



EPOXY-FIL EP-120

(Includes EP-120.B & EP-120.W)

EPOXY PRIMER



EPOXY-FIL EP-120 is a premium quality, chromate free, Low VOC epoxy primer. **EPOXY-FIL** primers have been formulated with premium ingredients and DTM (direct to metal) technology to provide you with the ultimate performance. These two component, primers are zinc oxide and zinc phosphate based and are available in gray, white and black. **EP-120** primers are corrosion inhibitive primers that can be applied wet-on-wet directly to properly prepared bare metal, aluminum, cured paint, fiberglass, bodyfillers, sanded original and SMC surfaces. These versatile primers offer a high film build, excellent anti-corrosion, sag resistance, adhesion, levelling, and sanding properties with excellent colour hold-out! **EPOXY-FIL** offer excellent adhesion and corrosion protection, resulting in a smooth and durable finish every time! **EP-120**, **EP-120.B** and **EP-120.W** must be activated with **H-122** Catalyst and reduced with **R-127 EPOXY-FIL** Reducer.

Colour: Gray, Black, White

Mix Ratio: 4:1:1

Required Catalyst: H-122
EPOXY-FIL Catalyst

Reducer: R-127 EPOXY-FIL
Reducer



Refer to Product Data Sheet (PDS) EP-120 for more information

Part No.	Description	Size	Units/Case
EP-120	EPOXY-FIL Epoxy Primer, Gray	3.78 L/1 US Gallon	4
EP-120.5	EPOXY-FIL Epoxy Primer, Gray	18.9 L/5 US Gallons	Ea.
EP-120.B	EPOXY-FIL Epoxy Primer, Black	3.78 L/1 US Gallon	4
EP-120.B.5	EPOXY-FIL Epoxy Primer, Black	18.9 L/5 US Gallons	Ea.
EP-120.W	EPOXY-FIL Epoxy Primer, White	3.78 L/1 US Gallon	4
EP-120.W.5	EPOXY-FIL Epoxy Primer, White	18.9 L/5 US Gallons	Ea.
H-122	EPOXY-FIL Catalyst	946 mls/1 US Quart	6
R-127	EPOXY-FIL Reducer	3.78 L/1 US Gallon	2
R-127.5	EPOXY-FIL Reducer	18.9 L/5 US Gallons	Ea.

FEATURES

Low V.O.C.
Excellent Corrosion Protection
Excellent Adhesion Properties
DTM (Direct-to-Metal) Technology
Wet on Wet Application

Chromate Free
Excellent Levelling
Easy Sanding Properties
Excellent Sag Resistance



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EPOXY PRIMER

EPOXY-FIL EP-120 are premium quality, chromate free, Low VOC epoxy primer systems that has been formulated with premium ingredients and DTM technology to provide you with the ultimate in performance. **EPOXY-FIL** primers are versatile high solids, two component systems designed to deliver a high film build, with excellent anti-corrosion, sag resistance, levelling, application, and sanding properties. These easy to use epoxy primers must be activated with **H-122 EPOXY-FIL** Catalyst and reduced with **R-127** Epoxy-Fil Reducer. **EP-120** will adhere to properly prepared bare metal, galvanized steel, aluminum, cured, sanded original finishes, SMC, bodyfillers, and fiberglass. **EPOXY-FIL** is available in gray, black, and white. **EP-120** can be applied wet-on-wet and will leave behind a protective, smooth and durable finish every time!

PACKAGING: **3.78 L / 1 US GALLON PER CAN 4 CANS PER CASE**
 18.9 L / 5 US GALLONS PER PAIL EACH

APPROVED SUBSTRATES: On properly prepared steel, aluminum, galvanized steel, cured paint, bodyfillers, fiberglass, SMC, and existing finishes.

* Do not apply over Thermoplastic Acrylic Lacquers

SURFACE PREPARATION:



If necessary, pre-wash the repair surface with soap and warm water. Rinse completely with clean water.

Clean surface. Prepare a clean repair surface free of dirt, oil, wax, grease, rust and other contaminants using **CLEAN-FIL CF-125** or equivalent cleaner.

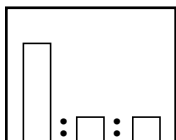


Prior to applying **EP-120**, finish sand repair surface with 320 - 400 grit sandpaper disc. Repair area *must be completely dry* prior to applying **EP-120** Epoxy Primer.

