



TECHNICAL DATA SHEET

P90 HS GRAY EPOXY PRIMER

07202021



P90 is a 2K, VOC compliant, high build, anti sag epoxy primer with built in corrosion resistance and excellent adhesion onto properly prepared hot or cold roll steel, aluminum and many other non-ferrous metals, fiberglass and over properly prepared 2K painted surfaces



COMPONENTS

- P90 Primer
- R60/70/85 Fast/Medium/Slow National Rule Reducers
- H50 Hardener



MIXING RATIO

One (1) part P90 Epoxy Base to one (1) part H50 Epoxy Hardener. Reduce 0%-25% with selected reducer.



POT LIFE

N/A



CLEAN UP

Use Lacquer Thinner or zero VOC solvents. (Check local regulations)



PHYSICAL DATA

Solids wt. 66.2%
 Volume wt. 47%

VOC

Coating: 2.1 lbs/gal - 252 g/l
 Material: 1.7 lbs/gal - 204 g/l



DRY / FLASH TIMES

Dust Free: 20-30 minutes @ 68°F/20°C
 Dry to Touch: 3-4 hours @ 68°F/20°C
 Total Hardness: 48 hours @ 68°F/20°C
 Force Dry: 30 minutes @ 140°F/60°C



GUN SETUPS

HLVP Gravity Feed 1.4 mm – 1.7 mm
 Pressure Pot HLVP 1.0 mm – 1.2 mm
 Air Assist Airless 1.0 mm - 1.2 mm
 Conventional 1.5 mm - 1.8mm



SURFACE PREPARATION

Use HyMax Clean Wipe (S01) to clean substrate free of grease, dirt, and foreign contaminants.

Ferrous Metals

Best:
 SA2 sandblast Blow all dust and contaminates off and apply P90 primer within 8 hours.

Better:
 Hot Phosphate wash system, blow dry and apply P90 primer Within 8 hours.

Good:
 Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply P90 primer within 4 hours

Aluminum: Clean surface with clean drying wax and grease remover, apply P90 Epoxy Primer within 4 hours.

Galvanized Steel: Clean all dust, oil residue, and contaminates from surface using a Clean drying wax and grease remover. Light Sanding (320P grit) Clean again with clean drying wax and grease remover using a wipe and dry process. Only suitable if P10 Primer is applied first.



APPLICATION AT 77° F/25°C

• One to three medium wet coats, allow 10-20 minutes flash between coats.



SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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