



# HIGH TECK TECHNICAL DATA SHEETS

## 2.1 VOC HIGH BUILD EPOXY PRIMER

HIT.7500-1 Dark Gray - Gallon  
 HIT.7500-4 Dark Gray - Quart  
 HIT.7501-1 Black - Gallon  
 HIT.7501-4 Black - Quart

HIT.7502-1 White - Gallon  
 HIT.7502-4 White - Quart  
 HIT.7503-1 Catalyst - Gallon  
 HIT.7503-4 Catalyst - Quart

### Description

2.1 VOC High Build Epoxy Primer has been formulated for excellent adhesion and corrosion resistance when used on various types of substrates including properly prepared steel and aluminum. When mixed properly, Epoxy Primer is compliant with all known Canadian and US rules including Rule 1151 in the SCAQMD.

### Components

- #7500-1 Light Gray - Gallon
- #7500-4 Light Gray - Quart
- #7501-1 Black - Gallon
- #7501-4 Black - Quart
- #7502-1 White - Gallon
- #7502-4 White - Quart
- #7503-1 Catalyst - Gallon
- #7503-4 Catalyst - Quart



### Mixing Ratio

Mix one (1) part Epoxy Base to one (1) part Epoxy Catalyst. Reduce 15-25% with High Teck Reducers to maintain 2.1 VOC. May be used for non-compliant product areas. \*\*SHAKE or STIR ALL products prior to mixing including the 7503 Catalyst.\*\*

### Pot Life at 77°F

8 Hours

### Clean Up

Use High Teck Lacquer thinner or Zero VOC solvents. (Check local regulations)

### Physical Data

Solids wt. (as mixed) 44 - 54%  
 VOC as mixed 2.1  
 Color Light Gray

### Dry/Flash Times

#### Air Dry at 77° F

Flash between coats 30 minutes  
 To sand Overnight  
 To topcoat 60 minutes

#### Force Dry

Flash before force dry 15 minutes flash  
 Force dry time 30 minutes at 140° F

### Gun Setups

#### Conventional

Gravity Feed 1.5 mm – 1.8 mm  
 Siphon Feed 1.5 mm – 1.8 mm



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HIT.7503-4 Catalyst - Quart

### Air Pressures

#### Conventional at Gun

Gravity Feed	35 – 45 psi
Siphon Feed	40 – 50 psi
HVLP at cap	8 – 10 psi

### Surface Preparation

Use at clean wipe to clean substrate free of grease, dirt, and foreign contaminants.

### Application

- Apply 1 - 2 medium wet coats over substrate
- Allow 15 minutes between coats, 60 minutes to topcoat
- Scuff after 48 hour period
- Clean gun after spraying is completed

### Safety

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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