

EPOXY PRIMER 2.1

PRODUCT FEATURES

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



SUBSTRATES

Properly sanded and treated:

- Steel
- Stainless Steel
- Some Plastics
- OEM Finishes
- Fiberglass
- Aluminum
- Body Filler

AVAILABILITY

Epoxy 2.1 (Part A)		Unit	Per Case	Catalyst (Part B)		Unit	Per Case
APR-2259-1	Gray	GAL	2	BPR-2250-1	Catalyst	GAL	2
APR-2259-4	Gray	QT	6	BPR-2250-4	Catalyst	QT	4

PHYSICAL PROPERTIES

Pot Life	4 hours	Weight Solids (RTS)	41.77 %
Flash Point	40° F	Induction Time	None
Recommended Dry Film Build	1 to 3 mils	Theoretical Coverage @ 1 mil (A+B)	428.79 sq ft
Sprayable Viscosity (RTS)	15" to 18" #2 Zahn Cup	Color Holdout	Excellent
VOC (RTS)	≤ 2.1 (lb./gal)	Inter Coat Adhesion	Excellent
Humidity Resistant	Excellent	Reparability Catalyzed	Excellent

DRY TIMES



@ 70°F

Air Dry

Flash 10 to 15 minutes between coats

To Sand

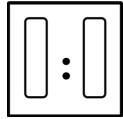
1 to 2 hours

To Topcoat

30 minutes

Note: All tests are performed at 70°F, higher temperatures will provide faster drying times.

MIX RATIO



- 1 Parts Epoxy EPOXY 2.1
- 1 Part Activator Catalyst

Note Add 2 ounces of ASC-0210-4 Universal Retarder Solvent per 32 ounces of ready-to-spray Epoxy 2.1 to improve flow in hot weather.

COLD SHOP CONDITIONS

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

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.3 to 1.4 mm	7 to 10 PSI
Conventional	1.3 to 1.4 mm	45 to 55 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.

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 ASC-0165-1 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. When spraying over ALUMINUM or STAINLESS STEEL, sand bare metal with 80 grit D.A. paper then clean with PRE-CLEAN.

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 waterbased) 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 SUPERBUILD 2.1 2K primer surfacer.

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.