



Epoxy Prime™ Primer/Sealer

PS3042™ (Lt. Gray) PS3044™ (Dk. Gray) PS3045™ (Black) PS3047™ (Yellow Oxide)

READ ENTIRE PRODUCT INFORMATION SHEET PRIOR TO USE. IF ANY QUESTIONS ARISE, PLEASE CALL TECHNICAL SUPPORT.

COMPONENTS



PS3042™ Light Gray Epoxy Primer
 PS3044™ Dark Gray Epoxy Primer
 PS3045™ Black Epoxy Primer
 PS3047™ Yellow Oxide Primer
 PA3040E™ Epoxy Catalyst (Express)

SPECIALTY COMPONENTS

PA3040V™ Low 3.5 VOC Catalyst
 TH035™ VOC Compliant Urethane Reducer

DESCRIPTION:

Epoxy Prime™ two-component, chromate-free epoxies are designed for use as medium fill primers that provide optimum adhesion with excellent corrosion protection for bare substrates. Epoxy Prime™ may also be applied as a sealer to ensure greater inter-coat adhesion, chemical resistance, and color holdout. Epoxy Prime™ is a full epoxy resin that utilizes a non-induction catalyst, used to increase productivity for automotive and fleet refinishing. If required, Epoxy Prime™ has a 3.5 VOC catalyst, used for fleet and light industrial applications.

SURFACE PREPARATION

- **Note:** Be sure to completely remove rust or oxidation prior to applying primer. Rust and oxidation can be removed by media blasting, grinding, or sanding. Liquid metal cleaners may be used followed by the appropriate metal conditioner for optimum adhesion and corrosion protection. Be sure all surfaces are free of waxes, oils, grease or other contaminants. Wash painted surfaces and plastic parts with detergent and hot water. Clean metal and painted surfaces with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover or TH5953™ Zero VOC Waterborne Surface Cleaner. Clean bare plastics with AP100™ Plastic Cleaner before sanding.

Bare Substrates: After proper cleaning;

- **Steel:** Finish sand with 80 - P180 grit sandpaper.
- **Aluminum, Galvanized, Stainless Steel:** Sand with P320 grit or scuff using a red scuff pad to remove light oxidation and abrade the surface. Due to certain metal inconsistencies, we suggest using the appropriate metal conditioner for *optimum adhesion*.
- **SMC, Fiberglass:** Finish sand with P180 to P240 grit sandpaper.
- **Bare Plastic:** Use a gray or red scuff pad with a scuffing agent. Rinse with water to remove residue. Re-clean all sanded substrates with their appropriate plastic cleaners and apply adhesion promoter before applying primer.

√ **Tech Tip:** Refer to **PI SHEET #1020** for information and product use of AP100™ and AP200™.

Prepainted Substrates: After proper cleaning;

- Sand repair area and featheredge as needed, finish the featheredge with P320 grit sandpaper. Final sand the area surrounding the repair and featheredge using P400 or finer.
- Re-clean repair with the appropriate surface cleaner to remove sanding residue before priming.

Sealer Option: After proper cleaning;

- Finish sand repairs and the remaining finish using P400 grit sandpaper or finer.

- Re-clean repair with the appropriate surface cleaner to remove sanding residue before applying as a sealer.

COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, stainless, aluminum, galvanized steel, copper, and brass.
- Thoroughly sanded OEM and cured paint.
- Cured and sanded body filler.
- Sanded Fiberglass and SMC.
- Properly prepared plastic.

Note: Do Not use over soluble substrates, Viper Grip II™, lacquer primer or lacquer finishes.

MIX BY VOLUME



As a Medium Build Primer

- 1 Part Epoxy Prime™
- 1 Part Epoxy Catalyst



As a Sealer

- 1 Part Epoxy Prime™
- 1 Part Epoxy Catalyst
- ¼ Part VOC Compliant Urethane Reducer

Catalyst Recommendations:

PA3040E™: (Express) Non-induction hardener, providing faster drying properties and no waiting to use once mixed.

PA3040V™: Non-induction, should be used when 3.5 VOC is required.

Note: We recommend using catalysts within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

TINTING

- Not Recommended.

POT LIFE



- 16-hours at 75°F/23°C.
- Clean equipment immediately after use.

EQUIPMENT SETUP



	Fluid Tip	Air Pressure
HVLP Gravity	1.4 – 1.6mm	7 – 10 PSI at the cap
HVLP Siphon	1.6 – 1.8mm	7 – 10 PSI at the cap
High Efficiency Gravity	1.3 – 1.6mm	30 – 40 (PSI) Inlet Pressure
High Efficiency Siphon	1.6 – 1.8mm	30 – 40 (PSI) Inlet Pressure
Conventional Gravity	1.4 – 1.6mm	35 – 45 (PSI) Inlet Pressure
Conventional Siphon	1.6 – 1.8mm	40 – 50 (PSI) Inlet Pressure

Note: These are starting points for spray gun recommendations. Refer to spray gun manufacturers recommendations for proper setup and operation. Additional adjustments may be necessary.

