

# PROPOXY PRIMER

- Two-component epoxy primer
- Superior adhesion and chemical resistance
- Seals porous finishes preventing absorption
- Excellent sanding qualities



## PREMIUM TWO COMPONENT EPOXY SURFACING PRIMER

ProPoxy™ Primer is a multi-use premium, two-part epoxy primer that can be used for both interior and exterior applications to seal undercoats and fillers prior to applying ProPoxy Acrylic Urethane. This non-porous product provides superior adhesion, chemical and corrosion resistance to a variety of substrates including fiberglass/gelcoat, wood, properly etched/primed metal, and previously painted 2-Part paint surfaces.

ProPoxy Primer primes and seals old and new properly prepared substrates, features excellent sanding qualities and enhances the high gloss finish of ProPoxy topcoat.

## TECHNICAL INFORMATION

**VEHICLE TYPE:** Epoxy

**FINISH:** Flat

**COLOR:** White or Gray

**COMPONENTS:** Two

**MIX RATIO:** 1:1

**SOLIDS BY WEIGHT:** 52% ± 2%

**COVERAGE:** Zero loss calculations

575 ft<sup>2</sup>/gal. @ 1 mil

150 ft<sup>2</sup>/gal. @ 3 mils

**VOC:** <335 grams/liter

**APPLICATION METHOD:** Conventional or HVLP

**POT LIFE:** 8 hours @ 70°F

**INDUCTION TIME:** 15 mins

**APPLICATION TEMP:** 50°F Min / 90°F Max

**WET FILM THICKNESS:** 3-6 mils per coat

**DRY FILM THICKNESS:** 1.5-3.0 mils per coat

**REDUCER:** 99 ProPoxy Epoxy Primer Reducer

**THINNER RATIO (MAX):** 10-25%

**CLEANER:** 99 ProPoxy Epoxy Primer Reducer

**RECOAT TIME:** @ 70° 1 - 14 hours

**TAPE OR SANDING TIME:** 16 hours

**FULL CURE:** @ 70° - 165 hours

**ASSOCIATED PRODUCTS:** AnchorTech® Adhesives and Sealants, 125 EZ Speed Strip™, 92 Bio Blue® Hull Surface Prep, 97 Epoxy Thinner, 7050 EZ Fair, 4700/4701 Pettit Protect Epoxy Primer, 130 ProPoxy Prep Solvent, 99 ProPoxy Epoxy Primer Reducer

### Mixing Instructions:

1. Mix part A base material well. All solids must be properly dispersed.
2. Mix part A base and part B activator together at 1:1 mix ratio
3. Reduce with ProPoxy Reducer 10-25% depending on weather and application conditions and mix well
4. Induct mixture for at least 15 minutes prior to reduction and application



**APPLICATION INFORMATION:** ProPoxy Primer may be applied via conventional or HVLP spray equipment. 2 -3 medium volume coverage coats may be applied in a day allowing 1 hour (depending on temperature) in between coats until recommended film thickness is achieved.

Do not apply in the late afternoon when working outdoors as the wet film may be adversely affected by dew. When working in cooler temperatures be sure the air and surface temperatures will remain at or above 45°F for at least 8 hours after application. Do not apply paint materials to surfaces less than 5°F above dew point, or to surfaces warmer than 125°F.

**NOTE: ProPoxy Primer allowed to cure for 7 days or longer must be sanded with 220 grit sandpaper for proper adhesion.**

**PREPARATION FOR PAINTING: Verify if previous painted surface passes the 'coating compatibility testing'.** If the previous coating passes the compatibility test proceed with the outlined steps for preparation. Coating performance, in general, is proportional to the degree of surface preparation. Follow recommendations carefully, avoiding shortcuts. Surface must be free of dirt, loose paint, rust, oil, grease, wax, soap, and any other foreign matter. Remove existing mildew with household bleach instead of ammonia. Prep areas to be painted Pettit 92 Bio-Blue Surface Prep and a scotchbrite® pad and rinse clean with water. Prior to coating application, the surface should be cleaned with Pettit 130 ProPoxy Prep Solvent using the two-rag cleaning method.

