

PRODUCT DATA SHEET

ENGINEERED BY:



2K EPOXY PRIMER
Solvent-Based
Field-applied Primer System
PRODUCT #: K-1022

2K EPOXY CORROSION RESISTANT PRIMER

PRODUCT DESCRIPTION:

2K Epoxy Corrosion Resistant Primer is a two component, high performance product used on metal and concrete outdoor building materials. The product is field-applied and most commonly used on structures in high humidity, UV, and corrosion-prone environments. The primer protects surfaces from harsh weather conditions, corrosion and provides excellent adhesion to the substrate as well as intercoat adhesion to our NeverFade® with Kynar® and Kynar Aquatec® topcoats.

The product is supplied in a two part kit and is formulated to be applied using standard contractor-grade HVLP equipment, brush or roller application. Reduce product with APV's Oxsol 100, as needed, to optimize sprayability. To activate the Part A, incorporate Part B (K-1023, 12.5% by weight) into the Part A container. Thoroughly mix the components. Apply the topcoat between 24-96 hours after application of the primer.



PHYSICAL PROPERTIES:

Product Description:	2K Epoxy Corrosion Resistant Primer
Product Number:	K-1022 + K-1023 KIT
Number of Components:	Two
Color:	Gray, other colors upon request
Type:	Solvent-Based
Viscosity:	85 +/- 10 KU (as supplied)
Weight per Gallon (ASTM D 1475-90):	12-14 lbs/gal
Flash Point:	0 °F (-17.8 °C)
Solids (Crosslinked):	70% by weight 68% by volume
VOC:	21 g/l
Recommended Film thickness:	4-5 mil (wet) 3 - 3.5 mil (dry)
Coverage:	270 - 370 sq ft/gal
Dry Time: (dependant on air temperature/humidity)	To touch: 4 hours Re-coat: 24 - 96 hours
Pot Life:	4 - 6 hours
Shelf Life:	12 Months Unopened
Freeze Caution:	Keep from freezing
Recommended Storage:	Cool, Dry, and Well Ventilated Storage

SUBSTRATES:

2K Epoxy Corrosion Resistant Primer is recommended for steel and concrete surfaces. Other substrates are acceptable, contact APV Engineered Coatings' Technical Department for approval and guidelines on application.

TINTED COLORS:

2K Epoxy Corrosion Resistant Primer can be tinted for hiding purposes under special request. Colors are custom matched to order.

PACKAGING:

2K Epoxy Corrosion Resistant Primer is ready-to-use as supplied in a pre-measured kit format. Packaging sizes include: 1 gallon cans and 5 gallon pails.

FEATURES:

Passes 3000 Hours of Salt Spray Exposure Testing
Exceptional Adhesion

Low VOC

Compatible with NeverFade(R) Topcoats

Flexible, Withstands Freeze-Thaw

Mold/Mildew Resistant

Adheres to a Variety of Surface Grades

Easy to Apply

Manufactured in the USA

SUBSTRATE PREPARATION:

Although APV's coating systems have been designed to apply over a wide variety of surface types, some substrates require additional preparation. Always consult your APV technical representative regarding each project. In all cases, the substrate must be properly prepared as defined in the instructions below and tested using the ASTM D3359 Standard Test Methods for Measuring Adhesion by Tape Test prior to coating the surface. Follow the guidelines on surface preparation and application thoroughly by referencing the **Field Coatings Guide**. Inadequate surface preparation and application can lead to coating failure and/or under-performance.

APPLICATION:

TEMPERATURE AND ENVIRONMENTAL FACTORS

Ambient air temperature is pertinent to coating performance and cure. Be sure to check that the air, surface, and material are between 55°-85°F and at least 5°F above the dew point. Avoid application if precipitation is expected within 24 hours and/or if air or surface temperature is expected to drop below 35°F within two days. Do not apply primer in direct sunlight as the flow, leveling and application characteristics will be adversely affected.

Wind Velocity | High wind velocity can severely impair spray application which can result in loss of materials, low film build, excessive dry spray or overspray. It is recommended to delay work until wind conditions are below 15 m.p.h.

