

PRO TECH™

PRODUCTION PAINT COATINGS

PRODUCT DATA

Armor Tech™ ProPoxy Prime Epoxy 1670-series modified polyamine epoxy

PRODUCT DESCRIPTION

A high performance epoxy primer designed for corrosion protection on ferrous metal surfaces where optimum surface preparation may not be feasible. A fast curing, direct to metal, surface tolerant coating. Lead and chromate free. Low VOC.

TYPICAL USES

For industrial and commercial use for the protection of ferrous metal surfaces where fast recoat is desired in a high performance protective coating system. Designed for long life protection of areas exposed to moderate to severe industrial exposures. Provides excellent protection to structures subject to mechanical abuse. Excellent primer for epoxy and urethane finishes.

PRODUCT ADVANTAGES

Excellent resistance to fresh and salt water, detergents and many chemicals. Very good resistance to fumes and spillage of most organic solvents, acids and alkalies. Excellent abrasion and moisture resistance. Excellent adhesion to ferrous metal.

COLORS

Gray 812, Buff 165, White 155, Black 111

GLOSS

Eggshell

PHYSICAL CONSTANTS

Nonvolatile - By weight - 62.9 ± 1.0%
By volume - 43.6 ± 1.0%
VOC (Calculated) - 3.1 lbs./gal.
372 grams/liter
Flash Point - 60°F (Setaflash)
Mixing Ratio - 4:1 by volume
Weight per gallon - 10.3 ± 0.2 lbs. (mixed)

APPLICATION

Recommended Film Thickness per coat - 2.0 mils dry, 4.6 mils wet
Theoretical Coverage @ 2.0 mils dry - 350 sq. ft./gal.

Method - Conventional spray, air assisted airless or airless spray

Thinner - Epoxy Thinner #914 or #915

Cure Time @ 75°F - Recoat - 30 minutes *
Dry Hard - 4 hours
* refer to "Recoat" section on back

Pot Life @ 75°F - 5 hours minimum.

Induction Time Above 75°F - 15 minutes
60 - 75°F - 30 minutes
below 60°F - 1 hour

SHIPPING & STORAGE

| | | |
|---|---------------|---------------|
| Consists of - | 1 Gallon Unit | 5 Gallon Unit |
| Component A | 1 Gallon (SF) | 5 Gallon (SF) |
| Component B (1670-255) | 1 Quart (SF) | 1 Gallon |
| Unit Shipping Weight (SF) - short filled) | 12 lbs. | 59 lbs. |

Shelf Life - 12 months minimum from date of manufacture when maintained in protected storage @ 40-100°F (subject to reinspection thereafter).

APPLICATION INSTRUCTIONS

Consult your Mobile Paint Pro Tech Representative for the protective coating system best suited for your requirements.

Limitations: For best results, apply in good weather when air and surface temperatures are above 50°F and surface temperature is at least 5°F above the dew point. May be applied in temperatures as low as 40°F with extended curing time. For optimum application properties, material should be between 70 to 100°F prior to mixing and application. Maintain unmixed material in closed containers in protected storage at 40 - 100°F.

Surface Preparation - Good surface preparation is essential for maximum performance of all high performance, direct to metal coating systems. Near white blasting provides surface preparation for maximum performance. However, where conditions and costs dictate that blasting is not possible, Armor Tech™ ProProxy Prime will provide excellent protection over less than ideally prepared substrates. Surfaces to be coated should be clean and dry.

At a minimum, remove all oil, grease, water, salt, dirt, loose rust, and all rust scale. It is important that rust scale is completely removed by high pressure washing, grit sweeping, mechanical descaling tools or other effective means. For non-immersion service, surface preparation should conform to SSPC-SP2 "Hand Tool Cleaning". If any very rusty surfaces remain, prepare with Armor Tech™ Epoxy Pre-Prep. Not recommended for immersion service. For maximum performance in critical areas of high moisture, condensation, chemical splash or spillage, or immersion, surface preparation should conform to SSPC-SP-10 "Near White Blast Cleaning". For longest service life, it is recommended that the coated area be visually inspected after approximately 6 months service for any rust spots. If any rust spots are found, power sand to metal and touch up with Armor Tech™ ProProxy Prime.

Mixing - Armor Tech™ ProProxy Prime is supplied in 2 containers as a unit. Always mix a complete unit in the proportions supplied. (1) Agitate Part A with power agitator. (2) Agitate Part B with power agitator. (3) Combine entire contents of Part A and Part B and mix thoroughly with power agitator. (4) Allow to stand for 15 minutes and remix before application. Usable pot life depends on the temperature of the material. Refer to Pot Life section on front page.

Thinning - Material is supplied at airless spray viscosity and should not require thinning. If thinning is necessary, thin with Epoxy Thinner #914 or #915 per gallon. Do not thin beyond local VOC and air quality regulations.

Application - Spray application is preferred for proper film build and best performance. Brush application is acceptable for touch up. Roller application is not recommended. Apply at 4.6 mils wet film thickness to achieve 2 mils dry film thickness.

Recoat - Air and/or surface temperature below 75°F or dry film thickness application above 2.0 mils require longer dry time prior to recoating. Addition of thinner to product for application may also lengthen dry time to recoat. Evaluation of product under final conditions of use should be undertaken to ensure adequate performance.

Equipment - Armor Tech™ ProProxy Prime can be applied by airless, air assisted airless or conventional spray equipment. Power agitated pots are recommended. Airless spray - Minimum of 30:1 ratio pump, .011"-.015" tip, 3/8" ID material hose. Conventional spray - DeVilbiss MBC gun with E tip and 30 air cap or equivalent at 35-45 psi atomizing pressure and 10 psi pot pressure, 3/8" ID product hose.

Note: During lunch, breaks or any period of work stoppage, material should be removed from hoses and equipment. Release pressure from equipment and flush hoses and equipment with Epoxy Thinner #914 or #915, or ketone solvents. Do not repressurize equipment until ready to resume work.

Cleanup - Clean all equipment immediately after use with Epoxy Thinner #914 or #915 or MIBK. Completely flush all spray equipment with either of these solvents. Occasional flushing of spray equipment during the course of the working day helps prevent buildup and possible clogging.

Safety - Safe storage, handling and use dictate that adequate health and safety precautions be observed with this product and any recommended thinners. User is specifically directed to consult the current Material Safety Data Sheet for this product as well as precautions contained on product labeling.

Notice - The technical data contained herein are true and accurate to the best of our knowledge. All products are offered and sold subject to Mobile Paint Manufacturing Company's Standard conditions of Sale. Published technical data and instructions are subject to change without prior notice.

ArmorTech1670(4/04)

LIMITED WARRANTY

The successful performance of this product is highly dependent on many factors beyond our control. Results are highly dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Mobile Paint warrants that its products meet the specifications which it sets for them. Should this product be proven to be off-specification within one year from date of shipment, Mobile Paint will, at its sole discretion, either replace the product or issue credit for the original purchase price of the product. The replacement or refund shall be the buyer's sole remedy and Mobile Paint and its affiliates **MAKE NO OTHER WARRANTY OR GUARANTEE, EXPRESS OR IMPLIED, INCLUDING MERCHANTABILITY, DESIGN COMPATIBILITY AND FITNESS FOR A PARTICULAR PURPOSE. LABOR OR COST OF LABOR AND OTHER INCIDENTAL AND/OR CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED.** The technical data contained herein are true and accurate to the best of our knowledge. Published technical data and instructions are subject to change without prior notice.