# Technical Data Sheet
## High Build Epoxy Fairing Primer

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|---|---|
| 50W802- White Base | 347 g/L or 2.9 lb/gl |
| 50Y902- Yellow Base | 338 g/L or 2.8 lb/gl |
| 50C302- Converter | 361 g/L or 3.0 lb/gl |
| PR106- Spray reducer | 850 g/L or 7.1 lb/gl |
| VOC as applied, 20% red. | 436 g/L or 3.7 lb/gl |

## Features & Uses

Oceanair Performance Coatings' High Build Epoxy Fairing Primer is a two component epoxy surfacing primer intended for use in applications that require the higher build and filling capacity that finishing primers cannot safely yield. High Build Epoxy Fairing Primer is crucial in fairing projects, as it provides both adhesion to the surface, and thermal-protective insulation to the fairing works prior to application of finishing primers. Apply 2-3 coats per day- depending on reduction rate- when temperatures are maintained above 75° F throughout the application process. Engineered as an intermediate coating, High Build Epoxy Fairing Primer should never be over-coated directly with any topcoat. Apply by spray for best results. For application above the waterline only.

## Specification Data

Type: Epoxy Polyamide
Packaging: 1 U.S. Gallon
Theoretical Coverage - Sq. Feet/Mixed Gallon @ 20% reduction; 777 Sq. Feet (72 sq mt) at 1 mil dry (25 microns).
110-150 Sq. Feet (10-15 sq mt) at recommended total dry film thickness.
Recommended Wet Film Thickness: 8-10 mils (200-250 microns) per coat.
Recommended Dry Film Thickness: 4-5 mils (100-125 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 time | 60°F | 70°F | 77°F | 90°F | Maximum dry Time |
|---|---|---|---|---|---|
| Pot Life- aprox | 8 hrs | 8 hrs | 8 hrs | 6 hrs | 8 hrs |
| Full Cure | 21 days | 18 days | 14 days | 10 days | N/A |
| Tape Time | 30 hrs | 24 hrs | 18 hrs | 12 hrs | N/A |
| Recoat with High Build Fairing Primer | 4 hrs Minimum | 2 hrs Minimum | 1-2 hrs Minimum | 1 hr Minimum | 24 hrs Maximum Sand P100-P150 |
| Overcoat with another product | 12 hrs | 12 hrs | 12 hrs | 12 hrs | 24 hrs Maximum Sand P100-P150 |

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## Surface Preparation

High Build Epoxy Fairing Primer is intended to be used as a surfacer over other properly prepared Oceanair primers and fairing compounds. Fairing compounds must be sanded with P60-P150 grit, then thoroughly cleaned of all sanding debris before application of High Build Epoxy Fairing Primer. NEVER SOLVENT-WIPE FAIRED AND SANDED SURFACES UNDER ANY CIRCUMSTANCE!

High Build Epoxy Fairing Primer may also be directly applied to gelcoat and fiberglass lay-up. Gelcoat surfaces must be sanded with P80-P150. Fiberglass resin must be carefully ground with P36-P60 profile, the surface must be dulled, with no shiny spots, or adhesion may possibly be compromised.

High Build Epoxy Fairing Primer may be applied directly to bare wood that has been sanded smooth with P80-P100 grit. Best results are achieved in gelcoat, fiberglass and wood surfaces if they are first sealed with a single coat of Oceanair Epoxy Finishing Primer.

High Build Epoxy Fairing Primer must be sealed with OceanAir Epoxy Finishing Primer prior to application of topcoats.

## Mixing & Reduction Directions

Base and Converter must be thoroughly agitated before mixing. Mix by volume one part High Build Epoxy Fairing Primer with one part Converter to a smooth, homogenous mixture. Allow mixture to induct for 15 minutes.

Reduce/thin inducted mixture by 10-20% with PR106.

Example: 10 oz. Base : 10 oz. 50C302 : 4 oz. PR106= 20% reduction

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

## Application Directions

**Application Equipment**: Only Conventionally Atomized or Airless spray are recommended.
Pressure fed equipment will be required.

Fluid Nozzle and Needle: Conventional- .110” orifice. HVLP- 2.0 mm orifice.

Pot Pressure: 15-25 PSI- Conventional and HVLP.

Atomization Pressure: 35-60 PSI- Conventional and HVLP.

Airless: Tip orifice- .043” / 60° fan.
Inlet Pressure- 40-70 PSI

Spray apply High Build Epoxy Fairing Primer in full, even coats of 8 to 10 mils wet film thickness each to yield 4 to 5 mils dry film thickness per coat. Two to three coats may be required to achieve an ideal dry film thickness of 12-15 mils.

## 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.

| HEALTH | 2 | FLAMMABILITY | 3 | REACTIVITY | 0 | PPE | I |
|---|---|---|---|---|---|---|---|

**Professional Use Only**



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