



2K EPOXY PRIME-N-SEAL



DESCRIPTION

2K EPOXY PRIME-N-SEAL is an excellent corrosion-resistant primer that offers optimum adhesion and superior hide to many types of properly prepared metal, aluminum, fiberglass and plastic filling materials. 2K EPOXY PRIME-N-SEAL is easy to sand and topcoat with all current base coats. 2K EPOXY PRIME-N-SEAL is chromate-free.

ADVANTAGES

Excellent hide and adhesion
Corrosion-resistant
Isocyanate-free
Chromate-free
Easy to sand
Can be applied direct to metal

PRODUCT NUMBERS

PART A: **6711 GRAY, 6713 CHARCOAL**
PART B: **6796 CATALYST**

DIRECTION FOR USE

SURFACE PREPERATION

Prior to application, the surface must be dry, clean and free from wax, grease, oil, rust, dirt or any other foreign matter. Use PCL 2040 NOVOC® Compliant Universal Solvent or PCL 8007 Compliant Cleaning Solvent on unpainted surfaces or PCL 271 Aero Prep Surface Cleaner for painted surfaces. Sand and featheredge original finish with 220 or 320 wet or dry sandpaper.



MIXING

2K Epoxy Prime-N-Seal is a two-component product consisting of 2K Epoxy Prime-N-Seal Part A and Part B 6796 Catalyst. The proper mixing ratio is 2:1.

IMPORTANT! 2K Epoxy Prime-N-Seal Part A must be mixed with 2K Epoxy Prime-N-Seal Part B Catalyst before the product can be used. Any mixture of Part A and Part B Catalyst will have the hazards of all components. Before opening the packages, **READ ALL WARNINGS ON THE LABELS. OBSERVE ALL APPLICABLE PRECAUTIONS. MIX ONLY WHEN READY TO USE.**

MIX ONLY WHEN READY TO USE. Mix only enough material to be used in a 2 hour period. Always maintain the proper mixing ratio, two parts Part A to one part Part B Catalyst. In a separate and larger container, thoroughly stir Part A and slowly add Part B Catalyst until well mixed.

Pot Life: Pot life is approximately 12 hours at 70°F. Pot life will shorten at higher temperatures and/or in larger quantities.

THINNING

No thinning is required.



APPLICATION

Spray one medium wet coat. For maximum corrosion resistance, apply two medium coats. Do not apply more than 3 medium coats.



DRY TIMES

SANDING: 6711 GRAY, 6713 CHARCOAL 2K EPOXY PRIME-N-SEAL may be recoated at any stage of cure. It can be topcoated within 48 hours air dry without sanding. If 6711 GRAY, 6713 CHARCOAL 2K EPOXY PRIME-N-SEAL is baked it must be sanded with P400-P600 before topcoating.

AIR DRY: To topcoat: 30-60 minutes at 70-80°F (21-27°C)
 For one coat, time to topcoat is 30-40 minutes. For two coats of primer, increase dry time to topcoat to 60 minutes.



PHYSICAL PROPERTIES

All Values Ready To Spray

6711 GRAY, or 6713 CHARCOAL	6711 Gray 2:1	6713 Charcoal 2:1
Max. VOC (LE)	182 g/L (1.5 lbs./gal)	182 g/L (1.5 lbs./gal)
Max. VOC (AP)	83 g/L (0.7 lbs./gal)	81 g/L (0.7 lbs./gal)
Avg. Gal. Wt.:	1425 g/L (11.89 lbs./gal)	1421 g/L (11.86 lbs./gal)
Avg. Wt. Volatiles:	50.5 %	51.5 %
Avg. Wt. Exempt Solvent:	44.6 %	45.8 %
Avg. Wt. Water:	0.0 %	0.0 %
Avg. Vol. Exempt Solvent:	54.2 %	55.2 %
Avg. Vol. Water:	0.0 %	0.0 %
Theoretical Coverage:	575 ft ² at 1 mil	562 ft ² at 1 mil
Recommended Dry Film Thickness:	2.0 to 2.5 mils	2.0 to 2.5 mils
Flash Point: See SDS/MSDS		

VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS/MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: October 2018