

25U-30 Epoxy Primer as a Primer Surfacer

1. Properties / Information





- 25U-30 Epoxy Primer is a two part epoxy primer for use as a primer surfacer.
- When using over steel, aluminum, zinc coated or galvanized metals, 25U-30 offers excellent adhesion and corrosion protection.
- 25U-30 can be applied over cured, cleaned and sanded paint finishes (except acrylic lacquers).

2. Surface Preparation

Substrate/Pretreatment:	Cleaning	Sanding	Second Cleaning
Well cured old paint work	70U-15 Degreaser	P240 - P400 grit	70U-10 Cleaner
O.E.M. primed spare parts	70U-15 Degreaser	P240 - P400 grit	70U-10 Cleaner
Bare steel	70U-15 Degreaser	P80 - P180 grit	70U-10 Cleaner
Galvanized Steel	70U-15 Degreaser	Coarse scuff pad	70U-10 Cleaner
Aluminum	70U-15 Degreaser	P120 - P180 grit	70U-10 Cleaner
Fiberglass, plastic parts (without gelcoat)	25U-30 is not recommended over this substrate		

NOTES: On Galvanized Steel and Aluminum, make sure sanding is not so vigorous that it removes the galvanized coating. With the second cleaning, make sure all residue is removed. Pay special attention when cleaning Galvanized Steel and Aluminum.







3. Application

	Mixing ratio	4:1:1 4 parts 25U-30 1 part 55U-10 1 part 60U-10, 60U-20, 60U-30 or 60U-40
	Pot life at 68°F / 20°C	8 hours
	Spray viscosity Ford 4 at 68°F / 20°C	20 s
	Spray gun HVLP	1.5 - 1.8 mm
	Spray pressure HVLP at the cap	6 - 10 psi
	Application	2 - 3 medium coats
	Film thickness	2.0 - 2.5 mil
	Coverage	762 sq. ft./gal @ 1.0 mil

Undercoat Technical Information

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4. Flash off / Drying / Sanding

	Flash-off at 68°F / 20°C	5 - 10 minutes between coats
	Drying at 68°F / 20°C at 140°F / 60°C	6 hours 30 - 35 minutes
	Infrared short wave medium wave	N/A N/A
	Wet sand by Hand	P400 - P600 grit
	Dry sand by Hand	P320 - P400 grit
	Dry sand by Machine	P320 - P400 grit

5. VOC / Comments

VOC as applied	≤ 250 gms/liter (≤ 2.1 lbs/gal)
Comments	Do not use over flexible parts.

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use — read product label and Safety Data Sheet (SDS) for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.