

SELECTION & SPECIFICATION DATA

Generic Type	High performance, rust inhibitive, epoxy primer
Description	One of the most durable primers known to industry. Excellent application properties are experienced over steel surfaces. This primer has excellent adhesion to steel and concrete also.
Features	<ul style="list-style-type: none"> • Two component heavy duty primer • Good prime coat for high performance paint systems • Durable primer under insulation • Contains high performance rust inhibitors
Color	Red (0500)
Finish	Flat
Dry Film Thickness	1 - 2 mils (25 - 51 microns) single coat
Typical Uses	<p>This product is used as a base coating for high performance paint systems. It may be topcoated with Epoxies, Phenolics, Polyesters, Vinyl Esters and Polyurethanes. It is an excellent coating under insulated surfaces.</p> <p>Use this product thinned 50% with thinner TH 760 as a steel holding primer or as a base primer under a variety of tank lining systems.</p>
Solids Content	By Volume 43% +/- 2%
Theoretical Coverage Rate	<p>690 ft²/gal at 1.0 mils (16.9 m²/l at 25 microns) 345 ft²/gal at 2.0 mils (8.5 m²/l at 50 microns) Allow for loss in mixing and application.</p>
VOC Values	As Supplied : 3.95 lbs/gal (473 g/l)
Dry Temp. Resistance	Continuous: 225°F (107°C)
Temperature Resistance (Immersion)	175°F (79°C)
Topcoats	<p>Thin mil lining systems applied over this product include, polyester, vinyl ester, epoxy phenolics, epoxies and polyurethanes. Thick mil lining systems applied over this product include 100% solids epoxy, polyesters, and vinyl esters.</p> <p>Note: Topcoat within 3 – 5 days @ 77°F (25°C) to be assured of good adhesion.</p>

SUBSTRATES & SURFACE PREPARATION

General	Non Immersion Service and/or Moderate Services: Commercial Sandblast (SSPC-SP6-63) (Sa2)
Galvanized Steel	Acid etch with TH 950 or Sandblast
Aluminum	Acid etch with TH 950 or Sandblast
Immersion Service	Immersion and/or Severe Service: White Metal Sandblast (SSPC-SP5-63) (Sa3)

American EX Series Primer

PRODUCT DATA SHEET



MIXING & THINNING

- Mixing** | Mix 4 parts resin (Part A) to 1 part catalyst (Part B) by volume. Allow material to stand 30 minutes before thinning.
- Ratio** | 4:1 by volume
- Pot Life** | 6-8 hours @ 77°F (25°C)

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

General | Use Conventional Spray, Airless Spray, Brush, or Roller.

Conventional Spray | Spray Pot Dual Regulation Air Gauges for Pot Pressure and Atomization Pressure
Air Supply (in): 100 psi
Material Hose Diameter (ID): 1/2" (1.3 cm)
Material Hose Length: 50' (15 m)
Air Hose (ID): 5/16" (7.9 mm)
Fluid Pressure: 10-25 psi
Atomization Pressure: 50-75 psi
Fluid Tip Orifice Size: 0.071" (1.8 mm)

Airless Spray | Pump Ratio: 30:1
Air Supply (in): 100 psi
Hose Diameter (ID): 1/4" (0.64 cm)
Hose Length: 100' (30.5 m)
Tip Size: 0.013-0.019" (0.33-0.48 mm)
Atomization Pressure: 2,200 psi

APPLICATION CONDITIONS

Condition	Ambient
Minimum	50°F (10°C)

Do not apply if temperature is below 50°F (10°C) and/or above 85% relative humidity.

CURING SCHEDULE

Surface Temp.	Maximum Recoat	Dry to Touch	Firm	Dry to Topcoat
77°F (25°C)	30 Days	2 Hours	5 Hours	7 Hours

Curing Details | Catalytic cure

CLEANUP & SAFETY

Cleanup | Clean all equipment immediately with thinner TH 760. Thin as required. (Usually 10–15 %)

CLEANUP & SAFETY

Safety | Keep away from heat, sparks or flame. Vapors may cause flash fire. Use with adequate ventilation. Do not breathe vapors or spray mist. Wear an appropriate, properly fitted respirator during and after application unless air monitoring demonstrates vapor/mist levels are below applicable limits. Avoid contact with eyes, skin, and clothing. Wash thoroughly after handling.

WARNING! FLAMMABLE! HARMFUL IF INHALED. CAUSES IRRITATION

PACKAGING, HANDLING & STORAGE

Packaging | **One Gallon Kit**
Part A: 1 Gallon<nbr> Part B: 1 Quart
Five Gallons Kit
Part A: 5 Gallons<nbr> Part B: 1 Gallon

UN No. 1263

Shelf Life | 1 year

Shipping Weight (Approximate) | **One Gallon Kit:**
Part A: 11.5 lbs (5.2 kg)
Part B: 2 lbs (0.9 kg)
Five Gallon Kit:
Part A: 49 lbs (22.2 kg)
Part B: 8.5 lbs (3.9 kg)

Flash Point (Setaflash) | Part A: 69°F (20.5°C)
Part B: 45°F (7vC)

WARRANTY

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