

**Description**

2.1 VOC High Build Epoxy Primer has been formulated for excellent adhesion and corrosion resistance when used on various types of substrates including properly prepared steel and aluminum. When mixed properly, Epoxy Primer is compliant with all known Canadian and US rules including Rule 1151 in the SCAQMD.

Components

- | | | | |
|-----------|--------------------|-----------|-------------------|
| • #7500-1 | Dark Gray - Gallon | • #7502-1 | White - Gallon |
| • #7500-4 | Dark Gray - Quart | • #7502-4 | White - Quart |
| • #7501-1 | Black - Gallon | • #7503-1 | Catalyst - Gallon |
| • #7501-4 | Black - Quart | • #7503-4 | Catalyst - Quart |

Mixing Ratio

Mix one (1) part Epoxy Base to one (1) part Epoxy Catalyst. Reduce 15-25% with High Teck Reducers to maintain 2.1 VOC. May be used for non-compliant product areas.

Pot Life at 77°F

8 Hours

Clean Up

Use High Teck Lacquer thinner or Zero VOC solvents. (Check local regulations)

Physical Data

Solids wt. (as mixed)	44 - 54%
VOC as mixed	2.1
Color	Light Gray

Dry/Flash Times**Air Dry at 77° F**

Flash between coats	30 minutes
To sand	Overnight
To topcoat	60 minutes

Force Dry

Flash before force dry	15 minutes flash
Force dry time	30 minutes at 140° F

Gun Setups**Conventional**

Gravity Feed	1.5 mm – 1.8 mm
Siphon Feed	1.5 mm – 1.8 mm



HIGH TECK™

TECHNICAL DATA SHEET

2.1 VOC HIGH BUILD EPOXY PRIMER

Air Pressures

Conventional at Gun

Gravity Feed	35 – 45 psi
Siphon Feed	40 – 50 psi
HVLP at cap	8 – 10 psi

Surface Preparation

Use at clean wipe to clean substrate free of grease, dirt, and foreign contaminants.

Application

- Apply 1 - 2 medium wet coats over substrate
- Allow 15 minutes between coats, 60 minutes to topcoat
- Scuff after 48 hour period
- Clean gun after spraying is completed

Safety

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.
