

# Marine Coatings Technical Data



HMG Performance Coatings LLC

PO Box 313  
Roebuck, SC 29376  
+1 864 578 6770

<b>Product Name</b>	Epi-prime Anti-corrosive Epoxy Primer
<b>Issue date</b>	11/29/2004
<b>Formula Number</b>	
<b>Product code</b>	

<b>Packaging</b>
Available in 5 liter pack sizes (4 liter fill)

<b>Product Description &amp; Function</b>
Epi-prime Anti-corrosive Epoxy Primer is a 2 Pack polyamide primer intended mainly for metal and fiberglass protection. Epi-prime Anti-corrosive Epoxy Primer gives excellent adhesion, water & chemical resistance combined with excellent corrosion protection.
Epi-prime Anti-corrosive Epoxy Primer is available in white color. (contains a non toxic anti-corrosive pigment)

<b>Substrates &amp; Preparation</b>			
	<b>Aluminum -</b>	Sand blast or grind to 3-4 mils profile depending on grade of Aluminum. Spot repairs grind with 60 - 80 grit. Must be 100% clean and coated within 1 hr. of blasting/grinding.	<b>Number of coats</b> 2 - 3 coats depending on condition of substrate and expected operating conditions
	<b>Steel -</b>	Sand with P60-P80g or sand blast to SSPC-SP5-85. Coat within 1 hr.	2 - 3 coats depending on condition of substrate and expected operating conditions.
	<b>Previously painted -</b>	Sand with P180-P320g - ensure good adhesion to previous coats	1 coat
	<b>Wood -</b>	Sand clean wood with P150-P180 grit and apply first coat reduced up to 50% with DG146. Reduce 2nd coat up to 25%	2 - 3 coats
	<b>GRP/Gel Coat -</b>	Sand with P180-P320g being careful not to abrade through the Gel coat.	1 - 2 coats
	<b>Note: If further build up coats are required, it is recommended to use 1 coat off Epi-prime Anti-corrosive Epoxy Primer followed by as many coats as required of Epi-prime Sanding surfacer Epoxy Primer followed by one more coat of Epi-prime Anti-corrosive Epoxy Primer (makes a "sandwich"). Excessive coats of epoxy primers in hot and humid conditions may result in solvent entrapment which may subsequently lead to paint blisters. Do NOT use Etch (Wash) Primers under epoxy primers.</b>		

<b>Cleaning</b>	
	All surfaces should be pre cleaned prior to preparation and prior to application of primer. HMG SAH 270 degreaser is highly recommended as a wipe on wipe off cleaner. Cleaning between sanded coats, Contec ProSat wipes are recommended and reduce static. CLEAN BEFORE SANDING

<b>Application</b>				
	<b>Mixing Ratio</b>	<b>HVLP</b>	<b>Pressure Pot</b>	<b>Airless/Air Assisted</b>
	Epi-prime Epoxy Primer Hardener (see options) Epi-prime Reducer V05 (1512)	4 parts 1 Part 1.5-2 Parts	4 parts 1 Part 1.5-2 Parts	4 parts 1 Part 1
Allow 20 min induction period before applying				
	<b>Spray Viscosity</b>	25 - 40 sec (Zahn 2 @ 72°F)	25 - 40 sec (Zahn 2 @ 72°F)	40 sec (Zahn 2 @ 72°F)
	<b>Gun Set Up</b>	See HMG Gun recommendations	Pot pressure 10 - 15lbs	See HMG Gun recommendations
	<b>No of Coats</b>	See substrate		1 full coat
	<b>Flash Off</b>	1 hour minimum when overcoating with itself		NA
	<b>Drying</b>	2 hours @ 72°F		
	<b>Pot Life</b>	8 hours @ 72°F		
	<b>Film Build</b>	4 mils WFT		2 mils DFT
	<b>Overcoating</b>	After 60 min with itself or after 12 hours with other products. If greater than 24 hrs between coats, th surface should be sanded. <b>If multiple coats applied, leave 24 hrs before applying topcoat to prevent solvent entrapment</b>		
	<b>Sanding</b>	Wet sand after 8 hrs or dry sand after overnight dry - P180 - P320 grit		
	<b>VOC (Ready for Use)</b>	< 440 g / liter		

<b>Hardener Option</b>	
DG145 Hardener	Use this hardener at 4:1 faster dry time -- can be sanded more quickly. Use in most cases except in very hot conditions.
Epi-prime Hardener	Use this hardener at 4:1 slower dry time -- best suited to very hot conditions (90 degrees +) or larger vessel types.
<b>Technical Information</b>	
<b>Solids</b>	75-80% by weight
<b>Flashpoint</b>	Below 72°F
<b>Storage</b>	12 Months in original sealed containers
<b>Equipment Cleaning</b>	Any listed above or Acetone
<b>Coverage</b>	500 sq/ft per US Gallon
<b>VOC (unmixed)</b>	440 g/l
<b>Special Properties</b>	
Outstanding adhesion / chemical resistance / corrosion resistance / impact resistance. Good adhesion to difficult substrates. Ideal for use with HMG Acrythane XSC topcoats	
<b>Special notice - prevailing weather conditions</b>	
Epi-prime Anti-corrosive Epoxy Primer should not be applied in temperatures below 50 °F as curing times become extended beyond practical limits and when the substrate temperature exceeds 105°F. Painting late in the day may result in condensation forming on the paint film that leads to loss of gloss and potential blistering problems in the cured coating. Space heaters can create moisture and worsen the situation. DO NOT apply paint if the temperature is going to drop below the dew point within 6 - 8 hours after painting is complete.	
<b>Health &amp; Safety</b>	
Refer to "Material Safety Data Sheet" and can label prior to use.	
FOR PROFESSIONAL USE ONLY. PAINT APPLICATORS ARE ASSUMED TO BE EXPERIENCED IN THE HANDLING AND APPLICATION OF THESE PRODUCT TYPES	
KEEP OUT OF THE REACH OF CHILDREN	
Wear suitable respiratory equipment.	

visit [www.hmgmarine.com](http://www.hmgmarine.com) for more information and updates

THIS INFORMATION RELATES ONLY TO SPECIFIC MATERIAL DESIGNATED AND MAY NOT BE VALID FOR SUCH MATERIAL USED IN COMBINATION WITH OTHER MATERIALS OR IN ANY OTHER PROCESS. Such information is to the best of HMG's knowledge and belief, accurate and reliable as of the date indicated. HOWEVER, NO REPRESENTATION, WARRANTY OR GUARANTEE IS MADE AS TO IT'S ACCURACY, RELIABILITY OR COMPLETENESS. IT IS THE USERS RESPONSIBILITY TO SATISFY HIMSELF AS TO THE SUITABILITY AND COMPLETENESS OF SUCH INFORMATION FOR HIS OWN PARTICULAR USE. Any warranties if or where applicable are limited to replacement material (except where limited by law).