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From the Stars to your Cars

Technical Data Sheet

Epoxy Primer Gray 1350-750

Product Description and Purpose

Epoxy Primer Gray is a corrosion protective primer providing excellent adhesion to various substrates including Fiberglass, Steel, Galvanized, and other difficult substrates. Epoxy Primer Gray can be used as a foundation product or any part of the repair process.

Quick Start Guide

Product:	Epoxy Primer Gray 1350-750	
Mix Ratio:	2 Parts	Epoxy Primer Gray 1350-750
	1 Part	Epoxy Hardener 11-750
Number of layers:	1-3 depending on requirements	
Items Needed:	Epoxy Primer Gray 1350-750 and Epoxy Hardener 11-750	

Acceptable Substrates

Steel, Aluminum, Fiberglass, SMC, various composites*,
OEM Finishes, E-coated replacements, and OEM primed plastic

*If considering use on non-OEM plastic, composites, and special alloys,
individual testing is recommended.

Substrate Preparation

All surfaces shall be cleaned prior to performing sanding, or spraying activity.

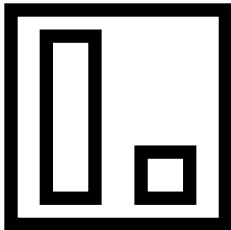
Cleaning: 594-30 Wax and Grease Remover

All surfaces should be cleaned of all surface rust by abrasion, sand/media blast, and/or properly neutralized metal conditioner solution.

Do not apply Epoxy Primer Gray directly over any acid activated primer.

Steel: Sand Dry P80-P120 Dry
Aluminum: Sand with 3M 7447 Pad (or equal) or P120-P220 Dry
Fiberglass: Sand with P120-P220 Dry
SMC: Sand with P120-P220 Dry
OEM E-Coat: Sand with P180-P220 Dry or P220-P320 Wet
OEM plastic: Sand with P180-P220 Dry or P220-P320 Wet
OEM finishes: Sand with P180-P220 Dry or P220-P320 Wet

Mixing Ratios and Optional



For filling/sanding capabilities:

2 Parts Epoxy Primer Gray 1350-750
1 Part Epoxy Hardener 11-750

For non-sanding, wet on wet capabilities:

4 Parts Epoxy Primer Gray 1350-750
2 Part Epoxy Hardener 11-750
1 part Urethane Reducer 594-UR60, 70, or 80

* Stir/Shake the mixture well for 1 minute

* Allow 30 minute induction time

Additives

Orion Automotive Finishes does not offer, or require, any additives for this product.

Application

Application can be 1-3 coats depending on requirements. Allowing thorough flash time will improve curing, sanding properties, and speed overall dry times.
Spray gun Recommendations:

Spray gun Recommendations:

For filling and sanding:

Gravity feed Primer grade gun 1.6-1.8 Fluid tip @ 12-16 PSI inlet pressure

For non-sanding or wet on wet:

Topcoat grade gun 1.5-1.6 Fluid tip @ 10-14 PSI inlet pressure

Dry Times/Pot Life @ 77F/25C

(Dry/Flash times dependent on layer thickness)

Flash time between coats: 15-45 Minutes

Recoat time: 30-45 minutes

Dry to Sand: 1-2 Coat 60-90 minutes
3 or more Coats 3 hours +

Pot Life: 8-12 hours

Recoating

After dry and sanding, Orion 1350-750 Epoxy Primer Gray can be top coated directly with any Orion Brand 2K Primer, Surfacer, Sealer, Basecoat, or single stage product.

1350-750 Epoxy Primer Gray can be recoated with 1350-100, 150, or 200 DTM Primer wet on wet style after 30-60 minutes, but, no longer than 72 hours.

Safety and Emissions Data

Color: Gray

The appropriate selection of this product is based on many local factors and is ultimately most accurate when made by the customer. To assist in issues with regard to product selection please contact Orion Automotive Finishes.

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions. The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

NOTE: Orion Automotive Finishes products are not recommended for use in temperatures below 65°F. Use below these temperatures will effect dry times and performance.