

EPOXY PRIMER

1:1

Product Numbers:

#6600- White

#6610- Gray

#6620- Black

#6700- Activator

Available in quarts and gallons

Gun Tip: 1.4 or 1.5

1.4 if used as a sealer

Mix:

1:1 or 1 part SPI Epoxy to 1 part SPI Epoxy activator. This epoxy needs no induction time, unless you reduce this epoxy with urethane reducer. If reduced an induction period of 15-30 minutes is recommended.

Although this epoxy does not require an induction period unless you add urethane reducer, we strongly recommend you activate the epoxy by first stirring very well and then allowing it set 10-30 minutes. Stir once again before spraying and the longer in between coats the better.

Uses for SPI Epoxy:

This epoxy is one of the finest available and it is great for use on any type of metal or aluminum if properly cleaned. This epoxy eliminates the need for an acid-etch primer. Use this epoxy on bare fiberglass or SMC before applying body fillers or 2K primers for best long-term results.

Prepping the Surface:

Metal or Aluminum must be clean of all rust and oils and any films. Never clean metal with lacquer thinner or reducers of any kind. Raw metal of any type is always cleaned best with a waterborne wax and grease remover such as SPI's part # 700-1. This is most important for prepping aluminum and sand aluminum or metals with 80 grit DA paper.

Spraying:

Spray two wet coats for normal applications. For special projects such as restorations spray one coat and let it flash about 10-30 minutes at 70° degrees or higher. Then spray second coat for maximum corrosion protection. If one coat of epoxy is used wait 60 minutes before painting.

Spraying Continued....

This epoxy does not need to be sanded if painted over within 7 days. Always paint or primer over the epoxy within 7 days. After 7 days the epoxy should be sanded and re-coated with epoxy for best adhesion.

Body Fillers:

On any restoration it is always best to apply the body filler over the epoxy rather than bare metal for best adhesion and corrosion protection. If one coat of epoxy is used then the body filler can be applied in 60 minutes. When applying two coats of epoxy, wait over night before applying the body filler. The epoxy does not need to be sanded before applying the body filler.

Wet and Dry Sanding:

If for some reason you need to sand a large area of epoxy, the epoxy will dry sand best after 12 to 16 hours. Wet sanding with moderate pressure can be done after 60+ minutes.

To use as a Paint Sealer:

To use the epoxy as paint sealer, reduce 10-50% with the proper temperature range urethane reducer (this is very important). Spray one wet coat ONLY, let it set 60 minutes and apply paint. For sealing of a potential problem paint job, apply two coats of epoxy with proper flash times between coats and let it set over night before painting.

Pot Life:

24-48 hours depending on humidity and temperature (sealed container)

V.O.C.

4.6 ready to spray.

Precautions:

NEVER use SPI Epoxy over a Soda Blasted vehicle, Acid Etch/Wash Primer, Rust Converter or other Metal Treatments. NEVER!

Cold Weather:

In cold shop conditions this primer can go dormant. Try to keep heat on car for four hours after spraying with a minimum metal temperature of 60° F. Also, when cold it will help to mix primer and let it induce 60 minutes before spraying. Application of any epoxy in cold weather can destroy a paint job. **If you have any questions regarding the application of SPI Epoxy in cold weather please call us first. Metal temperature when you spray is critical and must be at least 60 degrees!**

