



AUTOMOTIVE

TAMCO PAINT

HP770 SERIES ULTRA HI-BUILD MARINE GRADE EPOXY GRAY HP771 / HP772 / HP773

Tamco's® Very High Build Marine Grade 1:1 two-part, high-solids epoxy primer is an ideal coat under high-gloss urethane topcoats to maximize adhesion, improve gloss, and aid in gloss retention. We say improves gloss and aides in gloss as epoxies once topcoated too soon tends to cause dye back issues. HP770 Series epoxy will not have those issues. It dries quickly for faster overcoating, easy to sand once cured, (in as little as 3 hours above 78°F) and provides excellent corrosion control.

The Surfacing primer formula is ideal for easy sanding, very high build uses on all substrates. Ideal for a underwater marine primer, but not solely intended for marine use. This epoxy can be used on ANY substrate. The HP770 series epoxy unlike our HP660 series epoxy is solely Direct to rust! 3 coats of this epoxy is all the protection you need against rust!

Our HP660 series epoxy is a “sealer” coat epoxy. Never intended for build, you always needed to use our HP53xx primer over it (at least 12 hours later) for the build and sandable properties. You no longer need to do that with this unique epoxy.

MUST HAVE INDUCTION TIME!

Features & Benefits

- Very High Build
- Waterproof
- A replacement for inferior polyester primers which are not suitable for fiberglass repairs. Epoxy will not shrink or allow solvent penetration
- Will not crack in high milage applications
- Great for auto restorations
- Industrial and Marine use



Compatible Surfaces

- Plastics
- Old finishes in sound condition
- All metals except stainless
- Tamco® Primers.

Required products

- HP770C High Build Epoxy Hadener

Optional

- HR1360
- HR1370
- HR1380
- HR1390

(See our "What Temperature should I choose PDF" for a guideline on which suits your current job)

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Surface Preparation:

- Clean first with soap and water. Then use Tamco® HR397 (or HR397W) Wax and Grease remover. Our high strength HR397 solvent is an excellent choice for the initial cleaning of cured paint surfaces before sanding and for cleaning bare metal. We also have a waterborne version in the HR397W (water) which is great for cleaning plastics.
 - Sand the paint either to the bare metal, the original primer, or at least sufficiently for the new paint to adhere. Dry sand using 180-grit sandpaper to remove rust or surface damage before moving on to a 320-grit paper to remove your previous 180-grit scratches. Whichever method that you decide, follow it up using 400- to 600-grit sandpaper to sand the paint to prep the existing paint surface for the new coatings to be applied.
 - Re-clean with HR-398 Final wipe. This is a must to remove microscopic dust particles that will end up as "dirt" in your paint job. HR398 also contains Isopropyl alcohol to help de-static the area to be painted to keep the surface free from dust. This step also helps reduce grease from hand prints.
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Mix Ratio:



1:1 with a 30-45 minute induction time @ 78°F degrees.

Additives:



None.

Air Pressure:



Gun Setups:

Conventional

Siphon Feed: 2.5 or greater

Gravity Feed: 2.0-2.5

HVLP

Siphon Feed: 2.5 or greater

Gravity Feed: 2.0-2.5

Always refer to your gun manual for their advice in using our products.



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Application:



Follow Surface Preparation procedures listed above.

- Wash painted surfaces thoroughly with soap and water to remove water- soluble contaminants. Then clean with appropriate Tamco® HR397 cleaner.
 - Sand with 120-180 grit sandpaper or higher for desired smoothness.
 - Re-clean as needed with HR398 final wipe.
 - Mix HP770 Series 1:1 with HP770C and give at least a 30 -45-minute induction time. Apply: 2 – 3 coats of primer to achieve build using airless spray, roller, or conventional spray gun with 2.50 tip or larger. Induction of this is a must! Curing will be drastically slowed if not given proper induction time. HP770 series has a long pot life, so long induction times lead to faster curing.
 - Then apply your finish paint. See various Tamco® TDS sheets on each type of paint.
 - When you paint a car or parts, be sure to always sand the edges extremely well. If paint is going to lose adhesion and start peeling, it will probably start from an edge of a panel that was not sanded properly. One can also use our Topdawg Adhesion promoter to get to areas where you cannot sand.
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Drying Times:



4-8 hours depending on temperatures.

Recoat: No recoat window.

Tamco® Tips:



- Induction time is a must.
 - Can be reduced to make it easier to apply – however this product cannot be made into a sealer.
 - Great for underwater priming on boats and other structures.
 - Fixes gelcoat blistering.
 - A replacement for inferior polyester primers which are not suitable for fiberglass repairs. Epoxy will not shrink or allow solvent penetration.
 - Not to use on Aircraft.
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Polishing:



N/A



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Equipment Cleaning:

Lacquer Thinner

Cold Shop Conditions:

Do not use under 65°F or over 95°F.

TECHNICAL DATA & PHYSICAL PROPERTIES

VOC less exempt solvents (RTS) 2.4 lbs/Gallon
Total Solids by Volume (RTS) 78% as sprayed
Sq. Ft Coverage / US Gal (RTS) 281 sq feet at 4 mils
Film build per coat -4-6
POTLIFE 16 Hours at 77°F 1 hour at 90°F

IMPORTANT: The contents of this package must be blended with HP770C at a 1:1 ratio and given an induction time of 30-45 minutes at 78°F to work properly.

See Safety Data Sheet/Material Safety Data Sheet and Labels for additional safety information and handling instructions.

Important: The contents of this package must be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the public. Products mentioned may be hazardous and should only be used according to direction, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to Tamco Paint Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does Tamco Paint warrant freedom from patent infringement in the use of any formula or process set forth herein.

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