

Bodyian Bodyian Epoxy Primer (EP-4110)

Version 1.0

PRODUCT DESCRIPTION

■ Outline

Bodyian Epoxy Primer EP-4110 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. EP-4110 requires no induction time and is designed for fleets and automotive refinishes where extended service is important.

EP-4110 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

Steel / stainless steel
Body filler
Aluminum
Hot-dipped galvaneal

■ Product Configuration

Product Name	Pack(ℓ)	Contents(ℓ)	Storage
Bodyian Epoxy Primer (EP-4110)	4.0	5.79	24 months
Epoxy Primer Hardener (EH-10)	1.0	0.897	12 months
Epoxy Thinner (DR-100)	4.0, 18.0	3.85, 17.3	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 EH-10

APPLICATION GUIDE

■ Use

Mixing
Ratio



Product Name	Mixing Ratio
Bodyian Epoxy Primer (EP-4110)	4
Epoxy Primer Hardener (EH-10)	1
Epoxy Thinner (DR-100)	1

* Mix by volume.

Spray
Condition



2.0~3.0 bar (gravity feed)
2~3 wet coats keeping 20~25cm from the surface

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Fluid tip : 1.2~1.5mm, D.F.T.=25~50 μ m



3.0~4.0 bar (siphon feed)
2~3 wet coats keeping 20~25cm from the surface
Fluid tip : 1.4~1.6mm, D.F.T.=25~50 μ m



Drying time to sand : 30 min (80°C)

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

■ 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.

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2. For optimum corrosion resistance, 40~50 μ m (1.5~2.0 mils) of primer is recommended.
3. For 2K products, short pot life, delayed drying time or unreactive substance can occur depending on hardener volume. Thus please mix base(A) and hardener(B) according to the proper mixing ratio.
4. Stir thoroughly before use.
5. Avoid direct sunlight during delivery, storage and handling. Store in a cool, dry dark place under room temperature(5°C-35°C).
6. Keep container tightly closed and store upright. When spilled, absorb contents with sand.
7. During application(including touch-up application), color difference may occur depending on mixing ratio, painting tools and application method. It may occur in same color product and same LOT No.
8. Please check whether color difference occurred or not. If possible, apply the same LOT No. product in consistent application method.
9. Putty marks might appear when you directly apply over the lacquer coating. As time goes by, it can peel.
10. Completely eliminate the moisture of spray equipment before use.
Cleanse immediately after application not to have any leftover on spray equipment.
11. Suitable condition for application and hardening is 10°C or above.
12. Surface temperature must be at or above 3°C to avoid moisture condensation.
13. Do not mix with other paint products.
14. Proceed a test application before applying on a precedent or an old paint film (check adhesion, color spread and transparency).
15. Please refer to technical data sheet before system application(primer, midcoat and topcoat).
16. Please do not apply paint above 85% RH or below 5°C because it may influence physical properties.
17. Contents must not flow into drain, river and soil.
18. Hardener must be stored under room temperature, avoid direct sunlight and keep away from humidity.
19. To prevent environmental pollution, dispose contents after complete use and dispose the residue through waste disposal company authorized by the ministry of environment.
20. Beware of ingestion, inhalation and contact of animals and plants.
21. Use masking tape, covering tape, vinyl or newspapers to cover areas that should not be painted.

■ Health and Safety

1. Be well-informed of MSDS before use.
2. Keep out of the reach of infants and children. Do not apply a product to baby products and food containers.
3. Do not use a product for any other uses. (Sniffing is prohibited. Do not use as a fuel.)
4. If on skin or eye, wash thoroughly with running water and get a medical treatment.
5. Do not apply a product in an enclosed area.

In order to prevent suffocation during application and drying, use power blower to keep the area fully ventilated. Workers must wear gas mask and safety gears all the time.

6. Contents include organic solvents and can cause health problems such as headache, dizziness and dermatitis.

Do not ingest or inhale the product and avoid skin contact.

Wear safety glasses, coveralls and latex gloves when mixing and applying.

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- 7. Keep away from fire and heat during application or storage because it is flammable and has risk of fire. Beware of spark from impact, droppage and friction while handling.**
- 8. Storing a product with combustible substances such as stained clothes or paper may cause fire by spontaneous ignition. Thus do not pile products with combustible substances. Keep it in a non-flammable container filled with water, then put a lid on and dispose it.**
- 9. Please contact our customer service or refer to GHS-MSDS and technical data on the website for further details.**

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