

TotalBoat 2-Part Surfacing Epoxy Primer - Tech Data Sheet

SUPPORT PRODUCTS:

Required Products: TotalBoat 2-Part Epoxy Primer Surfacing Activator, TotalBoat 2-Part Epoxy Primer Base (Gray or Off White)
Reducer: TotalBoat Epoxy Primer Thinner 200, TotalBoat 2-Part Epoxy Primer Reducer
Cleanup: TotalBoat Epoxy Primer Thinner 200, TotalBoat 2-Part Epoxy Primer Reducer
Associated Products: TotalBoat 2-Part Epoxy Primer High Build Activator

COMPATIBLE SUBSTRATES:

Fiberglass: Yes
Metals: Yes, aluminum and steel
Wood: Yes

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

SURFACE PREPARATION:

FIBERGLASS: Abrade the surface with 100-150 grit sandpaper. Wipe away any surface contamination with a lint-free rag wetted with TotalBoat Epoxy Primer Thinner 200. Follow with a clean, dry, lint-free cotton rag to ensure no contaminants were spread or left behind. Ensure the surface has completely dried before applying primer.

WOOD: Abrade with 100-150 grit sandpaper. Wipe away any surface contamination with a lint-free rag wetted with TotalBoat Epoxy Primer Thinner 200. Follow with a clean, dry, lint-free cotton rag to ensure no contaminants were spread or left behind.

STEEL: Sandblast or grind to SSPC-6 Commercial Blast. Remove all sanding residue with a vacuum or air hose, and wipe the surface with a clean, dry, lint-free cotton rag wetted with TotalBoat Epoxy Primer Thinner 200. Ensure the surface has dried completely before applying primer.

ALUMINUM: Sandblast, grind, or sand the surface with 100-150 grit sandpaper. For best adhesion, use TotalBoat Aluminum Boat Etch Wash. If the etch wash is not used, remove all sanding residue with a vacuum or air hose, and wipe the surface with a clean, dry, lint-free cotton rag wetted with TotalBoat Epoxy Primer Thinner 200. Ensure the surface has dried completely before applying primer. Apply primer within 1 hour.

PREVIOUSLY PAINTED SUBSTRATES: Ensure that the substrate is a 2-component system. If it is a 1-part product, the solvents in this primer may break down the previously painted surface and it may not get a good bond. If no corrosion byproducts are present, abrade with 100-150 grit sandpaper to remove any surface gloss. Wipe any surface contamination away with a lint-free 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.

MIXING:

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

APPLICATION:

Spray: After the induction period, reduce 15-25% with TotalBoat Epoxy Primer Thinner 200 for desired application and film thickness control. Coats can be applied at 3-4 mils wet each, building up to 12 mils wet thickness, waiting 1-3 hours between coats. For single-coat application (3-4 mils wet), it can be sanded after 4 hours.

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 every 1-3 hours, up to 12 mils wet film thickness.

Sanding: A single-coat application can be sanded in 4 hours. For multiple-coat applications, allow 16 hours to cure after the final coat, before sanding. If possible, do not wait more than 24 hours to sand, especially with only one or two coats, as the primer will get increasingly harder. For optimum topcoat appearance, use 220-grit or finer sandpaper when sanding.

APPLICATION DATA:

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| Application Method: Brush, Roll, or Spray |
| Number of Coats: 1-3 |
| Film Thickness (per Coat): 3-4 mils wet |
| Pot Life: 8 hours @ 72°F |
| Application Temperature: 45-125°F |
| Recommended Finish: Urethanes |
| Induction Time: Induct for 30 minutes before reducing or application |
| Dry Time to Recoat: 1-3 hours |
| Dry Time to Sand: 4-16 hours (<4 mils dry), 16-24 hours (>4 mils dry) |
| Shelf Life: 24 months (minimum) |

PHYSICAL DATA:

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| Vehicle Type: Epoxy Resin |
| Components: Two |
| Finish: Semi-Gloss |
| Color: Off White or Gray |
| Mix Ratio (by Volume): 1:1 (1 part base to 1 part activator) |
| Solids (by Weight) +/- 51% (Admixed) 2%: |
| Flash Point: 80°F (Base), 64°F (Activator), 61°F (Reducer) |
| Theoretical Coverage 400 @ 2 mils dry (sq ft/gal): |
| VOC (Admixed): < 420 g/L |
| Viscosity (Ford #4): 45 +/-5" |

REVISION DATE: April 12, 2021

