Sky Fleet™ Product Information Sheet

Technical Support (800) 328-4892 **P.I. Sheet #3005**

SFE1122A™ (Red)
Epic Prime™ 2.1 VOC Primer/Sealer

READ ENTIRE PRODUCT INFORMATION SHEET PRIOR TO USE. IF ANY QUESTIONS ARISE, PLEASE CALL TECHNICALSUPPORT.

COMPONENTS

1. SFE1122A™ (Red) Epic Prime™
2. SFA1121B™ Epic Prime™ Activator
3. TH028™ or TH035™ Low VOC Reducer

DESCRIPTION:

Epic Prime™ Primer/Sealer is a high-build, Isocyanate and Chromate free, DTM primer/sealer designed to be applied to many substrates. Epic Prime™ provides excellent adhesion and fill with fast dry times. While created as a non-sanding primer/sealer, Epic sands easily and provides excellent color holdout. Recommended for use under single stage colors and properly activated basecoats.

SURFACE PREPARATION

Note: Be sure to completely remove all rust or oxidation prior to applying primer. Rust and/or oxidation can be removed by sand blasting, grinding, or sanding. Liquid metal cleaners may also be used followed by the appropriate metal conditioner or conversion coating.

Bare Substrates:

- Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Finish sand with 180 grit sandpaper.
- TH5950™ Strong Wax & Grease Remover and a red scuff pad may be used to remove light surface oxidation on aluminum. Follow by re-cleaning the aluminum to remove sanding residue with TH5950™ Strong Wax & Grease Remover.

Prepainted Substrates:

- Wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean, dry cloth. Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Sand repair area and featheredge as needed, finishing with 320 grit sandpaper.
- Re-clean small repair areas with TH5952™ Fast Evaporating Surface Cleaner to remove sanding residue before priming. On larger areas, the use of TH5951™ Mild Wax & Grease Remover may be desired.

Sealer Option:

- Wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean dry cloth. Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Sand repair areas, finishing with 320 grit sandpaper or finer.
- Re-clean repair with TH5951™ Mild Wax & Grease Remover or TH5952™ Fast Evaporating Surface Cleaner to remove sanding residue before sealing.

COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, aluminum, galvanized steel, copper, and brass
- Thoroughly sanded OEM
- Thoroughly sanded and cured paint
- Cured, sanded body filler (the use of stain free body fillers will reduce the chance of yellowing)
- Sanded fiberglass

MIX BY VOLUME

<u>As a Primer</u> (VOC 2.1 lbs/gallon as applied)

- 4 Parts SFE1122™ Epic Prime™
- 1 Part SFA1121B™ Epic Prime™ Activator
- 1 Part TH028™ or TH035™ Low VOC Reducer
  (Further reduction may be done while maintaining 2.1 VOC.)

Mix Ratio in Ounces (As a Primer)						
Primer	4	8	16	24	32	48
Activator	1	2	4	6	8	12
Reducer	1	2	4	6	8	12

<u>As a Sealer</u> (VOC 3.5 lbs/gallon as applied)

- 4 Parts SFE1122™ Epic Prime™
- 1 Part SFA1121B™ Epic Prime™ Activator
- 1 ½ Parts TH0860™ Series Reducer (Further reduction must be done with TH028™ or TH035™ low VOC reducer to maintain 3.5 VOC.)

Mix Ratio in Ounces (As a Sealer)						
Sealer	8	16	20	24	32	64
Activator	2	4	5	6	8	16
Reducer	3	6	7 ½	9	12	24

POT LIFE

Primer: 3 – 4 hours at 75°F
Sealer: 5-hours at 75°F

- Clean equipment immediately after use.

