

### Product Data Sheet

2K Epoxy Primer/Sealer is a high-quality, two-component, isocyanate-free epoxy primer designed to be used as a corrosion resistant primer with excellent adhesion to metal, fiberglass and aluminum surfaces. 2K Epoxy Primer Sealer improves adhesion of body fillers and resists moisture damage caused by water permeation. This epoxy primer also offers additional color holdout characteristics, can be tinted with Universal Primer Tints.

PRODUCT	SIZE	COLOR	ACTIVATOR
PF 664C	946 ml (U.S. Quart)	Gray	PF 663C 946 ml (U.S. Quart)
PF 661C	3.78 L (U.S. Gallon)	Gray	PF 660C 3.78 L (U.S. Gallon)
PF 662C	3.78 L (U.S. Gallon)	Black	PF 660C 3.78 L (U.S. Gallon)
PF 665C	3.78 L (U.S. Gallon)	White	PF 660C 3.78 L (U.S. Gallon)

**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
- Fiberglass
- Aluminum

#### ADVANTAGES:

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

#### SURFACE PREPARATION:

1. Wash area thoroughly with soap and water to remove contaminants that solvent based cleaners cannot remove effectively. All substrates must be degreased and sanded. All rust must be removed.
2. Clean repair area with PF 605-1 Wax & Grease Remover (Strong). Clean fiberglass surfaces with PF 606 Plastic Parts Cleaner. Wipe dry while the surface is still wet.
3. Sand bare metal area with 80-180 grit abrasive. Sand old finishes with 320-400 grit dry by hand or machine, or 600 grit wet. Re-clean area with PF 605-1 Wax & Grease Remover.
4. Prime aluminum substrates within 8 hours. Prime carbon steel immediately after cleaning.

#### MIXING DIRECTIONS:



**For Primer 1 : 1** 1 part Primer: 1 part Activator



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

## 2K Epoxy Primer/Sealer

PF 660C, PF 661C, PF 662C,  
PF 663C, PF 664C, PF 665C

### DIRECTIONS FOR USE:

All drying times refer to shop temperature of 24°C (75°F) / 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 (2-3 mils wet). Allow 20 minutes to recoat with Epoxy Primer/Sealer again. Maximum recoat without sanding 48 hours. Topcoat/primer 4 hours to 16 hours. Allow 24 hours drying time before applying body filler.

### IF USED AS A PRIMER:

1. Apply 1-2 full wet coats of primer allowing 15 minutes flash between coats (2-3 mils wet).
2. Allow 20 minutes to recoat with Epoxy Primer/Sealer again.
3. Maximum recoat without sanding 48 hours.
4. Topcoat/primer 4 hours to 16 hours.
5. Allow 24 hours drying time before applying body filler.

### IF USED AS A SEALER:

1. Adjust air pressure.
2. Apply 1 wet coat to achieve a dry film of 0.5 mils DFT.
3. Allow 20-30 minutes flash time before applying topcoat.

May be tinted using universal tinting bases. The mixing ratio should not exceed 5% of the primer.

<b>REDUCERS:</b>	Reducing is not recommended. However, if desired, up to 20% by volume of Zero V.O.C. Urethane Grade Reducers can be used.		
<b>DRYING TIMES @ 24°C (75°F):</b>	Flash: 15 minutes	Sanding: 20-30 minutes	Topcoat: Primer: 30-60 minutes Topcoat: Sealer: 20-30 minutes
<b>FORCE DRYING @ 60° (140°F):</b>	Purge Time: 15-20 minutes		Bake Time: 20-30 minutes
<b>REPAIRING &amp; RECOATING:</b>	If Epoxy Primer/Sealer is allowed to dry more than 2 days, primer must be cleaned with PF 603 Wax and Grease Remover (Mild), and sanded with 500 grit abrasive before topcoating. Sealer must be scuff sanded, cleaned with PF 603 Wax & Grease Remover (Mild), and re-applied. Maximum 1 mil wet.		
<b>ACCELERATOR:</b>	Do not use accelerator.		
<b>FISH EYE:</b>	Do not use Fish Eye Eliminator		
<b>POT LIFE:</b>	4-5 hours		
<b>CLEANING INSTRUCTIONS:</b>	Clean equipment immediately with Gun Wash or PF 686C Acrylic Lacquer Thinner.		

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**Caution:** It is important to test the compatibility of this product with your paint system. This product is not recommended for use in temperatures below 16°C (60°F). The use below these temperatures will affect dry times and performance.

#### TECHNICAL DATA:

	PF 664C, PF 661C	PF 662C	PF 665C	PF 663C, PF 660C
<b>Physical State</b>	Liquid			
<b>Color:</b>	Gray	Black	White	Light yellow
<b>Odour:</b>	Solvent odour	Aromatic	Solvent odour	Mild odour
<b>Solubility :</b>	Negligible	Slightly soluble in water	Negligible	Negligible
<b>Flash point:</b>	4°C (39.2°F) (estimate; lowest flash point ingredient)			
<b>Auto ignition temperature:</b>	Not available	287°C (548.6°F)	No data	No data
<b>VOC:</b>	2.17 lbs/usg • 260 g/L	2.17 lbs/usg • 260 g/L	2.15 lbs/usg • 257.6 g/L	1.88 lbs/usg • 225 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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