TOPKOTE

Product Data Sheet

NuCharge It Low VOC Epoxy Primer

Base: 214D7185B; Hardener 214X4444A

PRODUCT DESCRIPTION

Type Electrostatically applied two component epoxy primer.

Description **NuCharge It Low VOC Epoxy Primer** is a two-component, high performance epoxy primer designed for use on all metals where extra protection and durability is needed.

Uses

- Metal Buildings
- Aluminum Extrusions
- Wrought Iron railings and fencing
- Exterior furniture, recreational equipment, and machinery

Features

- Can be used as a primer with **NuCharge A-Thane II Polyurethane** or **NuCharge It Low VOC Epoxy** for extended durability.
- V.O.C. less than 2.8 lbs. / gal.
- Long pot life of 8 hours

SUBSTRATE & SURFACE PREPARATION

All Substrate must be clean, dry and free of contaminants.

Steel & Iron The minimum surface preparation for steel and iron is Hand Tool Cleaning per SSPC-SP2. Power Tool Cleaning per SSPC-SP3 is preferred for better performance. Prior to either procedure, the surface should be solvent cleaned per SSPC-SP1. Feathering around scratches is recommended because certain surfaces may lift when coated. A quick test should be conducted in an inconspicuous area to determine if a base coat should be removed or primed.

Galvanized **NuCharge It Low VOC Epoxy Primer** works great over aged galvanized surfaces. If painting new galvanized metal, it is important to determine if the galvanizer performed passive quenching of the galvanized substrate. The quenching process will interfere with adhesion of paint, so if it is known that the metal is to be painted, notify the galvanizer and ask that the quenching NOT be done. Removal will be required by either aging for several months or a uniform sweep blast. A professional blaster should perform the operation to blast so that care is taken NOT to remove the protective zinc finish. Once removal is done and cleaning the substrate is complete, priming with **NuCharge It Low VOC Epoxy Primer** is ideal.

MIXING & THINNING

Ratio 2 – components. Mix base and cure components at a 1:1 ratio. The curing agent is **214X4444A, and the base is 214D7158B**. Ensure both components are above 45°F before mixing and using. Allow 20 minutes induction time before using.

Mixing Mix the base and component thoroughly before use by boxing or with mechanical agitation.

Thinning Thinning is not normally needed. Add **560X1557 NuCharge It VOC Exempt Reducer** as required. Add 3-4 ounces of **480X9999 Roll-A-Glaze** per mixed gallon to reduce dry spray and orange peel, if required. **480X9999 Roll-A-Glaze** can be added to help add a wet edge for spraying large parts and to aid in brush and roll applications.

Pot Life 8 hours sprayable @ 77°F.

Cleanup Use NuCharge It Reducer (**560X2005**).

APPLICATION GUIDANCE

Application Conditions Excessive film or surface contamination may cause adhesion problems and solvent entrapment. DO NOT USE IN HEATED AIRLESS EQUIPMENT, as gelling will occur.

Brush Brush application in small areas

Roller Short nap or mohair phenolic core roller. Thinning is not normally needed. Add **560X1557 NuCharge It VOC Exempt Reducer** as required. Add 3-4 ounces of **480X9999 Roll-A-Glaze** per mixed gallon to reduce dry spray and orange peel, if required.

Spray This product may be applied by electrostatic, conventional, HVLP, and airless equipment.

CURE TIME & RECOAT WINDOW

Substrate Temperature	To Touch	Tack Fee	To Recoat	Full Cure
75°F (24°C)	1 hour	2 hours	4-5 hours	7 days

Drying times are dependent upon film thickness, temperature and humidity.

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PACKAGING, ESTIMATING & HANDLING

Product	Code	Packaging
NuCharge It Low VOC Epoxy Primer	214D7185B	1-gallon pails
Low VOC Epoxy Semi-gloss catalyst	214X4444A	1-gallon pails

Theoretical Coverage

167-344 ft^2 / catalyzed gallon @ 2.0 – 4.0 mils dry film thickness.

Storage & Shelf Life

Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 2 years when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions.

Safety

Mixes and applications of this product present several hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.

Ventilation

Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.

TYPICAL PHYSICAL PROPERTIES

Property	Typical Value
Specific properties below are of mixed kit.	
Colors	Gray
Gloss	Satin
Pot Life	6 hours *Do not use catalyzed material that has exceeded its pot life.*
Volume Solids	42%
Viscosity	17-22" Zahn 3
Recommended DFT	167-344 ft^2 / catalyzed gallon @ 2.0 – 4.0 mils dry film thickness.
Flash Point	Mixed 64.0°F
VOC	<2.8 lbs. / gal. (334 g/L) mixed
Weight / gallon	11.3 lb./gal. base component
Temperature Resistance	250°F
Shelf Life	2 years unopened and unactivated

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