**One Pak Primer**  
**TECHNICAL DATA**

## One Component Primer

### Description

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.

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).

### Uses

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.

### Features

1. Non-lifting when used as a primer under chemical resistant coatings.
2. Good resistance to undercoating 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.

### Physical Properties

- **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%
- **VOC:** 3.39 lbs/gal (406 Gms/L)
- **Shelf Life:** 12 months minimum

### Cure Time

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Tack-Free Time</th>
<th>Recoat Time</th>
</tr>
</thead>
<tbody>
<tr>
<td>90°F</td>
<td>1 hour</td>
<td>3-4 hours</td>
</tr>
<tr>
<td>75°F</td>
<td>2 hours</td>
<td>4-8 hours</td>
</tr>
<tr>
<td>50°F</td>
<td>8 hours</td>
<td>18-48 hours</td>
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</table>

SOLVENT-FREE COATINGS FOR TOUGH ENVIRONMENTS
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### SURFACE PREPARATION

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.

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.

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.

### MIXING INSTRUCTIONS

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.

**Spray:**

- Conventional
  - Gun - DeVilbiss
  - Fluid Tip - ‘E’ Needle
  - Air Cap - #704
  - Atomizing Pressure - 35/40 psi
  - Pot Pressure - 50 psi
  - Hose - 1/2” - 5/16” ID

- Airless Spray
  - Gun - Graco 240-000
  - Pump - 30:1
  - Tip Range - 013” - .017”
  - Hose - 3/8” - 1/2” ID

Apply by brush, roller or sprayer. Apply in a VERY thin coat. Thick applications are not recommended.

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.

### CAUTIONS

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.

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.

### TRANSPORT

Regulated by USDOT, IATA & IMO. Flammable Liquid, UN 1493, Packing Group III, Class 8

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

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