Mixing

- Products mix 1 part Epoxy to 1 part Activator by volume.
- Always mix product by volume, not weight.
- Scrape the bottom of the Epoxy can with the mixing stick to lift any product that may have settled back into suspension.
- The Activator is good for up to 1 year after opening.
- Epoxy Activator darkens over time, this is normal.
- To use as a sealer, the already mixed product can be reduced by up to 50%.
- Induction is not required but inducing at least 30 minutes is recommended.
- Always strain the product into the gun cup.

Surface Prep

- Bare metal - sand with 80 grit followed with waterborne WGR.
- Aluminum - sand with 80-180 grit, cleaned with waterborne WGR, and 1st coat of epoxy applied the same day to avoid oxidation.
- Fiberglass / SMC – sand with 80 grit followed with waterborne WGR, if strands are showing wait overnight and epoxy.
- E-Coat – if it wipes off with reducer then remove it completely. Otherwise, sand with 180 to 320 grit followed with waterborne WGR.
- Media blasted metal – if a rust inhibitor is applied ask the blaster how to neutralize it. Make a quick pass with a DA and 80 grit to add sand scratches and knock down any sharp edges followed by waterborne WGR.
- Do not apply over acid-etch primer.
- When cleaning with Waterborne WGR always use the appropriate shop towels, microfiber cloths can break down and cause contamination.

Surface Repairs

- Any structural repairs such as panel bond, fiberglass-filled fillers, or welding should be made before epoxy.
- Body filler work and seam sealer is recommended to be applied over the epoxy.

continued

Product Application

- The epoxy, metal / substrate, and shop temperatures need to be kept 65 degrees or above for 24 hours during and after application. Otherwise, do not apply the product.
- Use a 1.3 to 1.5 fluid tip at 2-2.5 turns out on fluid as a starting point.
- Set gun pressure with trigger pulled to about 26 psi as a good average.
- Spray the product like a basecoat, not a build primer. Spray even wet coats, do not spray for full coverage on the first coat.
- If you see cratering on the first coat you are spraying too heavy, too close or too much air pressure. This is most critical on the first coat.
- Allow 30 minutes between coats.
- If brushed or rolled on allow 2 or more hours between coats.
- If you are using the epoxy as the final coat and want a flatter sheen, apply two coats at 1:1, wait 24hrs and spray a final coat with up to 50% SPI 860 Fast Reducer. Spray only one reduced coat. Adding 30% SPI Fast Reducer is common to achieve flat. It will flatten as it cures.

Next Steps

- If the epoxy was applied as a sealer, then it would need to be painted within 2-24 hours. Scuff after 24 hours.
- You can base directly over the epoxy at 1:1 after a minimum of 4 hours up to 48 hours. Scuff after 48 hours.
- You can lightly sand the epoxy after 4 hours, but it will sand the best after 12-16 hours.
- The epoxy can be sanded wet or dry.
- You can apply 2K primer over epoxy up to 7 days, after that the epoxy should be scuffed with 180-320 grit first.
- Clean the epoxy and any filler work with 710 Solvent WGR. Waterborne WGR can be used but will need a much longer flash time.
- Wait 48 hours when top-coating with a bedliner, undercoating, clear coat, latex or 1k product.
- Wait 48 hours if using a polyester primer.
- Wait 48 hours or more if applying a vinyl wrap.