

Marine Coatings Technical Data



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Product Name	EPI-PRIME EPOXY PRIMER
Issue date	7/19/2004
Formula Number	
Product code	6700 series

Packaging

Available in 1 liter and 5 liter packs (4 liters base + 1 liter hardener)(4 Parts base and 1 part hardener)


Product Description & Function

EPI-PRIME EPOXY PRIMERS are 2 pack polyimide cured epoxy primers intended primarily for metal but provide excellent adhesion and protection to prepared fiberglass thus providing an excellent base for Superspeed SP 52 anti-foul. Can also be used as a primer for wood and is at home under K Type Polyurethane paint.

EPI-PRIME EPOXY PRIMERS give high adhesion, water resistance, and chemical resistance combined with excellent corrosion protection.


EPI-PRIME EPOXY PRIMERS are available as Zinc Phosphate (Gray)

Substrates & Preparation

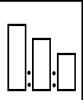





		Number of coats
 Aluminum -	Sand blast or grind to 3-4 mils profile depending on grade of Aluminum. Spot repairs grind with 60 - 80 grit. Must be 100% clean and coated within 1 hr. of blasting/grinding.	1 - 2 coats depending on condition of substrate and expected operating conditions
Steel -	Sand with 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.
Previously painted -	Sand with P180-P320g - ensure good adhesion to previous coats	1 coat
Wood -	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
GRP/Gel Coat -	Sand with P180-P320g being careful not to abrade through the Gel coat.	1 - 2 coats

Note: If further build up coats are required, it is recommended to use Polykote MPS 4+1 for subsequent coats as this material is very easy to sand and provides the best overall finish primer. Excessive coats of Epi-Prime applied 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.

Cleaning

 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**

Application

	HVLP	Pressure Pot	Airless/Air Assisted
 Mixing Ratio			
Base	4 Parts	4 Parts	4 Parts
Hardener	1 Part	1 Part	1 Part
Reducer	1 part	1 part	0 - 0.5 parts
Allow 20 min induction period before applying			
 Spray Viscosity	30 - 40 sec (Zahn 2 @ 72°F)	30 - 40 sec (Zahn 2 @ 72°F)	40 sec (Zahn 2 @ 72°F)
 Gun Set Up	See gun recommendation	See gun recommendation	See gun recommendation
No of Coats	See substrate		1 full coat
 Flash Off	30 minutes @ 72°F		NA
Drying	2 hours @ 72°F - Hard Dry 8 hours		
Pot Life	8 hours @ 72°F		
 Film Build	3.2 mils WFT gives approximately 2 mils DFT		
Overcoating	Between 2 and 36 hours. (Requires light abrading or sanding if left over 36 hours.) Leave overnight before applying SP 52.		
 Sanding	Wet sand after overnight dry.		
VOC (Ready for Use)	457 g /l mixed		

Reducer Options

Epi-prime Reducer	Std	} Dependant on temperature or size of vessel to enable a Wet Edge to be retained. The choice of correct reducer will give optimum lay down of product and ease of application. Reducers can be blended
Acrythane XSC Reducer CB122	Fast	
Acrythane XSC Reducer CB122 (RTD)	Medium	
Acrythane XSC Reducer A788	Slow	
Acrythane XSC Reducer Brushing	Extra Slow Reducer	

Hardener Option

Epi-prime Hardener	Epi-prime hardener is the only one available for Epi-prime Epoxy Primer.
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Technical Information

Solids	65 - 75% by weight
Flashpoint	Below 72°F
Storage	12 Months in original sealed containers
Equipment Cleaning	Any listed above or Acetone
Coverage	500 sq/ft per US Gallon
VOC (unmixed)	457 g/l

Special Properties

Outstanding adhesion / chemical resistance / corrosion resistance / impact resistance.
 Good adhesion to difficult substrates.
 Ideal for use with HMG K Type paints and excellent under Superspeed SP52
 Epi-prime Epoxy Primer can be used above or below the water line, making it a very user friendly primer

Special notice - prevailing weather conditions

Epi-Prime Epoxy Primer should not be applied in temperatures below 50°F as curing times become extended beyond practical limits. 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.

Health & Safety

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 for more information and updates

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