**2-PART PAINTED SURFACES:** The entire surface to be painted regardless of age must be thoroughly prepped with 130 ProPoxy Prep Solvent using the two-rag method. In some cases, priming may not be necessary if the previous coating is in excellent condition. If priming is necessary, sand the previous 2-part painted surface with 220 grit sandpaper to a dull appearance, solvent clean to remove residue. If the surface is rough or imperfections exist, it will have to be repaired. Fill all nicks and gouges with 7050 EZ Fair Epoxy Fairing Compound, sand flush when hard. Follow with a coat of ProPoxy Epoxy Primer to smooth the surface and provide a uniform base. Sand all surfaces to final 320-400 grit profile. Entire surface should be wiped down with 130 ProPoxy Prep Solvent using the two-rag method prior to application of ProPoxy acrylic topcoat.

**BARE FIBERGLASS/GELCOAT:** The entire surface to be painted regardless of age must be thoroughly prepped with 130 ProPoxy Prep Solvent using the two-rag method. Sand the gel coat with 220 grit sandpaper to a dull appearance, solvent clean to remove residue. If the surface is rough or imperfections exist, it will have to be repaired. Fill all nicks and gouges with 7050 EZ Fair Epoxy Fairing Compound, sand flush when hard. Follow with a coat of ProPoxy Epoxy Primer to smooth the surface and provide a uniform base. Sand all surfaces to final 320-400 grit profile. Entire surface should be wiped down with 130 ProPoxy Prep Solvent using the two-rag method prior to application of ProPoxy acrylic topcoat.

**Coating Compatibility Testing:** To ensure long term coating performance the surface should be tested with two compatibility tests to confirm solvent compatibility and condition of existing coating.

**Test 1- SOLVENT COMPATIBILITY:** First, sand a 4"x4" area with 220 grit paper lightly to a dull finish. Next, saturate a small rag with Pettit ProPoxy reducer 128 or ProPoxy Epoxy Reducer. Finally, tape the rag to the scuffed surface for 20-30 mins. Remove and inspect coating after 30 mins for detachment, coating degradation or softening.

**Test 2 - SYSTEM ADHESION COMPATIBILITY:** Perform a cross hatch adhesion test of existing coatings under ASTM 3359 Method B or C as appropriate.

If either test fails, the coating must be removed completely, and the sanded surface retested for compatibility.

**BARE STEEL/ALUMINIUM:** Surface must be cleaned to a bright finish by sandblasting or grinding to minimum SSPC-SP10 Near White; remove blast residue with a clean dry air line and broom. Surface must hold a uniform 2-3 mil anchor profile. Aluminum needs to be prepared with non-ferrous media or grinding materials. Immediately apply two coats of 4700/4701 Pettit Protect Epoxy Primer. Allow to dry a minimum of 24 hours. Scuff the primer with 120-180 grit sandpaper. Apply 2-3 coats ProPoxy Epoxy Primer following instructions. Repeat application as needed until a smooth, uniform base is reached. Proceed with the first coat of ProPoxy. Sand all surfaces to final 320-400 grit profile. Entire surface should be wiped down with 130 ProPoxy Prep Solvent using the two-rag method prior to application of ProPoxy acrylic topcoat



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Gun	Air Pressure	Nozzle
Conventional Gravity Feed	20-30 psi	1.4-2.0 mm
Conventional Pressure Pot	8-12 psi (Pot) 20-30 psi(gun)	1.4-2.0 mm at 8-12 oz/min

Dry Times	Touch	Recoat	Through	Tape
90 Degrees	30 mins	1 hour	4 hours	8 hours
70 Degrees	1 hour	1 hour	4 hours	8 hours