



PRODUCT DATA SHEET

PTI EPOXY PRIMER PTI EPOXY PRIMER SERIES

DESCRIPTION

PTI Epoxy Primer is a low VOC epoxy polyamide solvent primer which conforms to MIL-P-23377 Rev. E. This coating is highly recommended for use on aluminum and plated plated or un-plated metallic surface to insure maximum protection against corrosion. PTI Epoxy Primer also insures maximum adhesion of PTI TUF/FILM coating, or any other paint or lacquer finish coats. This Primer is intended to be used for aircraft, marine, original equipment manufacturing and/or industrial applications.

COLORS

This coating can be provided in yellow and green.

COATING PROPERTIES & CHARACTERISTICS

Mix Ratio, by volume	1 part Base to 1 part Catalyst
Reducer	Acetone, PTI-1003 TYII or PTI-1002
Recommended Dry Film Thickness	0.6 – 0.9 mil
Admixed Viscosity	14 seconds, max #4 Ford
Admixed Weight per Gallon	11.5 lbs.
Theoretical Coverage	800 sq. ft. ² /gal.
Pot Life	8 hours
Coatings VOC	Below 340 g/L

SHELF LIFE

Shelf life is only applicable for materials stored in unopened and undamaged original factory filled containers. 1 year when stored between 50°-85° Fahrenheit.

SURFACE PREPARATION INSTRUCTIONS

This primer can be applied directly to metal that has been prepared according to a recognized cleaning method such as Federal Test Method Standard, #141 and Method 2013. However, it is recommended that all parts be pretreated with chemical conversion coating materials to produce a pretreatment coating equivalent to PTI's Acid Etching Wash Primer.

- Scuff the surface with scotch bright pads.
- Dust off the surface with an air hose and wand.
- Wipe of the substrate with IPA or Acetone to remove grime and oils
- Remove all remaining dust and debris by lightly wiping the substrate with a tack or "cheese" cloth
- For additional protection apply PTI's Acid Etch Primer prior to the Epoxy Primer.

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MIXING INSTRUCTIONS

Shake component A in a paint shaker for 5 – 10 minutes for optimal results.

Admix by volume:

1. Add 1 volume of Component “A” to 1 volume of Component “B” and stir thoroughly. Stir each well before mixing. Allow to stand one (1) hour at room temperature before using. Reduce with exempt solvent(s) if required (see use of solvent above).
2. Mix only an amount that can be used in one day.

Add the Catalyst into the Base.

Admixed material should be allowed a 45-minute induction time for best application results.

Reduce: Use reducer PTI-1003 TYII or PT-1002 to thin the material.

- If using PTI additives to adjust the dry and cure times of the coating, please refer to those Product Data Sheets for specific instructions for admixing the material.

APPLICATION

This product can be applied using conventional air spray equipment, HVLP, Apollo Spray system. Please consult with a PTI representative for specific equipment recommendations and settings.

1. Make sure pots, guns, and lines are purged and cleaned.
2. Mix both base and catalyst thoroughly and filter/strain before spray application.
NOTE: It is not recommended to strain flat/matte coatings.
3. HVLP Spray Pressure: 7-10psi
4. Always air-blow and tack wipe the surfaces to be painted. Aircraft should be grounded to prevent static.
5. Best application results: apply 2 coats: 1 fog/tack coat & 1 full coats from 0.6 – 0.9 mil thickness.
6. Do not allow more than 24 hours to pass before applying the second coat.
7. Recommended Dry Film Thickness is 0.6-0.9 mils.

NOTE: Application of PTI products requires the use of all OSHA approved safety equipment, including proper ventilation. Additionally, PTI products require the recommended temperature/humidity conditions and film thickness ranges for optimal performance. The material, hangar, and aircraft skin temperatures should be no lower than 75° F / 25° C before, during and after application.

DRYING & CURING SCHEDULE

Dry times are based on the dry film thickness between 0.6 - 0.9 mils (25-50 microns).

Air Dry:

Allow applied coating to dry for at least 1 hour before apply a top coat. Dry hard after 4 to 6 hours.

Force Cure:

When force curing this primer do not let temperatures exceed 350°F for more than 2 hours

Always bring the coating to the “tack free” stage before top coating.



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EQUIPMENT CLEANUP

Use clean PT-1003 Type I Reducer. Do not allow material to dry or cure inside any equipment.

HEALTH, SAFETY, & STORAGE REQUIREMENTS

Refer to each individual material SDS (Safety Data Sheet) for specific requirements on the health, safety, storage and handling requirements. Follow all local, state, and national regulations during surface preparation, material application and cleanup.

PRODUCT INFORMATION & DISCLAIMER

Product Data Sheets are periodically updated to reflect new information. It is important to use the latest and most recent revision for the product being used. The foregoing information is accurate to the best of our knowledge. However, due to differences in customer handling, use and method of application which are not known and are beyond our control, Products Techniques, Inc. makes no warranties as to the end result.