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## TECHNICAL DATA

### SilverTip™ 2-part Epoxy Yacht Primer

**Description:** SilverTip Yacht Primer is a waterborne, two-component epoxy/polyamide primer. It cures to an, easily-sanded surface for adhesion to System Three topcoats. For marine applications, the SilverTip Yacht Primer can be applied above or below the waterline. SilverTip Yacht Primer will also seal fairing or other filler work prior to topcoating or application of anti-fouling paint.

**Recommended Uses:** For marine use on properly prepared substrates such as:

- Epoxy resin-coated surfaces
- Fiberglass Gelcoat
- Wood\*
- Concrete
- Previously-painted surfaces

\*See detailed information under coating wood below.

Primer can be applied by brush, roller, or spray. Surfaces can be recoated in as little as 2-3 hours.

#### Product Characteristics:

- Volume Solids: 36%
- Weight Solids: 52%
- Color: Gray
- Mixed VOC: <200 g/l
- Mix Ratio: 4:1
- Potlife: Use within 3 hours
- Induction: Let mixed primer stand 15 minutes before use
- Application Conditions: 55°F (13°C) minimum, 95° F (35°C)
- Clean Up: Water
- Dry to Prime: 2-3 hours@70°F
- Dry to Paint: 24 hours@70°F

**Coverage:** 3 coats are recommended for best results at 250-350 sq. ft. per gallon. Some porous substrates may require additional coats of SilverTip Yacht Primer.

- Wet film thickness per coat: 4.5-6.5 mils
- Dry film thickness per coat: 1.5-2.5 mils

**Surface Preparation:** Surface must be clean, dry, and free from oil, grease, or wax contaminants to ensure adequate adhesion of the SilverTip Yacht Primer. If using top coats other than those from System Three, pre-

testing is recommended to make certain good adhesion is present. Bare wood must be pre-sealed with marine epoxy resin if a waterproof surface is desired.

**Epoxy resin-coated surfaces:** Some epoxy resin systems leave an amine blush on the surface. Amine blush can interfere with the adhesion of the SilverTip Yacht Primer. Remove surface blush by using a Scotch-Brite pad with detergent and warm water. Then flush the surface with fresh water.

1. Sand the epoxy surface with 100-120 grit paper.
2. Fill surface imperfections with SilverTip Quikfair. Sand repair areas until smooth using 100-120 grit paper.
3. After sanding, vacuum or with clean, dry shop air remove sanding dust.
4. Wipe the surface with denatured alcohol and clean rags.
5. Apply SilverTip Yacht Primer with roller and brush, or by spray application. At 70 degrees SilverTip Yacht Primer can be recoated without sanding in as little as 2-3 hours. After 72 hours, the SilverTip Yacht Primer must be sanded, use 220-320 grit paper. Repeat steps 4-5.
6. 2-3 coats of SilverTip Yacht Primer are necessary to achieve a smooth, uniform surface.
7. After 24 hours @ 70 degrees, the SilverTip Yacht Primer can be top coated. First sand with 220-320 grit paper. Repeat steps 3-4.

#### Fiberglass Gelcoat:

Polyester gelcoats often have mold release agents as well as wax contamination on the surface. SilverTip Yacht Primer can be successfully applied over polyester gelcoats provided the surface is free from contaminants and well sanded.

1. The surface should be cleaned thoroughly using a Scotch-Brite pad with detergent and warm water.
2. Follow with a wax stripper. Flush the surface with fresh water.
3. Once the surface is thoroughly clean, sand using 80-100 sandpaper.
4. Fill surface imperfections with SilverTip QuikFair. Sand repair areas until smooth with 100-120 grit paper.
5. After sanding, vacuum or with clean, dry shop air, remove sanding dust.
6. Wipe the surface with denatured alcohol and clean rags.
7. Apply SilverTip Yacht Primer with roller and brush, or by spray application. At 70 degrees SilverTip Yacht Primer can be recoated without sanding in as little as 2-3 hours. After 72 hours, the SilverTip Yacht Primer must be sanded, use 220-320 grit paper.
8. 2-3 coats of SilverTip Yacht Primer are necessary to achieve a smooth, uniform surface.
9. After 24 hours @ 70 degrees, the SilverTip Yacht Primer can be top coated.

