



Tech Data Sheet

84XX Epoxy Primer

A traditional Epoxy Primer offering superior flexibility and adhesion to virtually all substrates. Has excellent corrosion protection.

Products

8404	Epoxy Primer – Black, quart
8414	Epoxy Primer – White, quart
8424	Epoxy Primer – Gray, quart
8434	Epoxy Primer – Red, quart
8444	Epoxy Primer Activator, quart

Application

Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover and wipe dry with a clean cloth. Apply three single wet coats of Epoxy Primer according to instructions on data sheet.

Surface Preparation, Prepainted Substrates

Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with a good grade wax and grease remover. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. For spot repairs, scuff sand area where primer will be applied. For overall refinishing, scuff sand the entire car with 320 grit sandpaper or fine scuff pad.

Mixing Directions

1 Part 8404, 8414, 8424, 8434	Epoxy Primer
1 Part 8444	Epoxy Activator
≤25% Reducer	Universal Reducer

Application

Use conventional spray or airless. Relative humidity should be below 85% with a minimum cure temperature of 40°F.

Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature. Excessive film thicknesses, low temperature and poor air movement will retard dry times.

Tack Free	1 hour
Recoat	6 hours

Pot Life

Six hours at 60-70F.

Technical Data

Weight Solids (Package): 60%	Mixing Ratio: 1:1
Volume Solids (Package): 54%	Pot Life: 6 hours
Induction Time: 10 min	Viscosity: 75 ± 2 KU
Max Temperature: 250°F	Recommended Film Thickness: 2.0 to 3.0 mil
Flash Point: 80°F TCC	Coverage @ 1 mil: 752 sq ft/gal
Gloss: Flat	Air Pressure @ Gun: 45-50 psi