



Technical Data Sheet

Epoxy Finishing Primer

60W36- White Base	428 g/L or 3.6 lb/gl
60A20- Light Gray Base	428 g/L or 3.6 lb/gl
60C37- Converter	616 g/L or 5.1 lb/gl
PR106- Spray reducer	850 g/L or 7.1 lb/gl
TR265- Brushing Reducer	946 g/L or 7.9 lb/gl
VOC as applied, 15% red, Spray	443g/L or 4.03 lb/gl
VOC as applied, 10% red., Brush	558 g/L or 4.7 lb/gl

Features & Uses

Oceanair Performance Coatings' Epoxy Finishing Primer is a two component epoxy finishing primer with excellent corrosion resistance and adhesion properties for application to fiberglass or gel coat, aluminum and steel, or wood. Epoxy Finishing Primer is engineered to tightly seal both newly faired and surfaced substrates as well as existing, compatible paint systems simply in need of an up-grade. Carefully applied and finely sanded, Epoxy Finishing Primer is the final step taken to create that classic "concert grand" finish provided by Oceanair's Linear Polyurethane Topcoats. Apply 2-3 coats per day- depending on reduction rate- when temperatures are maintained above 75° F throughout the application process. Apply by spray, brush or roller. For application above the waterline.

Specification Data

Type: Epoxy Polyamide

Packaging: 1 U.S. Gallon

Theoretical Coverage - Sq. Feet/Mixed Gallon @15% reduction; 497 Sq. Feet (46 sq mt) at 1 mil dry (25 microns).
165-250 Sq. Feet (15-23 sq mt) at recommended total dry film thickness.

Recommended Wet Film Thickness: 6-9 mils (150-225 microns) applied in 2-3 coats.

Recommended Dry Film Thickness: 2-3 mils (50-75 microns) per coat. 2-3 coats recommended.

Coverage data given is theoretical, and assumes 100% of the mixed product is applied to a given surface. Actual coverage yield obtained will vary according to equipment choice, application technique, part size and environmental conditions.

Drying Schedule

NOTE: The table below indicates approximate minimum and maximum times. Variables in surface temperature, air flow over the surface, direct or indirect sunlight, volume of reducer and wet film build will all effect the actual times during application. Cure cycle minimum advisable temperature is 60°F. The ideal temperature is 77° F.

Temperature for minimum recoat	60°F	70°F	77°F	90°F	Maximum dry Time
Pot Life- aprox	16 hrs	16 hrs	16 hrs	16 hrs	8 hrs
Dust Free- Spray only	2 hrs	1.5 hrs	1 hr	45 mins	N/A
Tape Time- Spray only	30 hrs	24 hrs	18 hrs	12 hrs	N/A
Full Cure	14 days	10 days	7 days	5 days	N/A
Recoat with Epoxy Finishing Primer Spray Only	2 hrs Minimum	1.5 hrs Minimum	1 hrs Minimum	1 hr Minimum	24 hrs Maximum Sand P180-P220
Recoat with Epoxy Finishing Primer Brush/Roller	16-14 hrs	12-14 hrs	12-14 hrs	8-12 hrs	24 hrs Maximum Sand P180-P220
Overcoat with another product	12 hrs Minimum	12 hrs Minimum	12 hrs Minimum	12 hrs Minimum	24 hrs Maximum Sand P280-P320

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Surface Preparation

The substrate must be clean, dry and free from dust, grease, oil and other contamination.

Fiberglass and gel coat can be coated directly with Epoxy Finishing Primer after sanding with P100 - P150 grit.

Steel and Aluminum should initially be coated with either Zinc Chromate Wash Primer, or 30Y98 Strontium Chromate Epoxy Primer for best over-all performance. Choice of system will dictate which chromate primer is best suited for the application. **Aluminum:** Grit blast or grind to a clean silver color with a 2-3 mil profile.

Steel: Blast/grind to SSPC-SP10 near white metal.

Fairing Systems: Epoxy Finishing Primer should be applied over High Build Epoxy Fairing Primer after first being block sanded to 100 - 150 grit.

Refit and repair: Existing coating systems must have good adhesion and chemical compatibility. Compatibility testing should be performed if there is any question in this regard. Once these doubts have been allayed, sound/compatible surfaces must be sanded with 100 - 150 grit. Any incompatible/poorly adhering coatings must be removed to a sound surface.

Wood: Smooth sand with P80-P100. Best results are obtained by reducing the first coat a minimum of 40% with PR106. Allow to cure 6-8 hours, and apply two additional coats at standard reduction of 25%.

Mixing & Reduction Directions

Base and Converter must be thoroughly agitated before mixing. Mix by volume one part Epoxy Finishing Primer with one part Converter to a smooth, homogenous mixture. Allow mixture to induct for 15 minutes. Reduce/thin inducted mixture by 10-25% with PR106 for spray application, 0-10% with TR265 for brush application.

Spray Example: 10 oz. Base : 10 oz. 60C37 : 5 oz. PR106= 25% reduction

Brush Example: 10 oz. Base : 10 oz. 60C37 : 1 oz. TR265= 10% reduction

The volume of reduction required will vary dependent on the application conditions and choice of equipment.

Application Directions

Application Equipment: Conventionally Atomized or Brush/Roller. Airless application is not recommended.

Fluid Nozzle and Needle, Gravity/Siphon- 0.055"-0.071"/1.4-1.8 mm- Conventional or HVLP.

Fluid Nozzle and Needle, Pressure Feed- 0.046"-0.060"/1.2-1.6 mm- Conventional or HVLP.

Pot Pressure: 10-20 PSI- Conventional and HVLP. Atomization Pressure: 30-60 PSI- Conventional and HVLP.

Spray: Apply Epoxy Finishing Primer in 2 or 3 full, even coats totaling 7 to 10 mils wet film thickness to yield 2 to 3 mils dry film thickness.

Brush/Roller: Apply 2 to 3 coats at 3 to 4 wet mils each yielding 1.0-1.5 mils dry film per coat. Allow 12-14 hours between coats. Light sanding with P320 between coats is advised to improve final appearance.

Equipment Cleaning

Acetone, methyl ethyl ketone or PR106 are acceptable.

Environmental, Health and Safety Report

Read SDS and all container labels before opening or using this product. Store containers tightly sealed, upright & locked up, indoors at 0-104°F. Keep away from open flame and sparks. Dispose of contents, containers and any unused mix material in accordance with local/regional/national/international regulations.

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Professional Use Only

The information provided in this Technical Data Sheet is not intended to be exhaustive. Any recommendation contained in this document covering the use, application, chemical, physical or other properties of the product is believed to be reliable; however Oceanair Performance Coatings make any warranty or representation with these respects. Use or application of any Oceanair Performance Coatings distributed product is at the discretion of the Buyer without any liability or obligation whatsoever to Oceanair Performance Coatings.

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