

**PRODUCT DESCRIPTION**

A high performance, two-component, industrial Polyamide Epoxy Primer designed for application over properly prepared metal or concrete substrates. A flat and semi-gloss catalyst is available to use with the epoxy primer.

**Color:** Gray  
**Sheen:** Semi or Flat

**Benefits**

Excellent moisture, chemical, and solvent resistance  
 Excellent impact resistance  
 1:1 mix ratio

**PRODUCT AND PERFORMANCE DATA**
**Product Data**

Property	Result
Volume solids (%)	64 ± 2
Weight solids (%)	80 ± 2
VOC	307.7 g/L 2.57 lb/gal
Recommended dry film thickness	2 – 4 mils
Recommended wet film thickness	3.25 – 6.25 mils
Theoretical Coverage (1.0 mil)	1026.6 ft <sup>2</sup> /gal
Dry to Handle	4 – 6 hours
Recoat	1 – 2 hours or overnight
Full Cure	1 week

*\*Testing was performed on CRS after a 200°F for 15min cure.*

**Performance Data**

Test Method	Standard	Result
Gloss @ 60°	ASTM D523-14	80+
Adhesion	ASTM D3359	5B
Impact Resistance	ASTM D2794-90	>120 in-lbs
Pencil Hardness	ASTM D3363	3H

**SURFACE PREPARATION**
**Pre-cleaning:**

Clean all surfaces to be coated in accordance with SSPC-SP-1, Solvent Cleaning prior to additional surface preparation or coating application. Surface must be clean, dry and free of any dirt, dust, oil, and all other visible contaminants.

**Surface Preparation**

Recommended	SSPC SP 6 (Commercial Blast Cleaning)
Minimum	SSPC SP 2 or SP 3 (Hand or Power Tool Cleaning)

**MIXING AND THINNING**

Before application, mechanically mix for 15 minutes at the ratio of 1:1. Allow mixture to stand for 45 minutes before using.

Catalyst A Gloss	10K000
Catalyst B Semi-gloss	10K011
Catalyst C Flat	10K022

**Mix Directions**

Stir thoroughly before and occasionally during use.

**Thinning Directions**

Product packaged ready to apply. If needed thin up to 10% maximum with Forrest's 81T014, Epoxy Thinner.

**APPLICATION**
**Application Parameters**

Relative Humidity	50 % ±10
Minimum Temperature	50°F (10°C)
Maximum Temperature	80°F (27°C)

**Force Cure Schedule**

Temperature	200°F (93°C)
Time	15 minutes

**Application methods**

The product can be applied by

**Spray**

Airless spray: .013" - .021"

Conventional spray: 1.0mm – 1.8mm

**Brush/Roll**

Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

**PACKAGING AND STORAGE****Packaging**

1 – Gallon

5 – Gallon

**Storage**

The product must be stored in accordance with local and national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

Shelf life at 73°F (23 °C) = 12 months \*

\*When kept in recommended storage condition and original unopened containers.

**CAUTION**

Adequate health and safety precautions should be observed during storage, handling, use and curing periods.

**READ SAFETY DATA SHEETS BEFORE USING THIS PRODUCT**

**DISCLAIMER**

The technical data and suggestions for use in this product data sheet are currently correct to the best of our knowledge, but are subject to change without notice. Because application and conditions vary, and are beyond our control, we are not responsible for results obtained in using this product, even when used as suggested. The user should conduct tests to determine the suitability of the product for the intended use under then existing conditions. Our liability for breach of warranty, strict liability in tort, negligence or otherwise is limited exclusively to replacement of the product or refund of its price. Under no circumstances are we liable for incidental or consequential damages.