



Technical Data Sheet

2K EPOXY PRIMER GREY or BLACK

Description: **2K Epoxy Primer Grey or Black** is a two-component high solid, low VOC epoxy primer designed with excellent corrosion protection, adhesion and resistance to chipping for repaired/remanufactured alloy wheels. The product is easy to apply with a smooth appearance and fast dry times. The **2K Epoxy Primer** has a ready to spray VOC of less than 2.1 lbs/gal. This makes it compliant in all low VOC regulated areas as well as all national rule markets.

Product & Additives:	PRODUCT	ITEM #	SIZE
	2K Epoxy Primer Grey	131001/131002	Pt./Qt.
	2K Epoxy Primer Black	131004/131005	Pt./Qt.
	2K Epoxy Primer Hardener	131110	½ Pint
	Wheelkote Reducers	Various	Qt./Gal.

Suitable substrates: **2K Epoxy Primer Grey or Black** can be applied over properly prepped aluminum, cold rolled steel, fiberglass, galvanized steel and existing finishes.

Note: See the TDS for DTM Pre-Treatment Wipe for proper preparation of bare aluminum surfaces.

Safety Aspects: Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. *Copies of the SDS and product label are available upon request.*



Mixing Ratios: **MIX 3:1:1**
3 parts 2K Epoxy Primer Grey or Black
1 part 2K Epoxy Primer Hardener
1 part Wheelkote Reducers
 *For higher build applications mix **2K Epoxy Primer Grey or Black [3:1]** with 2K Epoxy Primer Hardener



Gun Setup:	TYPE	FLUID TIP	SPRAYING PRESSURE
	Conventional Gravity	1.2 mm–1.6 mm	30–35 psi @ gun
	HVLP Gravity	1.2 mm–1.4 mm	10 psi @ cap





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Application: Apply one single flowing wet coat. Allow the recommended flash times between coats if another coat is desired. **2K Epoxy Primer Grey or Black** should be applied with an even wet flowing coat but should not be applied too heavily.

Number of coats: Apply one to two single medium wet coats.

Flash Times: 5 to 10 minutes between coats @ 70°F/21°C.

Time to topcoat: Allow 30 minutes before applying topcoat @70°F/21°C

Drying Times:



METAL TEMP	DUST FREE	TACK FREE	DRY
70°F/21°C	15-20 mins.	25-30 mins.	12-14 hours
140°F/60°C	N/A	N/A	30 mins.
250°F/120°C	N/A	N/A	10 mins.

Recoatability: **2K Epoxy Primer Grey or Black** can be topcoated after 30 minutes @ 70°F/21°C. **2K Epoxy Primer Grey or Black** has a 48 hour window @70°F/21°C to recoat/topcoat before sanding is required.

Film Thickness: Approximately 1.2-1.5 mils per single coat.

Pot Life: **2K Epoxy Primer Grey or Black** when mixed ready to spray is 4 hours @ 70°F (21°C)

Stirring: **2K Epoxy Primer Grey or Black** is a high solids product, it needs to be thoroughly agitated and stirred before use.

Cleaning Equipment: Clean equipment immediately with lacquer thinner.

Theoretical Coverage: 624 Sq Ft/ Gal @1 mil. wet film thickness

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Color	Grey or Black
Activator/Hardener	2K Epoxy Primer Hardener
Mix Ratio	3:1:1
Reducer	Wheelkote Reducers
Additives	N/A
Number of Coats	1-2 wet coats
Flash Time	5–10 minutes
Time to topcoat	30 minutes @ 70°F/21°C
Dry Time	12-14 hours @ 70°/21°C 30 minutes @ 140°F/60°C 10 minutes @ 250°F/120°C
Gun Set-Up	Refer to Table on Page 1
Air Pressure @ Gun	Refer to Table on Page 1
V.O.C. Limit	2.1 lbs/gal (251 g/l)
Sprayable V.O.C.	<2.1 lbs/gal (251 g/l)
% Solids Sprayable by Weight	39% +/- 2%
Package Size	Gallon
Case Quantity	2
Shelf Life	12 months unopened

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