For Previously Painted Surfaces: Prepare a clean surface free of oil, grease, wax, dirt, rust and other contaminants. The surface must then be dulled by abrading the smooth, glossy or hard coating prior to applying **EP-120**.

For Iron and Steel: Minimum surface preparation is Hand Tool Clean as per SSPC-SP2. Prepare a clean surface free of oil and grease by Solvent Cleaning as per SSPC-SP1. For best results, use Commercial Blast Cleaning as per SSPC-SP6. Prime bare steel before flash rust occurs or within 8 hours.

MIX RATIO:



4 : 1 : 1

Thoroughly stir **EP-120** Epoxy-Fil prior to use. Combine 4 parts by volume **EP-120** with 1 part by volume **H-122** Catalyst. Thoroughly stir and mechanically agitate this mixture under low speed for 5 minutes. Caution: The mixed material will generate heat. Add 1 Part by volume **R-127 Epoxy-Fil Reducer** to the above agitated mixture.

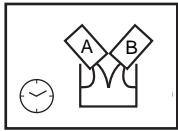
4 Parts EP-120 / EP.120.B / EP.120.W EPOXY-FIL Epoxy Primer
1 Part H-122 EPOXY-FIL Catalyst
1 Part R-127 EPOXY-FIL Reducer

Let this mixture stand for 15 - 20 minutes before applying.



PDS Form:
EP120/LVCDAUS/0417_V02

POT LIFE :

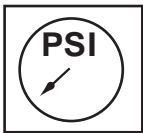


8 Hours @ 20° C / 68° F

Let the agitated mixture stand for 15 - 20 minutes prior to use.

* High temperatures will decrease the working potlife and lower temperatures will extend the working pot life. Do not use material beyond the recommended pot life above.

SPRAY PRESSURE:



Note: Do NOT apply **EP-120** primer over fresh or uncured coatings. *The substrate must be **completely cured** prior to applying the epoxy primer.*

Gravity Gun, HVLP Nozzel: 1.3 - 1.5 mm or 0.051" - 0.059"

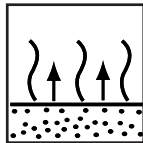
Gravity Gun, HVLP Pressure: 6 - 10 psi, at cap

Conventional Gun, Nozzel: 1.3 - 1.6 mm

Conventional Gun, Pressure: 28 - 30 psi (1.7 - 2.2 bar) at air inlet

* Clean spray equipment before use and/or before extended downtime periods to avoid blockage.
* For best results, refer to equipment manufacturer's recommendations for application instructions.

APPLICATION:



5 - 10 minutes
@ 25 °C/78 °F

Spray equipment must be purged with **CF-125** Clean-Fil prior to use.

Conventional Spray: Apply a wet first coat of the mixed material. Allow a 5 - 10 minute flash time between coats at 25°C / 78°F, depending on shop conditions, before applying the next coat. Then apply a wet second coat.

Airless Spray: Use 2800 - 3000 psi with a tip of .017" - .023" and hose having 1/4" ID. Reduce the agitated **EP-120** and **H-122** mixture up to 1 Part by volume with **R-127 Epoxy-Fil Reducer** to desired viscosity.

Brush: Use a nylon/polyester or natural bristle brush.

Roller: Use a 3/8" woven cover having a solvent resistant core.

DRY TO SAND TIME:



No sanding required. Must sand only if 72 hours have lapsed since application of **EP.120/EP.120.B/EP-120.W**.

**TECHNICAL
INFORMATION:**

Appearance:	Gray, Black or White Liquid
Weight Per Gallon:	5.29 kg - 5.48 kg / 11.66 lbs - 12.08 lbs
% Solids By Weight:	71 ± 3
Specific Gravity:	1.397 - 1.447
Sand Time, If Required:	Required only if 72 hours have lapsed from application
Pot Life:	8 Hours @ 20° C / 68° F
Mix Ratio:	4 : 1 : 1
Required Catalyst:	H-122 Epoxy-FIL Catalyst
Reducer:	R-127 Epoxy-Fil Reducer

**SAFETY &
HANDLING:**

Important: For Industrial Use Only by trained professionals using proper safety equipment. Prior to using be sure to read and understand the warnings of this product and all products it may require, since the mixture will have the hazards of all its components. Observe all precautions for all components. Use only with adequate ventilation and wear the appropriate safety equipment. Refer to Material Safety Data Sheet (MSDS) for more and current information regarding this product and handling instructions.

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