

TotalBoat 2-Part Clear Epoxy Primer - Tech Data Sheet

SUPPORT PRODUCTS:

Required Products: TotalBoat 2-Part Epoxy Primer Surfacing Activator, TotalBoat 2-Part Epoxy Primer Clear Base

Reducer: TotalBoat Epoxy Primer Thinner 200

Cleanup: TotalBoat Epoxy Primer Thinner 200

Associated Products: TotalBoat 2-Part Epoxy High Build Activator, TotalBoat 2-Part Epoxy Primer Gray and White Bases

COMPATIBLE SUBSTRATES:

Fiberglass, Carbon Fiber, Yes

Kevlar®:

Previously Painted Yes, if in good condition. Otherwise, remove any previous coatings.

Surfaces:

SURFACE PREPARATION:

FIBERGLASS, CARBON Abrade the surface with 150-180 grit sandpaper. Wipe away any surface contamination with a clean, dry,

FIBER, KEVLAR: lint-free cotton rag wetted with TotalBoat Epoxy Primer Thinner 200. Follow with a clean, dry, lint-free rag to ensure no contaminants were spread or left behind. Wipe the surface clean with a clean, lint-free cotton rag wetted with Epoxy Primer Thinner 200, then wipe dry with a dry, clean, lint-free rag before application.

PREVIOUSLY PAINTED Remove any paint or coating in poor condition. Sand smooth with 220- or 320-grit sandpaper and remove any sanding residue. Wipe the surface clean with a clean, lint-free cotton rag wetted with Epoxy Primer Thinner 200, then wipe dry with a dry, clean, lint-free cotton rag before application.

MIXING:

- 1 Prior to mixing, thoroughly shake or stir TotalBoat 2-Part Clear Epoxy Primer Base and TotalBoat 2-Part Epoxy Primer Surfacing Activator until each component has an even consistency.
- 2 Thoroughly mix 1 part TotalBoat 2-Part Clear Epoxy Primer Base with 1 part TotalBoat 2-Part Epoxy Primer Surfacing Activator by volume. Stir well for 2 minutes.
- 3 Allow an induction period of 30 minutes prior to application, or before adding any reducer.

APPLICATION:

Spray: After the induction period, for desired application and film thickness control, reduce up to 10% with TotalBoat Epoxy Primer Thinner 200. A 1.4-2mm tip is recommended for spray applications. Coats can be applied at 3-4 mils wet each. Subsequent coats can be applied after a minimum of one hour between coats. After application, wait a minimum of 1 hour before overcoating with urethane coatings. If 2-Part Clear Epoxy Primer has not been overcoated in 7 days, sand lightly with 220- or 320-grit sandpaper before overcoating.

Brush/Roll: Thinning should not be needed, but if reduction is desired for flow, use TotalBoat Epoxy Primer Thinner 200. If rolling, use only 1/8" nap foam rollers that are epoxy/solvent safe. Subsequent coats can be applied after a minimum of one hour between coats. After application, wait a minimum of 1 hour before overcoating with urethane coatings. If 2-Part Clear Epoxy Primer has not been overcoated in 16 hours, sand lightly with 220- or 320-grit sandpaper before overcoating.

Sanding: For multiple coat applications, allow 16 hours to cure after the final coat, before sanding. For optimum topcoat appearance, use 220-grit or finer sandpaper when sanding.

APPLICATION DATA:

Application Method: Brush, Roll, or Spray

Number of Coats: 2-3

Film Thickness (per Coat): 3-4 mils wet

Pot Life: 8 Hours @ 72°F

Application Temperature: 45-125°F

Recommended Finish: Urethanes, clear urethanes, epoxy surfacing or high build primer

Induction Time: Induct for 30 minutes before reducing or application

Dry Time to Recoat: 1 hour to 7 days

Dry Time to Sand: 16 hours (<4 mils dry), 16-24 hours (>4 mils dry)

Shelf Life: 24 months (minimum)

PHYSICAL DATA:

Vehicle Type: Epoxy Resin

Components: Two

Finish: Semi-Gloss

Color: Clear

Mix Ratio (by Volume): 1:1 (1 part base to 1 part activator)

**Solids (by Volume) +/- 35% (Admixed)
2%:**

Flash Point: 80°F (Base), 64°F (Activator), 61°F (Reducer)

Theoretical Coverage 175-200 @ 3 mils dry
(sq ft/gal):

VOC (Admixed): < 510 g/L

Viscosity (Zahn #2): 14-16 (Admixed)

REVISION DATE: April 29, 2020