**Wood:**

The substrate must be clean, dry (verify with moisture meter with levels no higher than 14%). Wood components that have insufficient epoxy sealing are likely to fail due to moisture cycling. Usually, 2-3 coats of a clear epoxy are needed to seal the wood, and preventing moisture cycling. Additionally, the substrate must be structurally sound with minimal deflection.

1. Sand the raw wood using 80-100 grit sand paper.
2. Clean sanding dust from the surface using a vacuum and clean, dry shop air.
3. Fill surface imperfections with SilverTip QuikFair. Sand repair areas until smooth using 100-120 grit paper.
4. Repeat step 2
5. Epoxy seal all surfaces with at least 2-3 coats. Some Porous wood species may require additional coats.
6. See "Epoxy resin-coated surfaces".

**Concrete:**

Concrete must be cured for at least 30 days @ 75 degrees. A calcium chloride test is recommended to ensure that excess moisture vapor is not emitting from the concrete. Large areas should be tested in multiple spots. Moisture vapor transmission levels should not exceed 3 lbs. /1,000sq. ft. /24 hours.

The concrete must also be free from contaminants such as grease and oil before the surface preparation can begin.

Note: It's highly recommended to test the SilverTip Yacht Primer with the topcoat in an inconspicuous area, to ensure the results meet your expectations.

1. Acid etch or shot blast the surface.
2. Thoroughly clean foreign material from the concrete
3. Apply SilverTip Yacht Primer with roller and brush, or by spray application. At 70 degrees SilverTip Yacht Primer can be recoated without sanding in as little as 2-3 hours. After 72 hours, the SilverTip Yacht Primer must be sanded, use 220-320 grit paper.
4. 3-4 coats of SilverTip Yacht Primer are required. In some cases, more coats may be necessary due to a high degree of porosity.
5. After 24 hours @ 70 degrees, the SilverTip Yacht Primer can be top coated. First sand with 220-320 grit paper.
6. After sanding, vacuum or with clean, dry shop air remove sanding dust.
7. Wipe the surface with denatured alcohol and clean rags.

**Previously-painted Surfaces:**

Remove any peeling or flaking paint from the surface to be primed. When previously-coated surface is sound, proceed to surface preparation steps for the appropriate surface listed above for any areas where coating has been completely removed. Sand any remaining painted areas with 120-150 grit sandpaper and proceed with primer application.

**Mixing:** Stir contents of hardener Part B thoroughly to remix any settled material. Mix 4 parts Hardener Part B with 1 part resin Part A by volume and stir thoroughly.

**Mix only enough material which can be used well within 3 hours @ 70°F.** Higher temperatures will reduce pot life, while cooler temperatures will increase pot life. Allow material to set for 15 minutes before use.

**Application:**

**Brush / Roller:** Use a high quality synthetic bristle brush or short nap roller made for waterborne paints. No reduction is necessary for application.

**Conventional Pressure Pot**

- Pot Pressure: 10-15 psi
- Atomization Pressure 25-30 psi
- Tip: 1.4 – 1.8 mm tip
- Reduction: As needed, up to 15% (Denatured alcohol or water)

**Airless Spray:**

- Pressure: 2700-3000 PSI
- Hose: ¼" ID
- Tip: .013" - .015"
- Reduction: As needed, up to 15% (Denatured alcohol or water)

**Notes:**

- Store in moderate environment, and prevent from freezing. If product has frozen, do not force thaw; allow to thaw at room temperature.
- Cover any outdoor work to prevent dew from forming on the uncured primer surface.
- Clean brushes, rollers, and spray equipment promptly after the application.
- If using top coats other than System Three, testing is recommended to ensure that proper adhesion is occurring.

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