EQUIPMENT SETUP

	Fluid Tip	Air Pressure
Primer / Sealer		
HVLP Gravity	1.5 – 1.7mm	6 – 10 PSI at the cap
HVLP Siphon	1.5 – 1.7mm	6 – 10 PSI at the cap
High Efficiency Gravity	1.5 – 1.7mm	30 – 40 (PSI) Inlet Pressure
High Efficiency Siphon	1.5 – 1.7mm	30 – 40 (PSI) Inlet Pressure
Conventional Gravity	1.5 – 1.7mm	45 – 50 (PSI) Inlet Pressure
Conventional Siphon	1.5 – 1.7mm	45 – 50 (PSI) Inlet Pressure

PRIMER APPLICATION

- Apply over properly prepared surfaces.
- Apply 1 full-wet coat.
- If 2nd coat is applied, allow 20-minutes flash between coats.
- Do not apply more than 2-coats.

Brushable / Rollable Option

- Mix according to directions.
- Apply 1 even coat of SFE1122™ Epic Prime™, making sure to cover the repair area completely into the featheredge.
- If a 2nd coat is applied, allow a 5-10 minute flash between coats.
- Apply the 2nd coat within ¾ inch of the previous coats outer edge.
- For best results, do not apply more than 2 coats prior to sanding.

SEALER APPLICATION

- Apply 1 single wet coat of properly mixed SFE1122™ to create a uniform base.
- Allow to flash for 30-45 minutes before applying topcoats.
- Apply topcoats within 12-hours of Sealer application.

DRY TIME TO SAND

Primer Option:

- If primer is not topcoated within 24-hours, scuff with gray scuff pad or 600 grit sandpaper.

Sealer Option

- Sealer does not require sanding if topcoated within 12-hours.
- Nub sanding with 600 grit sandpaper or finer may be done in approximately 1-hour for debris removal.

DRY TIME TO TOPCOAT

Primer Option

- 30 – 40 minutes at 75°F per coat prior to topcoating.
- If primer is not topcoated within 24-hours after sanding, scuff with gray scuff pad or 600 grit sandpaper.

Sealer Option

- 30 – 40 minutes at 75°F after single coat.
- If sealer is not topcoated within 12-hours, scuff with gray scuff pad or 600 grit sandpaper.

COMPATIBLE TOPCOATS

System 10™ Acrylic Enamel Color
System 22™ Acrylic Urethane Color
System 35™ Polyurethane Color
SFE60™ High Solids Polyurethane Color
System 12™ Acrylic Enamel Fleet Color
System 28™ Polyurethane Color
System 50™ Basecoat Color **** NOTE: System 50™ Basecoat Color must be activated with MP1665 activator 1-2 oz. per sprayable quart for maximum adhesion.**

SPECIAL NOTES

- Use in shop temperatures that are maintained above 75°F for the first 20-hours of the cure cycle.
- Ensure surfaces are up to shop temperature prior to work.
- Ensure proper metal conditioning/preparation procedures in early stages are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions for topcoats are followed.
- Use a mixing cup for accurate volume measurements.

PHYSICAL DATA (PRIMER)

Primer (Mix Ratio 4:1:1)	
Dry to Topcoat	30 – 40 minutes per coat
Film Thickness	1.5 mils ± .3 per coat
Volume Solids	43%
VOC Applied	2.1 lbs/gallon maximum
Theoretical Coverage	691 @ 1 mil DFT
Flash Point	See MSDS

PHYSICAL DATA (SEALER)

Sealer (Mix Ratio 4:1:1½)	
Dry to Topcoat	30 – 40 minutes
Film Thickness	1.0 mils ± .2 per coat
Volume Solids	39%
VOC Applied	3.5 lbs/gallon (with TH0860 Series Reducer)
Theoretical Coverage	627 @ 1 mil DFT
Flash Point	See MSDS

CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

DISPOSAL

Dispose of all paint and paint related materials in accordance with state and local regulations.

SAFETY & HEALTH

Read and follow all technical product information, labels, and MSDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

MSDS REFERENCE

Primer – MSDS #1000
Catalyst – MSDS #1003
Reducer – MSDS #1

COMPANY INFORMATION

ChemSpec USA
9287 Smucker Road
Orrville, Ohio 44667
Toll Free: (800) 328-4892
Fax: (330) 669-3965
Website: www.chemspecpaint.com

Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Material Safety Data Sheets (MSDS) supplied with the materials.

KEEP OUT OF REACH OF CHILDREN