EP-PRIME 1000

Epoxy Primer

FEATURES

- Excellent Corrosion Protection
- For Marine Use
- Surface tolerant
- Cures at low temperatures
- Low VOC

RECOMMENDED USES

EP-PRIME 1000 is recommended for immersion service.

Recommended as a corrosion inhibiting, protective barrier coating for metal surfaces.

SPECIFICATION DATA

Coating Type	2- Part Epoxy Primer
Packaging	1 Gallon kit 0.80 gallon base 0.20 gallon converter
Mixing Ratio	4:1 by volume
Induction Time	15 minutes @77°F (25°C) & 50%R.H.
Colors Haze Gray	**E Paint Number** P1000-705
Thinner	Not recommended
Shelf Life	2 Years, unopened
Pot Life	5 hours @ 70°F (21°C) & 50%R.H.

Recommended Number of Coats
1 coat at 6-8 wet mils, let cure and apply a mist coat.

Recommended Film Thickness
6.0-12.0 wet mils to obtain 4.0-8.0 dry mils

Solids by Volume	68% ASTM D 2697
VOC	2.40 lbs./gal 290 g/L
Coverage	At 1 mil dry, 1091 sq.ft./gal (28.0m²L)
Application	Roll, brush or spray
Flash Point	100°F (38°C)
Dry Time	Dry-to-recoat in 5 hours Dry-Hard in 7 hours (at 70°F (21°C) & 50% R.H.)

Safety: See product label and Material Safety Data Sheet for safety and health data.

Manufactured by:
E Paint Company
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12/7/04

APPLICATION GUIDE

SURFACE PREPARATION

Surfaces must be clean, dry, free of oil, grease, release agents and curing compounds and must be structurally sound. Remove all loose and flaking paint and rust. All direct to metal coatings offer maximum performance over blasted surfaces.The standard for immersion service is SSPC-SP3 (SSI-St3).

New Surfaces

Bonding strength depends on proper preparation of the surface to be protected for long-term performance of the product. The substrate should be free of oil, grease and salt/chloride contamination. Specifications call for a white metal (NACE 1, SSPC SP5, Swedish Standards SA-3) cleanliness with a 2.5 mil (62.5 microns) anchor profile. Surface preparation should be no less than a near white (NACE 2, SSPC-SP10, Swedish SA 2 1/2) finish. Cleanliness is the most important step to produce a surface that will perform and last.

Previously Painted Surfaces

Old coatings should be tested for lifting. If lifting occurs, remove. Scuff by hand sanding glossy areas and aged epoxy. Clean aged epoxy or urethane coatings to remove contaminates. Prepare bare areas as specified under New Surfaces.

MIXING

EP-PRIME 1000 is a two component product.The entire contents of each container must be mixed together. Power mix EP-PRIME 1000 Part A Base Component to obtain a smooth homogenous mixture. After thoroughly mixing EP-PRIME 1000 Part A Base Component, add EP-PRIME 1000 Part B Converter Component slowly with continued agitation. Continue to mix combined components. Allow the material to stand for 15 minutes at 60-80°F(16-27°C) prior to use. Always stir prior to use.

APPLICATION

Spray is preferred for appearance and film build control. For air spray application, use a "MASTIC" gun, fluid tip of .070" or larger, and an air cap with good break-up. The fluid pressure should be kept low, with just enough air pressure to get good break-up of the coating. Where airless equipment is used, an airless spray pump capable of 3,000 psi (207bars) and .021" to .025" tip size will provide a good spray pattern. EP-PRIME 1000 may also be applied by brush of roller. Care should be taken that proper and uniform thicknesses are obtained. For roller work, use E Paint Company's Roller Kit EP-K1 or exact equivilent. Brushing or rolling may require multiple coats to achieve correct film thickness. Thinning is not recommended. Clean up with Xylene.

ANTIFOULING APPLICATION

Solvent Borne- Apply first coat of antifouling paint when EP-Prime 1000 is tack free but soft to finger pressure. If epoxy has cured too hard, apply an additional thin mist coat of epoxy primer within recommended recoat intervals and then apply antifouling as described above. **Waterborne-** Apply first coat of antifouling paint when EP-Prime 1000 is fully cured but within 24 hours. If outside 24 hours, abrade to a matte finish. Remove sanding dust and debris by cleaning with water. Apply first coat of antifouling paint as per the instructions contained in the Technical Data Sheet.

POT LIFE

Pot Life is 4.0 hours @ 70°F (21°C) & 50%R.H. If primer thickens, do not add thinner. Discard and start with fresh material. Higher temperatures will reduce working life of the coating. Lower temperatures will increase it.

CURE TIMES

Minimum Dry-to-recoat is 5 hours at 70°F (21°C) & 50% R.H. Minimum Dry-hard is 7 hours at 70°F (21°C) & 50% R.H**.** If temperature drops or relative humidity rises, increase dry times.

VENTILATION

Ventilation should be maintained throughout the entire cure period. It is very important for the safety of the applicator and the proper performance of EP-PRIME 1000 that good ventilation with dry fresh air be maintained in enclosed work areas. All solvent vapors must be removed in enclosed areas. Solvent vapors are heavier than air. Maintain ventilation at the lowest points in work area.