



TECHNICAL DATA SHEET

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HI-SOLIDS
LOW VOC EPOXY PRIMER
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PRODUCT DESCRIPTION:

A high solids, high-build, low VOC, two component, corrosion inhibiting, lead and chromate free epoxy primer. Meets air pollution requirements (Rule 102). TriCom's Hi-Solids low VOC Epoxy Primer is formulated for maximum corrosion resistance. It may be top-coated with polyurethane or epoxy topcoats.

TYPICAL PROPERTIES:

- COLORS**..... Gray
- TOTAL VOLUME SOLIDS**.....56% Minimum
- SHELF LIFE**..... 1 Year From Date of Mfg.
- POT LIFE**..... 6-8 Hours (77 Degrees F.)
- DRYING TIME:**
 - Set-To-Touch..... Within 60 Minutes*
 - Dry Hard..... Within 4 Hours*
 - Dry Through..... Within 8 Hours*
 - Full Cure.....Within 7 Days*
- Thinner**..... MIL-T-81772B Ty.II
- Gloss Values:**
 - Flat..... 10-30%
- VISCOSITY:**
 - After Thinning..... Max 63-73 KU's (admixed material)
- VOLATILE ORGANIC COMPOUNDS:**
 - Max "VOC"..... 300 grams/liter (2.52 pounds/gallon)

*Dry times will vary depending on gloss, ambient and substrate temperature, and film thickness.
**Hi-film thickness and/or low temperatures or ventilation will result in solvent entrapment and coating failure.



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APPLICATION AND REDUCTION:

This Product is normally applied over well cleaned, bare substrates. Mix FOUR PARTS epoxy primer with ONE PART of the catalyst provided in the kit. Allow 30 to 45 minutes wetting time. Spray one cross coat to achieve a dry film thickness of 2 - 2.5 mils. Use admixed material within 8 hours. Dry to touch in 60 minutes, to handle in 4 Hours. For brushing and rolling, thin with MIL-T-81772B Type 2 as needed for proper flow and ease of application not to exceed 1 pint per gallon.

PRECAUTIONS:

USE WITH ADEQUATE VENTILATION.

AVOID CONTACT WITH SKIN AND EYES.

READ MATERIAL SAFETY DATA SHEET BEFORE USING.

KEEP OUT OF THE REACH OF CHILDREN.

FOR INDUSTRIAL USE ONLY.

CONTENTS ARE FLAMMABLE.