Epoxy Primer

2.1 VOC

Product Numbers:

6600-1 White (gallon)	6600-4 White (quart)
6610-1 Gray (gallon)	6610-4 Gray (quart)
6620-1 Black (gallon)	6620-4 Black (quart)
6630-1 Red Oxide (gallon)	6630-4 Red Oxide (quart)
6640-1 Sandstone (gallon)	6640-4 Sandstone (quart)
6650-1 Olive (gallon)	6650-4 Olive (quart)
6700-1 Activator (gallon)	6700-4 Activator (quart)

SPI Epoxy Primer is one of the finest available and great for use on any type of metal 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.

Mixing: 1:1

Mix 1 part Epoxy Primer to 1 part Epoxy Activator.

30 minutes of induction is recommended but not required.

4 hours of induction needed for maximum UV holdout if black epoxy is to be left uncoated.

If reducing the epoxy, induce it for at least 30 minutes.

When you first open the epoxy primer, it is VERY important to make sure that all settling on the bottom of the can is mixed up very well with a paint stick. If not mixed properly, you can destroy the epoxy. Paint shakers **DO NOT** perform well with settled epoxy so always use a paint stick first, then move to a paint shaker.

We strongly recommend when you activate the epoxy to stir and mix very well before letting it sit/induce for 30 minutes. Stir once again before spraying and the longer you wait between spraying your coats of epoxy the better.

Pot Life:

72-120 hours depending on humidity and temperature (stored in a sealed container, never store in refrigerator)

Prepping the Surface:

When prepping for epoxy always sand with 80 grit DA paper for bare metal, sand with 180-320 for paint or primer. Remove any weld through primer. Metal must be clean of all rust, oils, and any films. **Never** clean metal with lacquer thinner, acetone or reducers of any kind. **Clean**

surface with SPI 700-1 Waterborne Wax and Grease Remover and let sit for 45-60 minutes before applying epoxy.

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

Body Fillers:

Seam sealers are typically used over epoxy. Fiberglass filled fillers or other structural products are used before epoxy primer.

On any restoration, it is **always best to apply the body filler over the epoxy** rather than applying filler over bare metal for best adhesion and corrosion protection. After applying two coats of epoxy wait overnight before applying the body filler. The epoxy does not need to be sanded before applying the body filler for up to 7 days if it does not go outside.

If time allows, it's always best to apply filler over the epoxy after it has set for 24-48 hours.

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

Spraying: **Gun tip recommendation 1.4 – 1.5. Use a base / clear gun.**

Remove any internal gun strainers. Spray two wet coats for normal applications. For special projects such as restorations, spray one coat and let it flash 30 minutes or longer at 70 degrees or higher. Then spray a second coat for maximum corrosion protection. For frames we recommend three coats to make sure you do not have any thin spots as frames tend to be tougher to spray. **You do not need to top-coat our epoxy on frames, wheel wells, firewalls, or suspension components.**

For older corvettes such as early 70's and older, 3 wet coats of epoxy will perform best. Any cleaning of the raw glass should be allowed to sit 24 hours or longer before applying the epoxy. Apply one wet coat of epoxy, let it sit 1-4 hours then spray a second coat. If a third coat is desired again wait 1-4 hours before applying the next coat. Base directly over epoxy after a minimum of 4 hours when mixed 1:1, it is recommended to wait overnight on restorations.

This epoxy does not need to be sanded if it is **primed** over within 7 days. Epoxy can be recoated up to 14 days later without sanding. Always primer over the epoxy within 7 days. After 7-14 days you can sand with 180 grit and apply filler or primer. After 14 days, sand the epoxy with 180 grit and re-apply the epoxy.

Polyester Primers:

Wait at least 48 hours before applying a polyester primer.

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 4 hours depending on the amount of epoxy applied, air temperature and substrate temperatures.

To use as a Paint Sealer:

To use this epoxy as a paint sealer, mix it 1:1 with activator and reduce 10-50% with the proper temperature range urethane reducer (this is very important), induce for 30 minutes and spray with your base/clear gun. Spray one wet coat ONLY, let it sit 2 hours then apply paint. For sealing of a potential problem paint job, apply two coats of epoxy with proper flash times between coats and let it sit overnight before painting. You may basecoat over Epoxy Primer reduced as a sealer from 2-24 hours without sanding. After 24 hours scuff with a gray scuff pad or equivalent first.

Cold Weather:

In cold shop conditions this primer can and will go dormant. Keep heat on the car for 24 hours after spraying with an absolute minimum metal temperature of 65 degrees. Also, when it's cold it will help to mix the primer and let it induce 60 minutes before spraying. Application of any epoxy in cold weather can destroy a paint job. There is no way to accelerate the curing process.

Bottom line is if the car metal or primer contents cannot be kept at 65 degrees or higher as well as the shop temperature for the next 24 hours after spraying, **DO NOT** spray our epoxy as you may end up having to redo all your hard work.

Also, temperature of the epoxy in the can is just as important so store the epoxy in a warm place for at least 24 hours before spraying.

For $20 you can buy a laser temperature gun to take readings of the can and the car panels, and this will save you from guessing.

Once again if you have any questions regarding the application of SPI Epoxy Primer in cold weather please call us first. Metal temperature when you spray epoxy is critical and must be at least 65 degrees as well as the contents of the epoxy and activator cans!