

# Epoxy Primer-Sealer 320

## Surface Preparation

Thoroughly remove all wax, grease, oil, corrosion and dirt. All corrosion should be removed and metal prepared as for any paint application. Old finishes must be properly sanded and cleaned with 901 Final Wash. Aluminum must be thoroughly sanded or etched with Self-Etch before applying EP1

## Mixing Ratio

Mix the components in the order and ratio indicated

Mix Ratio	Primer	Sealer
Primer 320	2 Parts	2 Parts
Activator 321	1 Part	1 Part
Reducer 161	N/A	N/A
162	N/A	25%
163	N/A	25%

Mixed VOC 4.7 lb/gal

## Pot Life

8 Hours Minimum

## Topcoating

320 Epoxy Primer-Sealer can be topcoated with all finish coatings.

## Gun Set-Up

Use 40 to 50 PSI air pressure at the gun.

## Application & Dry Times

Compatible surfaces include; Properly sanded or etched aluminum. Properly cleaned steel. Clean, deoxidized galvanized steel. Clean, sanded fiberglass, SMC. Automotive plastics except polyethylene and all other primers. Application for Primer: Spray catalyzed primer at 40-50 PSI air pressure. Apply 1 to 2 wet coats. Allow 10 to 15 minutes dry time before topcoating. Dry film build should be .75 to 1.0 mil. Allow thirty minutes to one hour dry time before topcoating. Thinner coats will reduce dry time before topcoating. Application for Sealer: Reduced up to 25% apply one full wet coat. Allow 30 minutes dry time before topcoating. Note: If applied over lacquer products, all topcoats must be applied within the same workday to avoid lifting.

## Clean Up

Clean equipment immediately after use with Excel Urethane Grade reducer or Excel 99/100 Virgin Lacquer Thinner. Do not leave activated material in the spray gun longer than 3 hours.

## Safety & Handling

Read all directions and warnings before using this product.

