

One Pak Primer TECHNICAL DATA

One Component Primer

**Oil Based Alkyd Primer
Rust Inhibitor
Prevents Solvent Lift**

VOC Class: Primer VOC- 406 g/l

<p>STANDARD PRODUCT DESCRIPTION</p>	<p>A one component, rust inhibitive, corrosion resistant universal primer. This product is designed to be used as a primer under most types of topcoats especially enamels and latex coatings. One Pak Primer is used as a tie coat over sound, aged conventional paints to upgrade to a more chemical resistant type coating.</p> <p>This product is not California VOC compliant and cannot be sold in that state. It cannot be sold in the OTC states (Eastern seaboard states, Maine to Virginia).</p>		
<p>USES</p>	<p>Ideal as a universal primer on steel surfaces such as storage tanks, vessels, water towers, bridges, structural steel, marine structures, equipment, pipelines and racks, exterior building, etc. as well as a wood primer under latex topcoats.</p>		
<p>FEATURES</p>	<ol style="list-style-type: none"> 1. Non-lifting when used as a primer under chemical resistant coatings. 2. Good resistance to undercoatng and rust creepage. 3. Excellent adhesion to sound, aged coatings. 4. Can be used as a shop primer. 5. Can be sprayed, brushed or rolled. 6. Can be topcoated in 12 hours. 7. Non-toxic, contains no lead or chromates. 8. Recommended for mild chemical environments, not recommended for immersion. 		
<p>PHYSICAL PROPERTIES</p>	<p>COLOR Off white MIXING RATIO One component, stir well FINISH Flat THINNING Xylene CLEAN UP Xylene RECOAT TIME @ 75°F 12 hours APPLICATION Spray, roll or brush SERVICE TEMP 180°F APPLICATION TEMPERATURE 50°F - 120°F THEORETICAL COVERAGE 200-250 ft. per gallon DRY FILM THICKNESS 1-3 mils VOLUME SOLIDS 53% V.O.C. 3.39 lbs/gal (406 Gms/L) SHELF LIFE 12 months minimum</p>		
<p>CURE TIME</p>	<p><u>Temperature</u> 90°F 75°F 50°F</p>	<p><u>Tack-Free</u> 1 hour 2 hours 8 hours</p>	<p><u>Recoat</u> 3-4 hours 4-8 hours 18-48 hours</p>

SOLVENT-FREE COATINGS FOR TOUGH ENVIRONMENTS

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SURFACE PREPARATION	<p>1) Steel: For best results, sand blast to a 'commercial' blast finish. Where blasting is not appropriate, remove all loose rust and mill scale by power wire brushing or hand tool cleaning.</p> <p>2) Galvanized steel: Remove all oil, grease dirt, and other foreign matter. Surface should be clean, dry and free of contaminants. Remove all loose rust, etc., as outlined above under steel.</p> <p>3) Previously Painted Surfaces: Remove all loose, peeling, or blistered paints, and any other surface contaminants. Make sure surface is sound and dry. Apply a test patch of 1 Pak Primer over existing coating to check for adhesion and compatibility.</p>		
MIXING INSTRUCTIONS	<p>Stir each component to a uniform consistency, using a variable speed explosion proof drill and a Jiffy mixer. Make sure any pigment settled to the bottom is incorporated. One Pak Primer may be thinned up to 10% of xylene for 1 gallon of mixed material.</p> <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; vertical-align: top;"> <p>Spray: <u>Conventional</u> Gun - DeVilbiss Fluid Tip - 'E' Needle Air Cap - #704 Atomizing Pressure - 35/40 psi Pot Pressure - 50 psi Hose - 1/2" - 5/16" ID</p> </td> <td style="width: 50%; vertical-align: top;"> <p><u>Airless Spray</u> Gun - Graco 240-000 Pump - 30:1 Tip Range - 013" - .017" Hose - 3/8" - 1/2" ID</p> </td> </tr> </table> <p>Apply by brush, roller or sprayer. Apply in a VERY thin coat. Thick applications are not recommended.</p> <p>When spraying, use a 50% overlapping crosshatch pattern to minimize the occurrence of pinholes. Do not apply to surfaces below 50°F. Or Above 120°F. Do not apply over dew or frost. Do not apply if the temperature is within 5°F of the dew point. For safety and product curing, proper ventilation is necessary throughout application and cure.</p>	<p>Spray: <u>Conventional</u> Gun - DeVilbiss Fluid Tip - 'E' Needle Air Cap - #704 Atomizing Pressure - 35/40 psi Pot Pressure - 50 psi Hose - 1/2" - 5/16" ID</p>	<p><u>Airless Spray</u> Gun - Graco 240-000 Pump - 30:1 Tip Range - 013" - .017" Hose - 3/8" - 1/2" ID</p>
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CAUTIONS	<p>One Pak Primer is flammable. This product contains flammable solvents. Keep away from all sources of ignition during mixing, application, and cure. In confined areas, provide adequate forced air ventilation. The use of goggles, fresh air masks or NIOSH approved respirators, protective skin cream and protective clothing is a recommended standard practice when spraying coatings.</p> <p>This product is sold without warranty as to performance expressed or implied. Users are urged to make their own tests to determine the suitability for their particular conditions.</p>		
TRANSPORT	<p>Regulated by USDOT, IATA & IMO. Flammable Liquid, UN 1493, Packing Group III, Class 8</p>		

SAFETY: This is a hazardous material if misused. Read and understand the Material Safety Data Sheet (MSDS) before use.

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Manufactured by:
GCPM in Al

Distributed by:
Progressive Epoxy Polymers, Inc.
48 Wildwood Dr.
Pittsfield, NH 03263-3406

Tel: 603-435-7199
Fax: 603-435-7182
www.epoxyproducts.com
info@epoxyproducts.com