

POLYAMIDE EPOXY PRIMER

VEHICLE TYPE	Epoxy resins and polyamide curing agents.
PIGMENT TYPE	Chemically resistant pigments.
SOLVENT TYPE	Aliphatic and aromatic hydrocarbons, alcohol, glycol ether
FLASHPOINT, MINIMUM	99°F. PMCC
SOLIDS BY VOLUME	59%
RECOMMENDED DRY FILM (per coat)	Primers - 3.0-4.0 mils; Topcoats - 2.0-3.0 mils
COVERAGE (THEORETICAL)	940 square feet per gallon @ 1 dry mil. The actual coverage will be less, depending on application technique, job conditions and type of surface to be coated.
VISCOSITY AT 75°F.	Primers - 75-85 Krebs Units; Topcoats - 67-77 Krebs Units
AVERAGE DRY TIME AT 75°F	To touch - 6 hours. Recoat - 16 HOURS.
RECOMMENDED THINNER	N-Butyl Alcohol
VOC (Volatile Organic Compounds)	345 grams/liter as mixed
RESISTANCE TO	Heat - to 200°F sustained, 250°F. Intermittent. With light colors some change of color is to be expected with elevated temperature exposure. Weather - Excellent, Alkali - Very Good Moisture - Excellent, Adhesion to steel - Excellent Acid - Good
APPLICATION	May be applied with airless spray equipment, brush, or roller. Care should be taken to achieve required film build. CONVENTIONAL SPRAY: DeVilbiss MBC-510 Spray Gun, "E" Fluid Tip, #704, #765 or #78 Air Cap, Binks #18 Spray Gun, 66 Tip, 66 PE or 63 PB Nozzle. AIRLESS SPRAY: Use of spray tips with .015" to .021" orifice is suggested, depending on available pressure and job conditions, with a minimum of 2800 psi tip pressure.

POTLIFE 4 hours at 75°F.

CAUTION For best results apply when surface temperature is above 50°F. , and a minimum of 5°F. above the dewpoint, and relative humidity is no greater than 85%.

PACKAGE A two-component material with base and curing agent supplied in separate packages. Mix ratio is equal volumes.

GENERAL:

These products have been formulated to meet the specific composition and performance requirements of Federal Specifications MIL-P24441. Applied directly to bare, properly prepared steel, usually in a three-coat primer/topcoat system. Also use over zinc-rich primers, either as finish coats, or as a barrier coat for conventional finishes. Used for severe service and marine exposures, also for sustained immersion.

PREPARATION:

All surfaces to be coated must be dry, and cleaned free of rust, oils, dirt, soil, and other contaminants. For general use steel should be blast cleaned to a minimum of "Commercial Grade, SSPC SP-6". For severe service and sustained immersion, "Near-White" SSPC SP-10 is recommended. Galvanized metals should be abraded after normal cleaning and preparation to provide a surface profile.

SAFETY:

Improper handling and use may be hazardous. Recommended safety precautions for storage, handling, and application must be observed.

NOTICE:

This product is for industrial use only and is not intended or suitable for use in or around a household or dwelling.

SAFETY INFORMATION

DANGER: Causes eye burns and skin irritation. Flammable. Vapor harmful. May cause allergic skin reaction. Contains amine compound, epoxy resin and organic solvent. Do not get in eyes, on skin or clothing. Wear eye and skin protective equipment when handling. Keep away from heat, sparks, and flame. Avoid breathing vapor or mist. Wash thoroughly after handling. Wear appropriate, properly fitted respirator (NIOSH/MSHA approved) during and after application unless air monitoring demonstrates that vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Keep container closed. Where products contain lead, do not use in dwellings or on surfaces accessible to children. Keep out of reach of children. **FIRST AID:** In case of eye contact, immediately flush eyes with plenty of water for at least 15 minutes. Call a physician. For skin contact, flush with water and wash with soap and water. Remove contaminated clothing and launder before reuse. Discard shoes if material has penetrated to inside surface. If inhaled, remove to fresh air. If not breathing give artificial respiration, preferably mouth-to-mouth, and call a physician. **NOTICE:** Reports have associated repeated and prolonged occupational overexposure to solvents with permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents may be harmful or fatal.

NOTE: Some slight change in product constants and characteristics may occur as solvent content is adjusted to conform with current Architectural Air Pollution Regulations. If thinning product for application, it must comply with applicable VOC regulations after thinning. The furnishing of the information contained herein does not constitute a representation by *General Coatings Manufacturing Corp.* that any product or process is free from patent infringement claims of any third party nor does it constitute the granting of a license under any patent of *General Coatings Manufacturing Corp.* or any third party. *General Coatings Manufacturing Corp.* assumes no liability for any infringement which may arise out of the use of the product. *General Coatings Manufacturing Corp.* warrants that its products meet the specifications which it sets for them. *General Coatings Manufacturing Corp.* **DISCLAIMS ALL OTHER WARRANTIES** relating to the products, and **DISCLAIMS ALL WARRANTIES RELATING TO THEIR APPLICATION**, express or implied, **INCLUDING** but not limited to warranties of **MERCHANTABILITY** and **FITNESS** for particular purpose. Receipt of products from *General Coatings Manufacturing Corp.* constitutes acceptance of the terms of this Warranty, contrary provisions of purchase orders notwithstanding. In the event that *General Coatings Manufacturing Corp.* finds that products delivered are off specification, *General Coatings Manufacturing Corp.* will, at its sole discretion, either replace the products or refund the purchase price thereof, and *General Coatings Manufacturing Corp.* will under no circumstances be liable for consequential damages, except insofar as liability is mandated by law. *General Coatings Manufacturing Corp.* will deliver products at agreed times insofar as it is reasonably able to do so, but *General Coatings Manufacturing Corp.* shall not be liable for failure to deliver on time when the failure is beyond its reasonable control.

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