PRIMER APPLICATION



- Apply in single wet coats, allowing 15-minutes flash between coats.
- Apply 1-2 coats, depending on desired film build keeping within the sanded repair area.

- A light coat of body filler may be applied over 1 coat of Epoxy Prime™ after 2 hours at 75°F/23°C. If two coats of Epoxy Prime™ are applied, wait overnight before applying filler.

SEALER APPLICATION

- Apply 1 single wet coat of Epoxy Prime™ reduced as a sealer, to create a uniform base.
- Allow to flash for 45-60 minutes at 75°F/23°C before applying topcoats.

DRY TIME TO SAND

Primer Option:

Note: As a rule, epoxy primers do not sand well until completely dry.

- Air Dry: Overnight at 75°F/23°C for best results
- Final sand with P400 - P600 grit sandpaper before topcoating.

Sealer Option:

- Sealer option does not require sanding if topcoated within maximum recoat time.
- If necessary, Air Dry: 45-60 minutes at 75°F/23°C before sanding to remove debris.

TIME TO TOPCOAT

Primer Option:

- Minimum 1-hour dry time per coat and maximum 24-hours at 75°F/23°C.
- Between 24-72 hours, Epoxy Prime™ must be sanded prior to topcoating.
- After 72 hours, Epoxy Prime™ must be sanded and recoated with a single coat of Epoxy Prime™, Super Prime™ or Super Seal™ prior to topcoating.

Sealer Option:

- Minimum 45 minutes dry time and maximum 6-hours at 75°F/23°C prior to topcoating.
- Between 6-24 hours, Epoxy Prime™ must be sanded prior to topcoating.
- After 24 hours, Epoxy Prime™ must be sanded and recoated with a single coat Epoxy Prime™ or Super Seal™ prior to topcoating.

FLEXIBLE PARTS

- We suggest the use of AP200™ Plastic Adhesion Promoter prior to priming. Refer to Product information sheet #1020 for additional information on AP200™.
- Refer to Information Bulletin #MC31 for further information about plastic refinishing.

COMPATIBLE TOPCOATS

- | | |
|--|---|
| • System 10™ Acrylic Enamel Color | • System 12™ Acrylic Enamel Color |
| • System 20™ Synthetic Enamel Color | • System 22™ Acrylic Urethane Color |
| • System 28™ 2.8 VOC Polyurethane Color | • System 35™ 3.5 VOC Polyurethane Color |
| • System 50™ SkyBase® Basecoat Color | • System 60™ 3.5VOC Polyurethane Color |
| • Metalux2™ International Basecoat Color | • Acrylic Urethane Topcoats |
| • Polyurethane Topcoats | • Acrylic Enamels |
| • Acrylic Urethane Primer-Surfacers | • Montana Branded DTM Primer/Sealer/Surfacers |

√ **Tech Tip:** Activated basecoats offer better chemical resistance and inter-coat adhesion.

SPECIAL NOTES

- Ensure shop and repair surface temperatures are maintained above 75°F/23°C.prior to work.
- Ensure proper metal conditioning and preparation procedures are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions are followed.
- Ensure primer and paint temperatures are maintained above 75°F/23°C.prior to work.
- Maintain accurate measuring during mixing.

PHYSICAL DATA

Primer Surfacer/Standard Catalyst (Mix 1:1) at 75°F/23°C		Sealer (Mix Ratio 1:1:1/4) with VOC Compliant Reducer	
Dry to Sand	Best Overnight	Dry to Topcoat	30-45 minutes (single coat)
Film Thickness	1.0 ± .2 mils per coat	Film Thickness	.8 ± .2 mils per coat
Volume Solids	32.9	Volume Solids	29.2
VOC Applied	4.6	VOC Applied	4.6
Theoretical Coverage RTS	529sq. ft. @ 1 mil	Theoretical Coverage RTS	469 sq. ft. @ 1 mil
Flash Point	See MSDS	Flash Point	See MSDS

CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

DISPOSAL

Dispose of all paint and paint related materials in accordance with state and local regulations.

SAFETY & HEALTH

Read and follow all technical product information, labels, and MSDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

MSDS REFERENCE

Primer – MSDS #9
Catalyst – MSDS #6
Reducer – MSDS #1

COMPANY INFORMATION

ChemSpec USA
9287 Smucker Road
Orrville, Ohio 44667
Toll Free: (800) 328-4892
Fax: (330) 669-3965
Website: www.chemspecpaint.com

Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Material Safety Data Sheets (MSDS) supplied with the materials.

KEEP OUT OF REACH OF CHILDREN