



ORCA AIR DRY SURFACE PRIMER

PRODUCT APPLICATIONS-

- METALIC PRIMER— AUTOMOTIVE, TANKS
- IN MOLD PRIMER FOR POST PAINT APPLICATION
- PATTERN SURFACES—TOOLING BOARD (URETHANE, EPOXY)
- WOOD PRIMER—MDF, MARINE GRADE WOODS,
- MARINE APPLICATION
- ARCHITECTURAL WOOD SURFACES

-PRODUCT FEATURES-

- QUICK BUILD PRIMER WITH A TOUGHER SURFACE THAN THE SANDING PRIMER
- LOW POROSITY SURFACE FOR A FINISH COAT OR PREPARATION FOR A TOP COAT
- LOW VOC PRODUCT
- PERFECT PRIMER FOR ORCA TOPCOATS OR ANY OTHER SURFACE COATINGS DESIRED
- RELATIVELY HI-BUILD TO 80 MILS
- WILL POLISH TO A RELATIVELY HI-GLOSS SURFACE

-SURFACE PREPARATION-

- PREPARE SURFACE BY SANDING WITH 220g PAPER (ALWAYS NON-STEARATED)
- CLEAN SURFACE WITH IPA (ACETONE IS NOT SUITABLE)

-PRODUCT APPLICATION SUGGESTIONS-

- CATALYZE AT 2% W / MEKP INITIATOR (.5-OZ PER QUART)
- UTILIZATION OF HVLP SPRAY GUN OPTIMIZES FINISH
- AIR PRESSURE 25-40 PSI
- MAINTAIN 12-18" DISTANCE BETWEEN GUN AND SURFACE
- OPTIMUM TEMPERATURE OF 77°F
- START WITH FLASH COAT (2mils) WAIT 2 MINUTES THEN START BUILD COATS OF 4 mils PER PASS WAITING APPROX. 5 MINUTES BETWEEN COATS. DURING COOLER TEMPERATURES WAIT 20 MI-

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UTES BETWEEN COATS. IF YOU EXCEED 90 MINUTES, YOU MUST LET CURE, SAND, AND THEN RESUME BUILD COATS.

- OPTIMUM BUILD OF 16 MILS
- ALLOW FULL CURE (24 HOURS) PRIOR TO SAND AND POLISH

PRODUCT SPECIFICATIONS-

GEL TIME:

16-20 min

VISCOSITY:

2200 cps

CURE TIME:

1 HOUR

COVERAGE (8-MILS):

200 sf / gallon

THIX INDEX:

5.22

WEIGHT PER GALLON:

8.7 lbs.

FLASH POINT:

98° F

VOCs:

.68 lbs. / gal.

MONOMER CONTENT:

20%

SHELF LIFE:

6 months @ 68° F

DUST FREE TIME:

30 min @ 77° F

Handling & Storage

As with all polyester resin, rate and degree of cure are a function of initiator concentration and of temperature. Resin and work area should be between 70°F and 95°F to ensure satisfactory results. Initiator levels should be within a range of 1.0-3.0% based on weight of resin. The use of initiator levels outside of this range may result in an inadequate cure, with laminates exhibiting moderate to severe post cure after de-molding.

Orca Surface Primer is available in 55-Gallon metal drums.

To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers at temperatures below 75°F and away from heat sources and sunlight. All storage areas and containers should conform to local fire and building codes. Drum stock should be stored away from all sources of flame or combustion. Inventory levels should be kept to a reasonable min with first-in, first-out stock rotation.

Safety

Read and understand the Material Safety Data Sheet before working with this product

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