



## LV Epoxy Primer Base

LV Epoxy Primer Base is a 2K chromate free primer surfacer with excellent adhesion to any metal substrate. It's easy to sand, inhibits corrosion, and has excellent flexibility. This is a tintable primer base and can be used to make any of the more than 15,000 colors in the Paladin Industrial Coatings range. This primer can be used under any Paladin topcoat.



### Mix Ratio

4:1 – 4 parts 19-339-01 Primer Base and 1 part 19-242-04 LV Primer Hardener. Can be reduced up to 20% using Paladin Zero VOC Reducers.



### Suitable Substrates

- Mild steel & steel alloy surfaces
- Galvanized steel
- Stainless steel grade 316
- Sound existing coatings
- Aluminum, zincalume, zincanneal
- Glass reinforced polyester (GRP & general types of fiberglass body parts)



### Surface Prep & Application

Sand and clean all areas prior to application with SCAT Wax & Grease Remover. Ensure all residue is removed prior to application. Lightly rusted surfaces must be treated with a Metal Converter.

Apply 1 coat followed by 2 medium wet coats. Avoid heavy wet coats.



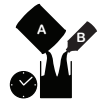
### Flash/Dry Times (Air Dry) @ 77°F (25°C)

Flash Between Coats: 5 minutes.

Air Dry: 3 – 4 hours.

Bake: 30 – 40 minutes at 122°F (50°C).

Must be topcoated within 24 hours.



### Pot Life

6 hours @ 77°F (25°C).



### Sanding:

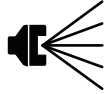
Wet sand with 600 – 800 grit before applying finish coat.

Dry sand with 500 – 800 grit before applying finish coat.



### Gun Set-up

Gravity Feed	2.0 mm
Suction Feed	2.0 mm
HVLP/LVLP	1.5 – 1.8 mm



### Air Pressure

Gravity/Suction Feed	30 – 35 psi at the gun
HVLP/LVLP	6 – 10 PSI at the gun



### Technical Data & Physical Properties

Mix Ratio.....	4:1	Pot Life .....	6 hours
Theoretical Dry Film.....	325 ft <sup>2</sup> @ 1.0 mil	Dry Film Thickness .....	1.6 – 2.0 mils
Volume Solids .....	49.5%	Weight Solids.....	71.04%
Actual VOC .....	2.66#/gal (319g/l)	Regulatory VOC.....	3.35#/gal (401g/l)
Viscosity (RTS).....	BSB 4 Cup 17 – 19 sec; Ford 4 Cup 15 – 17 sec		

Shelf Life – 36 months minimum from date of manufacture in an unopened container at room temperature away from sunlight.



### Limitations

Stir all components thoroughly each time before use.  
Surface temperature must always be a minimum of 37°F (3°C) above dew point.  
Ensure complete removal of any residue of rust converter before applying primer.



### Safety

Read all directions, safety warnings and SDS before using any Paladin Industrial Coating Products. **For use by professionally trained painters only. Not for sale or use by the general public. Keep out of reach of children.**

#### LIMITED WARRANTY

The successful performance of this product is dependent on many factors beyond our control. Results are dependent upon the skill of the operator. This product is manufactured to meet the highest level of consistency and quality for the intended use. Paladin Industrial Coatings 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, Paladin Industrial coatings 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 Paladin Industrial Coatings 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.