

# Marine Coatings Technical Data




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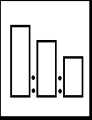






<b>Product Name</b>	Epi-prime Sanding Surfacers Epoxy Primer
<b>Issue date</b>	11/29/2004
<b>Formula Number</b>	
<b>Product code</b>	

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

<b>Product Description &amp; Function</b>
Epi-prime Sanding Surfacers Epoxy Primer is a 2 Pack polyamide primer intended mainly for metal and fiberglass protection. Epi-prime Sanding Surfacers Epoxy Primer gives excellent high build and is used for multi-coat application when higher film thicknesses are required. Epi-prime Sanding Surfacers Epoxy Primer is available in cream color. (contains a non toxic Sanding Surfacers pigment)

<b>Substrates &amp; Preparation</b>			
		<b>Number of coats</b>	
	<b>Aluminum -</b>	Apply over Epi-prime Anti-corrosive epoxy primer - see data sheet for surface preparation	2 - 3 coats or as required
	<b>Steel -</b>	Apply over Epi-prime Anti-corrosive epoxy primer - see data sheet for surface preparation	2 - 3 coats or as required
	<b>Previously painted -</b>	Not normally used - only requires Epi-prime Anti-corrosive epoxy primer	1 coat
	<b>Wood -</b>	Apply over Epi-prime Anti-corrosive epoxy primer - see data sheet for surface preparation	2 - 3 coats or as required
	<b>GRP/Gel Coat -</b>	Apply over Epi-prime Anti-corrosive epoxy primer - see data sheet for surface preparation	1 - 2 coats or as required
<p><b>Note: It is always recommended that Epi-prime anti-corrosive epoxy primer be applied to the substrate first and then last so as to "sandwich" the sanding surfacer. If the sanding surfacer is not overcoated in this fashion, then excessive sinkage of the topcoat may result. 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></p>			

<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>HVLP</b>	<b>Pressure Pot</b>	<b>Airless/Air Assisted</b>
	<b>Mixing Ratio</b>			
	Epi-prime Epoxy Primer	4 parts	4 parts	4 parts
	Hardener (see options)	1 Part	1 Part	1 Part
	Epi-prime Reducer V05 (1512)	1.5-2 Parts	1.5-2 Parts	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		NA
	<b>Drying</b>	2 hours @ 72°F		
	<b>Pot Life</b>	8 hours @ 72°F		
	<b>Film Build</b>	6 mils WFT	3 mils DFT	
	<b>Overcoating</b>	After 4 hours with itself or after 12 hours with other products. If greater than 24 hrs between coats, the surface should be sanded. <b>If multiple coats applied, leave 24 hrs before applying topcoat to prevent solvent entrapment</b>		
	<b>Sanding</b>	Sand after overnight dry - P180 - P320 grit		
	<b>VOC (Ready for Use)</b>	< 400 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>	85% 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>	400 g/l
<b>Special Properties</b>	
Outstanding adhesion / chemical resistance / corrosion resistance / impact resistance. Good build properties Ideal for use with HMG Acrythane XSC topcoats	
<b>Special notice - prevailing weather conditions</b>	
Epi-prime Sanding Surfacer Epoxy Primer should not be applied in temperatures below 50 °F as curing times become extended beyond practical limits or when substrate 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 hrs 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.	

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