

Epoxy Primer

An outstanding quality, two component, isocyanate, lead, and chromate free epoxy primer or sealer with good corrosion resistance. The primer offers excellent adhesion to prepared metal, fiberglass and aluminum surfaces.

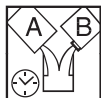


Part #	Description	Size
8411	Epoxy Primer Green/Gray	Gallon
8412	Epoxy Primer Green/Gray	Quart
8413	Epoxy Primer Black	Gallon
8414	Epoxy Primer Black	Quart
8415	Epoxy Primer White	Gallon
8416	Epoxy Primer White	Quart
8121	Epoxy Catalyst	Quart
8122	Epoxy Catalyst	Half Pint



Substrates

- Fully Cured Finishes - Sand with 240-320 grit paper
- Steel, Galvanized & Aluminum - Sand with 80-180 grit paper
- Fiberglass and SMC - Sand with 150-240 grit paper
- Always clean surface prior to application with 5900 or 5910 wax & grease remover.



Mixing

VOC Compliant Primer	Conventional Primer	Conventional Sealer
4 parts Epoxy Primer	4 Primer	4 Primer
1 part Epoxy Catalyst	1 Catalyst	1 Catalyst
Up to 1/2 Part Urethane Reducer	3 Urethane Reducer	4 Urethane Reducer
5 Min. Mechanical Induction	5 Min. Mechanical Induction	5 Min. Mechanical Induction



Set Up Tech Info

Tip/Needle:	1.5mm to 1.8mm		
Spot Air Pressure	35 - 45 psi / HVLP 5 to 10 psi at cap		
Overall Air Pressure:	45 - 55 psi / HVLP 5 to 10 psi at cap		
Viscosity (#2 Zahn)	VOC Primer 20-25 Sec	Conv. Primer 19-22 Sec	Conv. Sealer 16-18 Sec
Film Build	1.0-1.2 mils DTF	.8-1.0 mils DTF	.5 mils DTF
Coverage (@ 1mil)	481 Sq. Ft.	336 Sq. Ft.	288 Sq. Ft.



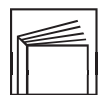
Application

VOC Compliant Primer	Conventional Primer	Conventional Sealer
1 full wet coat	1-2 full wet coats w/10-15 min. flash	1 wet coat



Drying

	VOC Primer	Conv. Primer	Conv. Sealer
Sand Time	Not recommended	60 minutes	Not recommended
Recoat	60 minutes	60 minutes	30 minutes
Topcoat	60 minutes	60 minutes	30 minutes
Pot Life	8 hours	8 hours	8 hours



Physical Data

Volume Solids RTS	30%	21%	18%
VOC RTS	4.8 lb/gal.	5.5 lb/gal.	5.7 lb/gal.
Humidity Resistance	Excellent	Excellent	Excellent
Salt Spray Resistance	Excellent	Excellent	Excellent



Master Tips

Do not use over lacquer products. Recoat within 72 hours. Greater than 72 hours, scuff sand before top coat. In temperatures over 77°F recoat within 36 hours.