



TECHNICAL DATA SHEET

EPOX-PRIME & SEAL

Gray APR12311 - Black APR12321 - White APR12331

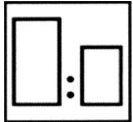
Description

Epoxy-Prime & Seal is a two-component, epoxy primer with good film build and exceptional anti-corrosion properties. It has excellent adhesion to properly sanded and cleaned bare metals, including aluminum. It levels to an almost texture-free surface with excellent gloss holdout. It can be sanded, when needed, and the three colors can be intermixed to achieve various shades of gray. It is V.O.C. compliant in North America and available in quarts and gallons.



Use suitable respiratory protection

Axis recommends to use fresh air supply respirator
Shake well before mixing



4 EPOX-Prime & Seal
1 EPOX-Prime & Seal Activator
4:1:1 Mix as a sealer with Zero VOC Reducer

NOTE: Make sure product is at room temperature (72°F) before mixing.

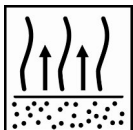


Gravity spray gun set-up:
1.4 - 1.6 mm

Application pressure:
8-10 PSI at air cap
Check gun manufacturer specification



1 - 2 wet coats



Between coats:
10 - 15 minutes



30 - 60 Minutes before applying topcoat

Read complete TDS for detailed product information

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Product and additives

- Product:** - EPOX-Prime & Seal - Gray/Black/White
- Activators:** - EPOX-Prime & Seal Activator (BPR12301-4 / BPR12301-6)

Suitable surfaces

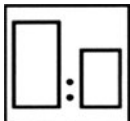
- Cold Rolled Steel*
- Stainless Steel*
- Galvanized/Galvaneal*
- Aluminum*
- OEM Surfaces
- Factory E-coats
- Body Filler/Putty
- *Properly sanded and cleaned

Surface Preparation

Wash area with soap and water, then thoroughly clean with wax and grease remover
Sand surface with 180 – 220 grit sandpaper
Re-clean area with wax and grease remover

NOTE: Aluminum should be prepared by scuffing with a red scu pad.

Mix Ratio



- 4 EPOX-Prime & Seal - Gray/Black/White
1 EPOX-Prime & Seal Activator (BPR12301-4 / BPR12301-6)

Technical Data

Color	Gray/White/Black
Mix Ratio	4:1 (up to 5-10% Reducer Optional)
Pot Life	Up to 8 hours @ 72°F/22.2°C, 50% RH
Dry-Film-Thickness	1.0 – 1.2 mils per coat
Gun Setup (HVLP)	1.4 mm – 1.6 mm
Air Pressure	8 – 10 psi HVLP 40 – 45 psi Conventional
% Solids by Weight	45% (Sprayable, no reducer)
Shelf Life (Unopened)	12 months

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Mix Ratios

MIX RATIO	TOPOCAT COLORS
WHITE APR12331	Whites, Silvers and Light Yellows
4 parts WHITE + 1 part GRAY	Med. Silvers, Yellows, Light Blues and Greens
GRAY APR12311	Med. Gray, Med. Blue, Med. Green, Med. Red, Med Brown
1 part GRAY + 1 part BLACK	Dark Grays, Blues, Greens and Reds Red
BLACK APR12331	Black and other Very Dark Colors

TECH Tips

- EPOX-Prime & Seal can be sanded with 180 – 220 grit or finish sanded with 400 – 600 grit
- Allow EPOX-Prime & Seal to dry 24 hours before sanding and applying a polyester primer

Application

Apply 1 to 2 wet coats of EPOX-Prime & Seal, allowing 10-15 minutes flash time between coats

Dry Time: 30 - 60 minutes before applying topcoat

Recommended gun setup can be found on page 2 under Technical Data

Notes

- Reduce 5%-10% with Zero VOC Reducers for HOT temperatures
- Adding standard grade urethane reducers will increase VOCs
- Adding reducers will decrease dry film thickness
- Scuff and Recoat if let to sit more than 24 hours

Personal Protection

- For use by trained professionals only
- Read label, directions and SDS before use
- Wear appropriate Personal Protection Equipment (PPE) while mixing and spraying
- For additional health and safety information refer to the SDS which can be found at www.finish-pro.com

VOC / Regulatory information

Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air- supplied respirator when exposed to vapors or spray mist.

HEALTH & SAFETY

See Safety Data Sheet and labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all component, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls, and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practice.

Revision Date: May 7th 2020

MANUFACTURED FOR / FABRICADO PARA:

Axis™ - Liberty Bell Equipment Corp. 810 N. Jefferson Ave. St. Louis, MO 63106 Phone/Teléfono (888) 646-1400 www.axiscoatings.com