

2K Epoxy Primer / Sealer is a chromate and isocyanate-free product designed to be used as a corrosion resistant primer. It dries fast and provides very good topcoat holdout. Primer can be used on all properly prepared metals and plastics. 2K Epoxy Primer can be tinted up to 5% with toner or primer tints to improve topcoat hiding.

PRODUCT	SIZE	COLOR	ACTIVATOR
13170	U.S. Quart (946 ml)	Gray	13164 U.S. Quart (946 ml)
13172	U.S. Gallon (3.78 L)	Gray	13162 U.S. Gallon (3.78 L)
13174	U.S. Gallon (3.78 L)	Black	13162 U.S. Gallon (3.78 L)
13176	U.S. Gallon (3.78 L)	White	13162 U.S. Gallon (3.78 L)

READ ALL INSTRUCTIONS AND SAFETY PROCEDURES PRIOR TO USING!

IMPORTANT! This product contains hazardous materials.

Proper protective equipment should be used at all times. Please consult labels on each product as well as the safety data sheet for complete safe handling procedures and personal protection information.

NOTE: TEST ON A HIDDEN AREA BEFORE USING TO MAKE SURE THE PRODUCT PERFORMS TO YOUR SATISFACTION.

SUITABLE SUBSTRATES

- Metals
- Plastics

ADVANTAGES

- Direct to metal
- Excellent adhesion
- Corrosion resistant
- Excellent color holdout

SURFACE PREPARATION:

1. Before sanding, wash all surfaces thoroughly with soap and water. Rinse well and dry with a clean cloth.
2. Clean surface with 19160 Heavy Duty Wax & Grease Remover (Strong). Wipe dry while surface is still wet.
3. Completely sand surface with 180–220 grit paper. Aluminum and stainless steel MUST be sanded with 180–220 grit sandpaper even if a metal prep or self etching primer is used.
4. Wipe all sanded areas with 19180 Prime Wash Wax & Grease Remover (Mild) before applying primer.
5. Prime aluminum and stainless steel within 72 hours. Prime bare steel immediately after cleaning.

MIXING DIRECTIONS:

Mix in order shown. Stir thoroughly between each addition and continue to stir regularly after catalyzed. Strain before spraying material. Can be used with one of these Urethane Grade Reducers: Slow 13546, Medium 13566 or Fast 13586.



For Primer:
1 part Primer: 1 part Activator



For Sealer:
1 part Primer: 1 part Activator: 1/2 part Urethane Reducer

APPLICATION INSTRUCTIONS:

All drying times refer to shop temperature of 68°F (20°C) / 50% humidity. Allow additional drying time when optimal conditions are not reached.

SPRAY GUN AND PRESSURE:

<i>Gun Type</i>	<i>Fluid Tip</i>	<i>Air Pressure</i>
Siphon Feed	1.4-1.6 mm	45-55 psi
Gravity Feed	1.2-1.6 mm	40-45 psi
HVLP	1.2-1.6 mm	10 psi

Apply 1-2 full wet coats of primer allowing 15 minutes flash between coats (1.0 mils DFT). Allow 30 to 60 minutes dry times before applying additional primers or topcoats. To achieve maximum film integrity, allow at least 3 hours dry time if film thickness exceeds 1.0 mils. Allow 12 hours drying time before applying body fillers.

IF USED AS A SEALER:	Apply 1 wet coat to achieve a dry film of 0.5 mils DFT. Allow 20–30 minutes flash time before applying topcoat.
DRY TIME:	30-60 minutes
SANDING:	6-8 hours
RECOATING:	If Epoxy Primer/Sealer is allowed to dry more than 1 week, primer must be cleaned with 19180 Prime Wash Wax & Grease Remover (Mild), sanded with 500 grit paper before topcoating, or sealer must be scuff sanded and re-applied. Over some undercured OEM substrates, a recoat lift may occur. The solution is to apply this primer as a sealer after 1 hour and topcoat as normal.
FISH EYE:	Do not use fish eye eliminator with this product.
POT LIFE:	3-5 hours
CLEANING INSTRUCTIONS:	Clean equipment with 13612 Acrylic Lacquer Thinner immediately after use.

Caution: Test the compatibility of this product with your paint system. Do not use in temperatures below 60°F (16°C). Use below these temperatures will affect dry times and performance.

TECHNICAL DATA:

	Primers			Activators		
	13170	13172	13174	13176	13164	13162
Physical State	Liquid					
Color:	Gray	Black	White	Light Yellow		
Odour:	Solvent odour	Aromatic	Solvent odour	Mild odour		
Solubility :	Slightly soluble in water					
Flash point:	4.4°C or 39.92°F (estimated)			4°C or 39.2°F (estimate)		
Auto ignition temperature:	287°C or 548.6°F			No Data		
VOC	2.32 lbs/gal • 278 g/L	2.17 lbs/gal • 260.02 g/L	2.17 lbs/gal • 260.02 g/L	0.94 lbs/gal • 112.64 g/L		

PRECAUTIONARY INFORMATION

Refer to product label and Safety Data Sheet for health and safety information before using this product.

SAFETY CONSIDERATION

Safety Data Sheets are available at www.proformproducts.com or upon request at info@proformproducts.com. These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

TECHNICAL INFORMATION

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

PRODUCT USE

Many factors beyond Pro Form's control and uniquely within user's knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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