Dust and Contamination | Work areas should be protected from conditions where dust and contamination are possible during the application and curing process. Dust and contaminants that settle on fresh applied coatings can impair the integrity of the coating leading to a shorter coating life and reduced performance. Please ensure your work area is free from dust and contaminants. If any previous coatings accumulate dust or contaminants, remove those before adding succeeding coats.

Mixing and Thinning | Primer should always be mixed thoroughly before use with an air mixer for 10-15 minutes. No reduction necessary for brush or roll application; however, small amounts of APV's Oxsol 100 can be added if needed to optimize viscosity for spray application.

Ventilation | Always use adequate ventilation and proper NIOSH approved respirator when applying NeverFade® topcoats and associated primer systems. Avoid breathing mist or sanding dust created by the application or surface preparation.

FILM THICKNESS AND SPREADING RATE

Theoretical spreading rates can be used as a rough guide for determining film thickness. However, to ensure proper film thickness, wet thickness readings should be taken at random locations immediately after application. A Nordson Wet Film Gauge or similar instrument may be used for this purpose.

Dry film thickness may be measure on ferrous metals using a magnetic gauge following the procedure outlined in SSPC-PA2, Sections IV, Paint Thickness Measurement. Readings should be taken in accordance with the specifications standards mentioned above.

Applying the appropriate film thickness is important to the performance characteristics of the coating. Be careful not to apply too heavy of a coat. Excessive paint on the surface may result in runs and sags as well as weak spots in the film. A heavy coat weight may also change the drying properties causing wrinkling or cracking, and adversely affect intercoat adhesion.

BRUSH, ROLL AND SPRAY APPLICATION

Primer can be applied with a brush, roller, or spray equipment. Products can be reduced as necessary for spray with APV's Oxsol 100.

Brush | Nylon/Polyester Brush

Roller | 3/8"-3/4" nap cover

Contentional, HVLP, Airless, & Air Assisted Airless | Consult an APV Equipment Specialist for recommendations on spray tips, caps, nozzles, fluid and air pressures.

CLEANUP INFORMATION:

Always observe good professional hygiene practices and wash hands thoroughly after using our products. Clean hands immediately after use with soap and water. Use water to thoroughly clean application equipment. This will keep the primer from curing onto the surfaces. Any cured or dried coating left on the equipment will have to be removed with standard grade paint thinner. After cleaning, flush spray equipment with water or a water/solvent blend.

CAUTIONS. It is necessary for the integrity of the job that contractors ensure all personnel are properly protected from hazards when coating, or blast cleaning. There are numerous OSHA standards that cite how, where, and when workers need to be protected. You should consult OSHA, local, and equipment officials before starting the job to ensure your complete compliance with the law to avoid any liability issues. Product labels, Product Data Sheets, and Safety Data Sheets should always be consulted prior to any coating operations, and safety and health details should be addressed prior to implementing these operations.

Always dispose of dry, empty containers in compliance with local or state regulatory codes. First Aid: In case of eye contact, flush with water for 15 minutes. In case of skin contact, wash with soapy and water. If you experience difficulty breathing, seek a fresh source of air. In all cases, if you continue to experience discomfort, seek medical attention immediately. All products are for professional use only. Do not take internally. Keep out of reach of children. **Refer to the Material Safety Data Sheet for safety instructions.**

WARNING! Removal of old paint may generate fumes and dust that contain lead. This may be a step in the surface preparation process outlined previously. Lead can cause serious health issues. For more information regarding the proper protective equipment, containment, and cleanup for the removal of lead based paints contact the **National Lead Information Center at 1.800.424.LEAD** or contact your local health authority.



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NOTE: The information and data given herein are based upon tests and reports considered reliable and are believed to be accurate. However, due to varied application and handling methods, no guarantee of duplicate performance, expressed or implied, is made.

*NeverFade® uses a specialized pigment system. Some colors may not incorporate this pigment system which, therefore, will not be covered under the warranty. APV will notify all customers if the chosen color falls outside of this system.

NeverFade® is a trademark belonging to APV Engineered Coatings, Inc. Sold under a trademark license from ARKEMA INC. which is the owner of the KYNAR and KYNAR AQUATEC Trademarks.