



Alumigrip® 10P8-11 Primer Application Procedure

Characteristics



Product
Information

This two component, VOC compliant epoxy primer will provide a very smooth finish optimizing the appearance of the subsequent topcoat. This primer utilizes exempt solvents in meeting the required VOC level.

Components



Base
Curing Solution

Alumigrip® 10P8-11
EC-286

Surface Conditions



Cleaning

Surface pretreatment is an essential part of the painting process.

Components



Mixing Ratio
(volume)

1 parts	Alumigrip® 10P8-11
1 parts	EC-286

1. Store material at room temperature for a minimum of 24 hours prior to mixing.
2. Prior to mixing, put the primer base portion on a shaker and agitate for ten minutes.
3. The base component should be uniform and free of lumps, skins or hard settling.
4. The curing solution should be clear with a slight amber color. Do not use if the curing solution is cloudy.
5. Following the mixing instructions provided, add the curing solution to the base component stirring to a homogeneous condition.



	Note: Overcoat Time	2 Hours
	Induction Time	No induction needed
	Pot Life (25°C/77°F)	4 hours.

Application Recommendations

	Conditions	<p>Temperature: 15 – 35°C 59 – 95°F</p> <p>Relative Humidity: 35 – 75%</p>
	Note	<p>The quality of the application of all coatings will be influenced by the spray equipment chosen and the temperature, humidity, and air flow of the paint application area. When applying the product for the first time, it is recommended that test panels be prepared in order to identify the best equipment settings to be used in optimizing the performance and appearance of the coating.</p>
	Equipment	<ol style="list-style-type: none"> 1. Conventional air spray: Atomizing air pressure: 45 to 65 psi, Pot pressure (if applicable): 6 to 12 psi Tip size: 1.2 to 1.4 mm 2. Air assist airless electrostatic spray equipment: Fluid pressure: 850 to 1,000 psi (pump ratio 15:1), Atomizing air pressure: 55 to 65 psi, Tip size: .013 inches (0.33mm) or smaller, preferably .011 inch (0.28mm) 3. High pressure air assist airless electrostatic spray equipment: Fluid pressure: 1800 to 2500 psi (pump ratio 30:1), Atomizing air pressure: 55 to 65 psi, Tip size: .009 to .011 inch (0.23 - 0.28 mm) 4. HVLP: Input air: up to 65 psi, Fluid/pot pressure: 6 to 12 psi, Tip size: 1.2 to 1.4 mm



Application

1. Spray a single uniform wet coat to a dry film thickness of 0.6 - 0.9 mils / 15 – 23 micron (μm).
2. See Mixing Instructions section of this document for minimum time to overcoat. Maximum overcoat time is 48 hours. After 48 hours, surface must be lightly abraded and solvent wiped and tacked.

Safety Precautions

Comply with all local safety, disposal and transportation regulations. Check the Material Safety Data Sheet (MSDS) and label of the individual products carefully before using the products. The MSDSs are available on request.

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IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advice given is subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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