Durepox SYSTEM GUIDE

	If carrying out large repaint work in a no	n controlled environment Do not apply paint if relative hum	iidity is above	85% or temperature is within 3 deg C of Dew Point I	being the MPT or Minimum Paint Temperature.
SUBSTRATE	PREPARATION	ETCH PRIMER		PRIMER/FILLER	COLOUR
Composite: Carbon Fibre and GRP (Polyester and Epoxy)	 Remove all mould release agents. Abrade with P150 / P180 Grit by hand or machine or garnet blast. Fill and shape if required. Air blow and clean down always wearing gloves & lint free cloths. 			 Apply 2 coats of Durepox High Solids Primer or 2K Primer Fill pinholes by squeegee or brush over as seen. Cure for 24 hr 20 deg C. 	
Steel Heavy / Light	 Heavy Steel: Degrease the surface. Grit Blast to SA2.5 with Garnett Grade C to 30 micron profile. Light Gauge Steel With No Milscale: Degrease the surface. Abrade with suitable abrasive such as P150 / P180 grit. Preheat steel is always good practice. Air blow and clean down always wearing gloves & lint free cloths. 	1. Not applicable for steel with Milscale removed followed by grit blasting.		 Apply Durepox 2K Primer. Take note of substrate profile and required wet & dry film build. Good practice is 50 microns DFT of Durepox above the peeks of a recommended 30 micron Garnett blast profile. 	 Sand after full cure. Finish with P400. Coloured Durepox 2K Primer or Boero Challenger Pro, Boero Challeng Pro Basecoat (solid or Special effect) Challenger Pro Clear.
Galvanised Steel	 Heavy Steel Galv / Light Steel Galv: 1. Degrease the surface. 2. Preheat steel is always good practice. Air blow and clean down always wearing gloves & lint free cloths. 	1. Use Durepox Etch primer.		 Apply Durepox 2K Primer. Take note of substrate profile and required wet & dry film build. 	
Aluminium	After Cleaning & Degreasing 1. Abrade with P150 / P180 by hand or machine. Air blow and clean down, always wearing gloves and using lint free cloths Preheat Aluminium is always good practice	2. Allow min 3hr to dry.			
Wood / MDF	 MDF 1. Sand smooth / Finish sand with P240 / P320 grit including edges. Timbers with Grain 1. Sand smooth / Finish sand with P240 / P320 grit in the direction of the grain. Sand edges. Air blow and clean down always wearing gloves & lint free cloths. 			MDF & Grain Timbers 1. Depending on desired finish timbers with grain can be directly topcoated with Durepox High Performance Clear.	 MDF & Grain Timber (if colour is required. 1. Sand after full cure. 2. Finish with P400. 3. Coloured Durepox 2K Primer or Boero Challenger Pro, Boero Challen Pro Basecoat (solid or Special effect) Challenger Pro Clear.

Durepox 2K primer is a very unique two component epoxy Urethane that can be applied by brush, roller, airless, air assisted airless, electrostatic and conventional gravity or pressure pot spray. Durepox has many applications from hi build primers to being used as coloured topcoats in conjunction with Durepox High Performance Clear (DHPC). Other 2K topcoats can be applied over Durepox after full cure and sanding, test an area first before completing entire project.

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