

Epoxy Primer 1:1

(IMP 4700/4710/4701)

Epoxy Primer

DESCRIPTION:

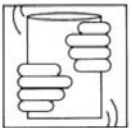
IMP 4700 Epoxy Primer 1:1 is a fast dry, fast curing epoxy that has excellent corrosion resistance and adhesion. This epoxy primer can be used on all properly prepared metals and plastics. **IMP 4700 Epoxy Primer** can be topcoated with any topcoat system including acrylic lacquer. Available in quarts and gallons in two colors for increased basecoat hiding. (**4700** gray and **4710** black)



FEATURES:

- ✓ Can be topcoated in 30-60 minutes @ 72°F (22.2°C)
- ✓ Can be used as a primer surfacer or a sealer
- ✓ Excellent corrosion resistance even in harsh environments
- ✓ Superior humidity resistance
- ✓ Simple 1 to 1 mix ratio
- ✓ Tintable
- ✓ Excellent color hold-out
- ✓ Superior adhesion to bare steel, sanded fiberglass and etched or sanded aluminum
- ✓ Economically priced

INSTRUCTIONS:



Shake Epoxy Primer thoroughly before mixing.

GUN SETUP:

| | | |
|----------------------|--------------|-----------------|
| | 1.6mm -1.8mm | 40-45 psi @ gun |
| Conventional Gravity | 1.6mm -1.8mm | 40-45 psi @ gun |
| Siphon | 1.6mm -1.8mm | 8-10 psi @ gun |
| HVLP gravity | | |



MIXING:

Mix 1 part **IMP 4700/4710 Epoxy Primer** to 1 part **IMP 4701 Epoxy Primer Activator**



SURFACE PREPARATION:

Wash area with soap and warm water. Thoroughly clean area with **Wax and Grease Remover**. **Water Base Pre-clean** can be used where VOC restrictions are in effect. All corrosion should be removed and metal prepared as for any paint application. Old finishes must be properly sanded and cleaned with **Wax and Grease Remover** (or equivalent). Aluminum must be thoroughly sanded or etched before applying **4700/4710 Epoxy Primer**





APPLICATION:

Apply 1-2 full wet coats of **Impact Epoxy Primer 1:1** using a good quality spray gun with a 1.6 to 1.8 tip. Allow 10-15 minutes flash time between coats. Dry film thickness should be .75-1.0 mils. Allow 30-60 minutes @ 70°F (21°C) air dry before topcoating. Allow 60-90 minutes @ 70°F (21°C) cure time before applying polyester body filler over **Impact 4700/4710 Epoxy Primer**.



SANDING:

Allow **Epoxy Primer** to thoroughly cure for 24 hours before lightly sanding

TECHNICAL DATA

| | |
|---------------------------------|------------------------------------|
| Color | Gray & Black |
| Activator/Hardener | IMP 4701 |
| Reducer | (adding reducer will increase VOC) |
| Mix Ratio | 1:1 Reducer Optional |
| Pot Life | 8 hrs @ 70°F(21°C) 50% RH. |
| Number of Coats | 1-2 |
| Dry film Thickness (DFT) | 0.75-1.0 mil |
| Flash Time | 10-15 minutes |
| Recoat w/o sanding | 30-60 minutes |
| Dry to Sand 70°F(21°C) 50% RH | 24 hours |
| Air Dry 70°F (21°C) 50% RH | 30-60 mins. @70°F (21°C) |
| Gun Set-Up Gravity Feed (HVLP) | 1.6mm – 1.8mm |
| Air Pressure @ Gun HVLP | 8 – 10 psi |
| Air Pressure @ Gun Conventional | 40 -45 psi |
| V.O.C. Limit | 5.0 lbs/gal (600 g/l) |
| Sprayable V.O.C.* | 2.92 lbs/gal (318 g/l) |
| % Solids Sprayable by Weight | 33% |
| Coverage Sq. Ft. / gal @ 1 mil* | 389 sq. ft. |
| Shelf Life | 12 months |



(Note) The topcoat window of Epoxy Primer is 30 minutes to 24 hours. After 24 hours the primer must be scuffed or lightly sanded before topcoating. After 72 hours sand, re-apply and then topcoat.