full Product Name	339 2K Epoxy Primer Base (Tintable Primer)
Type of Product	2K chromate free epoxy-polyamide primer
Description	Concept Unicote 339 2K Epoxy Primer base is a 2K, chromate free epoxy-polyamide primer surfacer characterised by excellent adhesion to any metal substrate. Its unique formulation ensures a primer, which is very easy to sand and is suitable for use under any topcoat. It has very good anti-corrosive properties, with outstanding flexibility, chemical and water resistance, also can be used as Wet on Wet applications. This base is used as part of the Unicote 300 system making it tintable allowing all colours to be made as a primer.

Products						
Product Name	Volume Solids %	Weight Solids %	Density		VOC	
			g/mL	lbs/US gal	g/L	lbs/US gal
339 2K Epoxy Primer base	49.5	71.04	1.381	11.52	450.8	3.70
339 Epoxy Primer Hardener	31.5	38.9	0.910	7.60	572.7	4.78
831 2K Thinner Slow	0.0	0.0	0.893	7.45	892.7	7.45
831 2K Thinner Normal	0.0	0.0	0.872	7.27	881.9	7.36
831 2K Thinner Fast	0.0	0.0	0.882	7.36	871.5	7.27

Properties	
<ul style="list-style-type: none"> Excellent good anti-corrosive properties 	<ul style="list-style-type: none"> Outstanding flexibility
<ul style="list-style-type: none"> Excellent adhesion and durability 	<ul style="list-style-type: none"> Easy to sand
<ul style="list-style-type: none"> Excellent chemical and water resistance 	<ul style="list-style-type: none"> Suitable for use under all CONCEPT Paints Topcoats

Substrates

- Mild Steel and Steel Alloy surfaces
- Stainless steel grade 316
- Aluminium, Zincalume, Zinccanear
- Galvanised steel
- Glass reinforced polyester (GRP & general types of fibreglass body parts)
- Sound, cured and properly prepared existing surfaces

Substrate Preparation



All Substrates

All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application. Lightly rusted surfaces must be treated with Concept 025 Rust Converter.

NOTE: Ensure complete and thorough removal of residual rust converter before applying this product.

Product Preparation










	Mixing Ratio 4:1 (by volume)	Unicote 339 2K Epoxy Primer		Concept 339 Epoxy Primer Hardener
		4 parts		1 part
	Reducer	10-25% (v/v) of Concept 831 2K Thinner, if required.		
	Pot life @ 25°C (77°F)	6 hours		
	Spray viscosity @ 25°C (77°F)	BSB 4 Cup Ford 4 Cup	17-19 s 15-17 s	

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Product Preparation cont

   	Spray equipment	Gun type	Fluid tip	Spray pressure	Spray Distance
	Gravity feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
	Suction feed	2.0 mm 0.079"	200-240 kPa 2.0-2.4 bar 30-35 psi	15-20 cm 6-8 inch	
	HVLP	1.5-1.8 mm 0.059-0.071"	40-70 kPa 0.4-0.7 bar 6-10 psi	15-20 cm 6-8 inch	
	Airless Air Assisted Electrostatic	Consult the manufacturer's instructions.			
	Number of coats	2-3 coats	Apply one coat followed by two even full coats. Avoid heavy wet coats.		
	DFT Recommended	40-50 µm 1.6-2.0 mils			
	Flash off time @ 25°C (77°F)	5 min between coats			
	Drying	Air Dry @ 25°C (77°F)	3-4 hours		
		Wet on Wet @ 25°C (77°F)	25-30 minutes before applying topcoat . Must be topcoated within 48hrs, otherwise will require sanding. Drying time listed may vary, depending upon film build, colour selection, temperature, humidity and degree of air movement.		
		Low Bake @ 50°C (122°F)	30-40 min		
	Sanding	Wet sand with P600-P800 or Dry sand with P500-P800 before applying finish coat			



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.

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Product Data	
Colour	White, Grey, Black
Theoretical Coverage	Approx. 8 m ² /L (325 ft ² /US gal) @ recommended DFT
Shelf Life	36 months in an unopened container at room temperature away from sunlight.

Remarks	
	Stir all products thoroughly each time before use. Stir the mixture well after the weigh-out of the components.
	Surface temperature must always be a minimum of 3°C (5°F) above dew point.
NOTE:	Ensure the complete removal of any residue of Rust Converter before applying this primer.

Equipment Cleaning	
Use recommended Concept Paints 035 Gunwash	

Dry Film Properties	
After 7 days drying, when compared to similar technology products.	
Hardness	Excellent
Flexibility	Excellent
Chemical and water resistance	Excellent
Corrosion protection	Excellent
Durability	Excellent

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Product Packaging

Product Code	Product Name	Package Size
IN33990003.60	339 2K Epoxy Primer Base	3.6L
IN33990000018	339 2K Epoxy Primer Base (18LT in 20LT)	18L
IN33992000001	339 Epoxy Primer Hardener	1L
IN83191000020	831 2K Thinner Slow	20L
IN83192000020	831 2K Thinner Normal	20L
IN83193000020	831 2K Thinner Fast	20L

Safety

For automotive and industrial use only by professional painters. Not recommended for sale to, or use by the general public. Before using, read and follow all label and Safety Data Sheet (SDS) precautions. If mixed with other components, the mixture will have hazards of all individual components.

Read and understand the Guidelines for the Safe Handling and Use of Isocyanate Containing Paints, including the use of approved respiratory protection and Personal Protective Equipment. Use only in a well-ventilated approved spray booth, according to local regulations.

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This Technical Data Sheet supersedes all previous issues.

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