



### DESCRIPTION:

320/321 Epoxy is a very fast dry fast cure primer/sealer that has tremendous corrosion resistance and adhesion. This primer can be used on all properly prepared metals and plastics. Epoxy Primer can be topcoated with all topcoat finishes including acrylic lacquer. Epoxy Primer is an excellent sealer when reduced 25% with 162, 163 urethane reducer. When using as a sealer do not reduce with 161 Fast Urethane Reducer.

### PART NUMBERS:

#32001 Primer/Sealer (Gallon) #32104 Primer Catalyst (Quart)

### FEATURES:

1. May be topcoated in 30-60 minutes
2. Superior corrosion resistance in harsh environment
3. Superior humidity resistance
4. Excellent color holdout
5. Superior adhesion to bare steel, sanded fiberglass and etched or sanded aluminum
6. Tintable with 10% Acrylic Urethane & Acrylic Urethane Basecoat

### COMPATIBLE SURFACES:

1. Properly sanded or etched aluminum
2. Properly cleaned steel
3. Clean, deoxidized galvanized steel
4. Properly cleaned, sanded stainless steel
5. Clean, sanded fiberglass, SMC
6. All other primers
7. Automotive plastics except polyethylene

### SURFACE PREPARATION:

Thoroughly remove all wax, grease, oil, corrosion and dirt. All corrosion should be removed and metal prepared as for any paint application. Old finishes must be properly sanded and cleaned with 900 Final Wash (or equivalent). Aluminum must be thoroughly sanded or etched with Self-Etch before applying 320 Epoxy.

### TECHNICAL DATA:

Color (mixed):	Grey	Film Build:	1 mil DFT (1 coat)
Weight per gallon:	Primer 10.7 lbs./gallon Catalyst 7.10 lbs./gallon	Dry time to touch:	10-15 minutes
Coverage/gallon at 1 mil:	542 sq. ft	Color Holdout:	Excellent
Mix Ratio by volume:	2:1 High Build	Humidity Resistance:	Excellent
Induction time:	5 minutes	Salt Spray Resistance:	Excellent
Sprayable Viscosity:	19 sec. #2 Zahn	Pot Life:	8 hours minimum
Flash Point:	40 F TCC	Solids by weight (mixed):	52.7%
		Solids by volume (mixed):	33.8
		V.O.C.'s ready to spray:	4.7 lbs/gal or 570 g/l

### MIXING INSTRUCTIONS

#### MIXING INSTRUCTIONS: (PRIMER)

1. Mix 2 part 320 Epoxy Primer with 1 part 321 Catalyst.
2. Stir thoroughly after catalyzing and strain.

#### MIXING INSTRUCTIONS: (SEALER)

1. Mix same as primer then reduce 25% with mid-temp urethane grade reducer (162) or slower.

#### APPLICATION INSTRUCTIONS: (PRIMER)

1. Spray catalyzed primer at 40-50 P.S.I. air pressure.
2. Apply 1 to 2 wet coats. Allow 10 to 15 minutes dry time between coats. Dry film build should be .75 to 1.0 mil.
3. Allow thirty minutes to one hour dry time before topcoating. Thinner coats will reduce dry time before topcoating.

#### APPLICATION INSTRUCTIONS: (SEALER)

1. Reduced up to 25%, apply one full wet coat.
  2. Allow 30 minutes dry time before topcoating.
- \*\*Note\*\* If applied over lacquer products, all topcoats must be applied within the same workday to avoid lifting.**

#### CLEANING:

Use good quality lacquer thinner or urethane reducer (161/162/163) to thoroughly clean all equipment.

#### TOPCOATING:

1. 320 Epoxy Primer-Sealer can be topcoated with all finish coatings.

**\*\*Note\*\* The topcoat window of EP Epoxy Primer is 30 minutes to 24 hours. After 24 hours the primer must be scuffed or lightly sanded before topcoating. After 72 hours sand, re-apply EP and then topcoat.**