

**COATING DATA**

**DESCRIPTION:**

Induron Fast Prime 2 is a two-component specially modified, polyamide cured, high build epoxy primer providing very fast dry times and excellent resistance to corrosive and abrasive environments.

**Fast Prime 2 Epoxy**

- Dries to a low sheen finish
- Very fast dry to handle and recoat times.
- Available in white, light gray and light yellow
- Excellent chemical resistance.
- Excellent resistance to aliphatic and aromatic hydrocarbons.
- Lead and chromate free.
- Complies with OTC(Ozone Transfer Commission) Standards for HAPS and VOC
- Performs well as a primer in many aggressive environments and substrates such as:
  - Structural steel
  - Locomotives
  - Oilfield Equipment
  - Piping
  - Heavy Duty Equipment and machinery

**USE:**

As a highly durable primer on properly prepared carbon steel surfaces. This product may be topcoated with all Induron epoxy, urethane, acrylic siloxane and DTM acrylic finish coats.

**LIMITATIONS:**

Do not use for surface temperatures above 200°F (93°C). Not recommended for immersion.

**SURFACE PREPARATION:**

**Steel (Non-Immersion)**—The recommended surface preparation is SSPC-SP 6/NACE 3 Commercial Blast Cleaning to obtain a 1.5-2.5 mil surface profile after removal of all surface contaminants. If blasting is not possible or practical, then the substrate may be prepared as per SSPC-SP 2 and/or SSPC SP-3 Hand and Power Tool Cleaning, with some sacrifice in performance was compared to abrasive blasted surfaces.

**Aluminum**—Prime with Induron Vinyl Wash Primer. Follow product data sheet instructions.

**Galvanized Steel**—Prime with Induron Vinyl Wash Primer. Follow product data sheet instructions.

**COVERAGE:**

Theoretical—829 ft<sup>2</sup> per gallon at 1.0 mil dry film thickness.

**DRY FILM THICKNESS:**

3.0 to 6.0 mils per coat.

**WET FILM THICKNESS:**

5.8 to 11.5 mils.

## APPLICATION DATA

### BLEND RATIO:

One part Fast Prime 2 Base to one part Fast Prime 2 Epoxy Blending Resin by volume. Power agitate until components are thoroughly mixed.

### POT LIFE:

2.5 hours at 70°F, 4 hours at 50°F and 1 hour at 90°F

### APPLICATION:

**Airless Spray**—Use .015-.019 tip; 60 mesh filter; 30:1 pump ratio at 60-100 psi operating air pressure.

**Conventional Spray**—Follow instructions of equipment manufacturer for the application of epoxy paints.

**Roll**—Use a high quality synthetic cover with a solvent resistant core. Additional coats may be required to achieve desired film thickness. **Brush**—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

### THINNING:

If required, thin up to 10% with K-1034. Clean-up with K-1070 (MEK)

### CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 40°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dewpoint for a period of at least two hours after application to avoid film defects from condensation occurring on wet paint.

### DRY TIME:

TO TOUCH: 60 min. @ 75°F, 2 hours at 50°F and 45 minutes at 90°F

TO SAND: 5 hours @75°F, 7 hours at 50° F and 3 hours at 90°F

TO RECOAT— 45 min. @ 75°F

This product may be recoated up to 60 days without scarification as long as the surface is clean and dry.

**Note:** High film thickness, low temperature and/or poor ventilation will retard dry time.

**Note:** E-60 Accelerator may be used to increase the normal curing rate of reaction to provide a rapid low temperature cure. See E-60 Technical Data Sheet for more information.

### PHYSICAL DATA:

VOLUME SOLIDS: 51.7% ± 1%

SOLIDS BY WEIGHT: 69.1% ± 1%

WEIGHT PER GALLON: 12.6 ± 0.2 lbs/gallon

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 2.8 lbs/gallon; < 336 grams/liter

Mixed thinned 10% - < 3.2 lbs/gallon; < 384 grams/liter

HAZARDOUS AIR POLLUTANTS:

Mixed unthinned – 3.7 lbs/gallon solids

Mixed thinned 10% - 3.7 lbs/gallon solids

**SAFETY DATA:** See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request.