

EPOX-PRIME & SEAL

PRODUCT FEATURES

- Compatible with a wide range of topcoats
- Lead and Chromium Free
- Excellent adhesion over most substrates
- May be used on most plastics



AVAILABILITY

Epoxy (Part A)	Unit	Per Case	Catalyst (Part B)	Unit	Per Case
APR-1231-1 Gray	GAL	2	BPR-1230-1 Catalyst	GAL	2
APR-1231-4 Gray	QT	6	BPR-1230-4 Catalyst	QT	4
APR-1232-1 Black	GAL	2			
APR-1232-4 Black	QT	6			
APR-1233-1 White	GAL	2			
APR-1233-4 White	QT	6			

PHYSICAL PROPERTIES

Pot Life	8 hours	Flash Point	54°F
Induction Time	None	Weight Solids (RTS)	41.77 %
Dry Film Build	1 to 1.5 mils per coat	Theoretical Coverage (RTS) @ 1 mil	428.79 sq ft
Sprayable Viscosity	24-28 sec. Zahn #2 Cup	Adhesion Over Bare Metal	Rated
VOC	<3.9 lb/gallon 467.3 g/l	304 grade Stainless Steel	5B (after 24hrs)
Color Holdout	Excellent		
Inter Coat Adhesion	Excellent		
Reparability Catalyzed	Excellent		

Caution: 304 Stainless Steel is “food grade” There are over 50 different grades of stainless steel and this product will not have the same adhesion over all grades of stainless steel. The epoxy must be allowed to dry for 24 hours before it reaches a 5B rating.

Warning: Not compliant in states such as California where low VOC regulations are in place.

DTM EPOXY PRIMER

SURFACE PREPARATION



- Wash surfaces with a mild detergent in warm water. Rinse well and wipe dry with a clean, dry cloth.
- Wipe vehicle with AXIS WATER BASED PRE-CLEAN, using generous amounts and changing rags frequently prior to painting.

BARE METAL

- Sand area as necessary to remove any rust or corrosion, repair all body damage.

PRE-PAINTED SURFACES

- Sand vehicle with 320P grit or finer D.A. or hand sand with 400P grit or finer wet or dry sandpaper and repair all body damage.

APPLICATION



Apply 1 to 2 medium wet coats allowing 10 to 15 minutes flash time between coats - Film Build is approximately 1 to 1.5 mils per coat (dry film build).

- After allowing the epoxy to properly dry, topcoat with acrylic or synthetic enamel, basecoat (solvent or waterborne) or single stage acrylic urethane.
- If the epoxy has cured for more than 24 hours, scuff the surface before priming or topcoating.
- If filling capabilities are required, prime with VERSAPRIME 2K primer surfacer.

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure.

TIPS OF THE TRADE

- It can be used “under” for adhesion to various substrates.
- It can be used “over” as a Sealer (1:1:½)
- It can be used in hot weather without dusting by adding Super Flow Solvent (1:1:½)
- Use Moderate SUPER-FLOW @ 75°F or Hot Weather SUPER-FLOW @ 85°F.
- Topcoat after 30 min up to 24 hours dry (without sanding)
- For maximum adhesion, after 24 hours dry, scuff with a red pad and apply 1 coat of Epoxy at the 1: 1 ½ ratio.

DRY TIMES



Air Dry @ 70°F

Flash 10 to 15 minutes between coats

As a Primer 4 to 6 hours

As a Non-Sanding 30 minutes

Sealer

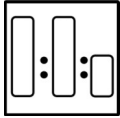
Note: All tests are performed at 70°F, higher or lower temperatures will affect the performance of this product.

Forced Dry

Purge for 10 minutes, bake @ 140°F for 30 minutes.

Allow substrate to cool down to room temperature before sanding and topcoating.

MIX RATIO (As a Sealer)



- | | | |
|------------|------------------|------------------------------------|
| 1 | Parts
Epoxy | CATALYST |
| 1 | Part
Catalyst | Catalyst |
| 1/2 | Part
Reducer | SUPER FLOW Series Urethane Reducer |

Note

1. Will not fill sand scratches coarser than P220.
2. Add 2 ounces of ASC-0210-4 Universal Retarder Solvent per 32 ounces of ready-to-spray Epox-Prime & Seal to improve flow in hot weather.

SPRAY GUN SETUP



HVLP Primer Gun 1.5 to 1.8 mm 7 to 10 PSI

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish, improper adjustment may cause paint defects such as orange peel, runs, sags, poor drying and poor adhesion.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

PRODUCT SAFETY INFORMATION

Before using any AXIS Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.