Tech Data

5000 Series Epoxy Primers (Black, White)

Products

5000	Epoxy Primer (Black)
5002	Epoxy Primer (White)
5001	Epoxy Activator

Application

Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover and wipe dry with a clean cloth. Apply three single wet coats of 5000 Series Epoxy Primer according to instructions on data sheet.

Surface Preparation, Prepainted Substrates

Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with wax & grease remover. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. For spot repairs, scuff sand area where primer will be applied. For overall refinishing, scuff sand the entire car with 320 grit sandpaper or fine scuff pad.

Mixing Directions

1 Part 5000 or 5002	Epoxy Primer
1 Part 5001	Epoxy Activator

Mixing Directions, Primer-Sealer

1 Part 5000 or 5002	Epoxy Primer
1 Part 5001	Epoxy Activator
≤50% Quality Reducer	Urethane Grade Reducer

Application

Use conventional spray or airless. Relative humidity should be below 85% min cure temperature 40ºF.
Adjust air pressure at the gun to 30-45 psi for siphon feed guns. Use less pressure to minimize over spray on small jobs. Apply 2-3 medium wet coats at a gun distance of 8 -12 inches as needed to fill voids and block sand with 180 to 280 grit treated sandpaper. Allow 10 to 20 minutes flash time between coats. Recoat times will vary with temperature, air movement and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system. Finish sand repaired area with 320 grit sandpaper using a DA Sander or hand sand.

Application, Sealer

Adjust air pressure at the gun to 30-45 psi for siphon feed gun. Use less pressure to minimize over spray on small jobs. Apply 1 or 2 wet coats at a gun distance of 8-12 inches. Allow 30 minutes flash time before top coating. Recoat time will vary with temperature, air movements and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system.

Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature.
Excessive film thicknesses, low temperature and poor air movement will retard dry times.

Air Dry	High Build	Sealer
Dust Free	15-20 min	10-15 min
Tack Free	25-30 min	15-20 min
To Topcoat	1.5-2 hours	45-1 hour

Technical Data

Weight Solids	
Ready to Spray, High Build	45%
Ready to Spray, Sealer	37%
Volume Solids	
Ready to spray, High Build	30%
Ready to spray, Sealer	25%
VOC @ Gun, High Build	4.8 lbs/gal
VOC @ Gun, Sealer	5.2 lbs/gal

Mixing Ratio, High Build	1:1
Mixing Ratio, Sealer	1:1:50%
Pot Life	6 to 8 hours
Viscosity @ Gun	20-40 #2 Zahn
Recommended Film Thickness	1.5-2.5 mil
Flash Point	77°F TCC
Air Pressure @ Gun	45-50 psi