

High Solids Epoxy Primer is an 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.

PRODUCT	SIZE	COLOR	ACTIVATOR
13242	U.S. Quart (946 ml)	Gray	13254 U.S. Quart (946 ml)
13240	U.S. Gallon (3.78 L)	Gray	13252 U.S. Gallon (3.78 L)
13244	U.S. Gallon (3.78 L)	White	13252 U.S. Gallon (3.78 L)
13246	U.S. Gallon (3.78 L)	Black	13252 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 80-180 grit paper. Aluminum and stainless steel **MUST** be sanded with 80-180 grit paper 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 8 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: ½ part Urethane Reducer

### APPLICATION INSTRUCTIONS:

All drying times refer to shop temperature of 75°F (24°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.

<b>IF USED AS A SEALER:</b>	Apply 1 wet coat to achieve a dry film of 0.5 mils DFT. Allow 20 - 30 minutes flash time before applying topcoat.
<b>DRY TIME:</b>	30-60 minutes
<b>SANDING:</b>	6-8 hours
<b>RECOATING:</b>	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 under-cured OEM substrates, a recoat lift may occur. The solution is to apply this primer as a sealer after 1 hour and topcoat as normal.
<b>FISH EYE:</b>	Do not use fish eye eliminator with this product.
<b>POT LIFE:</b>	3-5 hours
<b>CLEANING INSTRUCTIONS:</b>	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	
	13242	13240	13244	13246	13252	13254
<b>Physical State</b>	Liquid					
<b>Color:</b>	Gray		White	Black	Pale Yellow	
<b>Odour:</b>	Solvent odour					
<b>Solubility :</b>	Slightly soluble in water					
<b>Flash point:</b>	-18°C or -0.4°F				4°C or 39.2°F (Closed Cup)	
<b>Auto ignition temperature:</b>	> 343°C or > 649.4°F					
<b>VOC</b>	215.7 g/L - 1.8 lb/usg		214 g/L - 1.79 lb/usg		2.24 lb/usg - 268 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](http://www.proformproducts.com) or upon request at [info@proformproducts.com](mailto: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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