

# EPOXY PRIMER

**Gun Tip: 1.4 or 1.5**

**As a reduced sealer use a 1.3 or 1.4**

## **Product Numbers:**

#6600- White

#6610- Gray

#6620- Black

#6700- Activator

Available in quarts and gallons

## **V.O.C.**

2.1 VOC Ready to Spray

## **Mix:**

1:1 or 1 part SPI Epoxy to 1 part SPI Epoxy Activator. This epoxy doesn't need an induction time unless you reduce this epoxy with urethane reducer. If reduced an induction period of 15-30 minutes is recommended.

Although this epoxy doesn't 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 you wait between spraying your coats of epoxy the better.

## **Uses for SPI Epoxy:**

SPI Epoxy is one of the finest available and it's great for use on any type of metal or aluminum if properly sanded and 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, oils and any films. **Never** clean metal with lacquer thinner, acetone or reducers of any kind. When prepping aluminum and metals for epoxy always sand aluminum or metals with 80 grit DA paper. **Clean bare metals or aluminum with SPI #700 Waterborne WGR then let it 30-60 minutes before applying SPI Epoxy!**

If you have any questions on how to prep any type of substrate please call our tech line before beginning.

## **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 top coating epoxy with other coatings such as basecoat.

For older corvettes such as early 70's and older 2-3 wet coats of epoxy will perform best. Any cleaning of the raw glass should be allowed to set 24 hours or longer before applying the epoxy. Apply one wet coat of epoxy and let it set 1-4 hours then spray a second coat. If a third coat is desired again wait 1-4 hours before applying the next coat.

This epoxy does not need to be sanded if it's 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's always best to apply the body filler over the epoxy rather than applying filler over 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 (up to 7 days).

If you choose to do the filler work over bare metal the epoxy can be sprayed over the sanded body filler.

## **Wet and Dry Sanding:**

If you need to sand a large area of epoxy, the epoxy will dry sand best after 12-16 hours. Wet sanding with moderate pressure can be done after about 2 hours, depending on the amount of epoxy applied and air and substrate temperatures.

## **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:**

48-92 hours depending on humidity and temperature (store in a sealed container)

### **Cold Weather:**

In cold shop conditions this primer can go dormant. Try to keep heat on car for four hours after spraying with a absolute minimum metal temperature of 60° F. Also, when it's 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!**

### **Precautions:**

**NEVER use SPI Epoxy over a Soda Blasted vehicle unless you call us first for proper neutralizing instructions.**

**NEVER use SPI Epoxy over Acid Etch/Wash Primers or Rust Converters.**

**Acid treatments should not be used unless you know the proper way to neutralize them, again call us first to be safe but we strongly recommend against them.**

**If not handled properly the aforementioned issues can destroy a paint job and will result in an expensive mistake.**