



Epoxy Primer (EP-411)

Version 24.03

PRODUCT DESCRIPTION

■ Outline

Epoxy Primer EP-411 is a low VOC, two-component primer offering excellent direct-to-metal adhesion and corrosion resistance over properly cleaned steel and aluminum substrates without the use of lead or chromates. Epoxy Primer EP-411 requires no induction time and is designed for fleets and automotive refinishers where extended service is important.

EP-411 is applicable directly to properly cleaned metal surfaces. It dries very fast and is ideal for harsh environments where corrosion protection is important.

■ Suitable Substrates

Treated steel / stainless steel
OEM finishes
Sanded body filler
Aluminum
Hot-dipped galvaneal

■ Product Configuration

Product Name	Pack(ℓ)	Contents(ℓ)	Storage
Epoxy Primer (EP-411)	4.0		24 months
Epoxy Primer Hardener (EPH-100)	1.0		12 months
Epoxy Thinner (DR-100)	4.0, 18.0		24 months

* Standard temperature of storage is 20°C.

■ Mixing Viscosity

16~18 sec. Viscosity(A+B+T) Ford Cup #4 at 77°F (25°C)

■ Pot Life

2 hours at 77°F (25°C) using EPH-100

APPLICATION GUIDE

■ Use

Mixing
Ratio



Product Name	Mixing Ratio
Epoxy Primer (EP-411)	4
Epoxy Primer Hardener (EPH-100)	1
Epoxy Thinner (DR-100)	1

* Mix by volume.

Spray
Condition



1~2.5 bar
2~3 wet coats keeping 15~20cm from the surface



Fluid tip : 1.3~1.6mm, D.F.T.=40~60µm



Flash time : 10 mins
Set time : 20 mins
Dry to sand time : 30 min (176°F)

Protective
Equipment



Use fresh air mask or charcoal respirator to avoid inhaling or being exposed to fumes.

■ Drying Times

	Temp. Time		Temp. Time		Remark
Set time	25°C	5~6 min	70°C	45 min	
Recoatable wet-on-w	25°C	30 min	80°C	30 min	
Tack-free	25°C	1 hr	-	-	
Time to sand	25°C	12 hrs	-	-	
Recoatable with polyester products	25°C	30 min	-	-	

(*) If coats are thicker, the drying schedule will be delayed.

ADDITIONAL INFORMATION

■ Recoatability

A-6000® Polyester Putty PS-330® Acrylic Urethane Primer Surfacer
PT-4000® Acrylic Urethane PS-550® Acrylic Urethane Primer Surfacer
UNITAN® Acrylic Urethane PS-650HB® Acrylic Urethane Primer Surfacer
HiQBASECOAT® Basecoat/Clearcoat US-412® Urethane Sealer



Dry sand P400



Wet sand P600

■ Blending



Product : HiQ Blending Reducer (DR-500)
Spray pressure : 2 bar
Number of coats : 1~2 coats

Procedure : 1) Apply TC-410 clearcoat.

- 2) On the second application, apply wider than the first application area.
- 3) Dilute TC-410 with DR-500 by the portion of 1:1 and apply once wider than the previous application area.
- 4) Melt the edge of the previous coat using DR-500.

■ VOC Content

VOC content of 4.9lbs/gal (600g/liter)

■ Notice

1. Sand with 320 grit or finer sandpaper after 3 days of dry time before topcoating.
2. For optimum corrosion resistance, 40~50 μ m (1.5~2.0 mils) of primer is recommended.

■ Health and Safety

1. Be well-informed of MSDS before use.
2. Follow all the directions labeled on the container.
3. For safety reasons, work in the fully-ventilated place.
4. Wear safety glasses, coveralls and latex gloves when mixing and applying.

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