

### PRODUCT FEATURES

- Sandable
- Can be used as a sealer
- Outstanding adhesion to bare metal
- Lead and Chromium free
- Good adhesion over most plastics
- High corrosion resistance
- No induction time



### DESCRIPTION

Painter's Pride Epoxy Primer is a universal epoxy primer with no induction time that provides excellent corrosion resistance and exceptional adhesion to properly prepared substrates. It can be used on steel, galvanized steel, aluminum, fiberglass, some plastics and properly prepared, cured finishes. **DO NOT USE OVER ELASTOMERIC (FLEXIBLE) PRIMERS.** The cured product is sandable.

### AVAILABILITY

<u>PART NO</u>	<u>DESCRIPTION</u>	<u>SIZE</u>	<u>PER CASE</u>
PPP-4701	Epoxy 3 in 1 Primer - GRAY	GAL	2
PPP-4704	Epoxy 3 in 1 Primer - GRAY	QT	6
PPP-4711	Epoxy 3 in 1 Primer - Catalyst	GAL	2
PPP-4714	Epoxy 3 in 1 Primer - Catalyst	QT	4
PPP-4721	Epoxy 3 in 1 Primer - BLACK	GAL	2
PPP-4724	Epoxy 3 in 1 Primer - BLACK	QT	6

### PHYSICAL PROPERTIES

<b>Pot Life</b>	8 hours
<b>Induction Time</b>	None
<b>Dry Film Build</b>	1 to 1.5 mils per coat
<b>Sprayable Viscosity</b>	24-28 sec. Zahn #2 Cup
<b>VOC Ready-to-Spray</b>	<3.9 lb/gallon 467.3 g/L
<b>Color Holdout</b>	Excellent
<b>Inter Coat Adhesion</b>	Excellent
<b>Reparability Catalyzed</b>	Excellent

<b>Flash Point</b>	54°F
<b>Weight Solids (RTS)</b>	41.77 %
<b>Theoretical Coverage (RTS) @ 1 mil</b>	428.79 sq ft
<b>Humidity Resistant</b>	Excellent
<b>Adhesion Over Bare Metal</b>	<b>Rated</b>
304 Stainless Steel (see caution)	5B (after 24hrs)

**Caution:** 304 Stainless Steel is a "food grade" There are over 50 different grades of stainless steel and this product will not have the same adhesion over all grades of stainless steel. The epoxy was allowed to dry for 24 hours before performing the adhesion test.

**Warning:** Not compliant in states such as California where low VOC regulations are in place.



## **SURFACE PREPARATION**

Wash surfaces with a mild detergent in warm water. Rinse well and wipe dry with a clean, dry cloth.

Wipe vehicle with AXIS WATER BASED PRE-CLEAN, using generous amounts and changing rags frequently prior to painting.

### **BARE METAL**

Sand area as necessary to remove any rust or corrosion, repair all body damage.

### **PRE-PAINTED SURFACES**

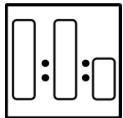
Sand vehicle with 320P grit or finer D.A. or hand sand with 400P grit or finer wet or dry sandpaper and repair all body damage.



## **DRY TIMES AT 70°F**

**AIR DRY:** Allow Epoxy to become hand slick (10-15 minutes) before applying the next coat. **As a Sealer**, allow 30 minutes dry time before topcoating. **As a Primer**, allow 4-6 hours dry time before sanding & topcoating,

**FORCED DRY:** No purge necessary. Bake @140°F for 30 minutes. Only Allow vehicle to cool down to room temperature before sanding and topcoating.



## **MIX RATIO**

To one (1) part EPOXY, add one (1) part CATALYST, and ½ part of 62,63 or 64 Series PREMIUM Urethane Reducer.

### **Note**

1. Will not fill sand scratches coarser than P180.
2. Add 2 ounces of Retarder Solvent per 32 ounces of ready-to-spray Epoxy Primer to improve flow in hot weather.

## **TIPS OF THE TRADE**

- For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure.
- It can be used “under” for adhesion to various substrates.
- It can be used “over” as a Sealer (1:1:½)
- It can be used in hot weather without dusting by adding PREMIUM Urethane Reducer (series 62,63, and 64) (1:1:½)
- Use **6221** PREMIUM Urethane Reducer @ 75°F or **6321** @ 85°F.
- Topcoat after 30 min up to 24 hours dry (without sanding)
- For maximum adhesion, after 24 hours dry, scuff with a red pad and apply 1 coat of Epoxy at the 1: 1 ½ ratio.



## **SPRAY GUN ADJUSTMENT AND SETUP**

**GUN TYPE:** Siphon or Gravity feed HVLP or RP

**NOZZLE/TIP SIZE:** 1.5—1.8 mm is required for proper atomization when using an HVLP. If using an RP type gun 1.4—1.7mm tip is recommended..

**AIR PRESSURE:** 40 to 50 PSI at the gun or 7-10 PSI at the cap.

Adjust the material flow according to product viscosity.

- Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

**Note:** Proper spray gun adjustment will determine the final finish. Improper adjustment may cause paint defects such as orange peel, runs, sags, dieback, solvent entrapment and poor drying.



## **APPLICATION**

Apply 1 to 2 medium wet coats allowing 10 to 15 minutes flash time between coats - Film Build is approximately 1 to 1.5 mils per coat (dry film build). After allowing the epoxy to properly dry, topcoat with acrylic or synthetic enamel, basecoat (solvent or waterborne) or single stage acrylic urethane. If the epoxy has cured for more than 24 hours, scuff the surface before priming or topcoating. If filling capabilities are required, prime with PREMIUM 2K primer surfacer. For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure.

## **EQUIPMENT CLEANING**

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

## **PRODUCT SAFETY INFORMATION**

Before using any PAINTERS PRIDE product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.