INTRODUCTION TO EPOXY PRIMER

In the restoration process, epoxy primer is used to set the foundation for corrosion protection, preparing the entire project for the processes that follow. If parts are too large to prime in the given timeframe, consider working on individual parts or smaller areas.

EPOXY PRIMER

* Should be sprayed over metal or aluminum that has been treated with metal treatments\* after dried and within 8 hours.
* **Sand blasted or sanded metal should be epoxy primed within 30 minutes at 50% humidity to prevent rust from starting.**
* Epoxy primer will not stop or neutralize any rust that has already started or is already present.

SPECIAL NOTES

* Epoxy primer needs to be applied within 30 minutes of paint removal, especially in humid conditions. If this is not possible, consider working on individual parts or smaller areas of the project to meet this timeframe. Using the metal treatment system will expand the working timeframe.
* Untreated steel and aluminum should be coated with a minimum of 3.0 mils wet (1.5 mils dry) of epoxy primer for corrosion resistance.
* Steel and aluminum treated with PPG’s metal treatment system, should be coated with a minimum of 1.0 mils wet (0.75 mils dry) of epoxy primer for corrosion resistance.

\*Metal treatments cannot be used in some areas due to VOC or heavy metal restrictions. Refer to local regulations.

**EPOXY PRIMER AND BODY FILLER**

* One coat of epoxy primer must dry 1 hour before body filler application.
* Two coats of epoxy primer must dry overnight before body filler application.
* Epoxy can be scuffed or lightly sanded before applying body filler.
* For more specific instructions, refer to PD-1180 in this manual.

**REMINDER—APPLY EPOXY PRIMER PROMPTLY**

* Bare steel starts to rust in as little as 30 minutes at 50% humidity.
* Aluminum starts to oxidize in 8 hours after sanding.
* Do not touch metal with bare hands before applying epoxy primer.

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