



Epoxy Primer SE-678

DESCRIPTION:

SE-678 Epoxy Primer 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. **SE-678 Epoxy Primer** can be topcoated with any topcoat system including acrylic lacquer.

V.O.C. Compliant in North America at 2.1 V.O.C.

FEATURES:

- Can be topcoated in 45-60 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 4 to 1 mix ratio
- Tintable (up to 10%)
- Excellent color hold-out
- Superior adhesion to bare steel, sanded fiberglass and etched or sanded aluminum
- Sandable

SURFACE PREPARATION:

Wash area with soap and warm water. Thoroughly clean area with **1235 Wax and Grease Remover** or **1237 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 **1235 Wax and Grease Remover** (or equivalent). Aluminum must be thoroughly sanded or etched before applying **SE-678 Epoxy Primer**. Sand area according to body filler manufacturer's recommendations. Reclean with **Wax and Grease Remover** or **1237 Water Base Pre-clean**

Mix Ratio:

Mix 4 part SE-678 Epoxy Primer to 1 part with SE-679 Catalyst

(Optional) **SE-678 Epoxy Primer** can be reduced 5-10% with Urethane Grade Reducer.

Adding reducer will increase sprayable V.O.C.'s and decrease dry film thickness (DFT)

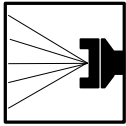
(Note) For spray temperatures over 100°F (37.8°C) and 1 oz. of **Retarder Solvent** to improve flow, leveling and cure through.

(Note) Do not apply synthetic enamels over **SE-678 Epoxy Primer**.



Application:

Apply 1-2 full wet coats of **SE-678 Epoxy Primer** 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. **SE-678 Epoxy Primer** can be baked for 20 minutes @ 140°F (60°C). Allow 60-90 minutes @ 70°F (21°C) cure time before applying polyester body filler over **SE-678 Epoxy Primer**



Gun Setups:

Gun Set-Up Gravity Feed
(HVLP) 1.6mm – 1.8mm



Air Pressures:

Air Pressure @ Gun HVLP 8 – 10 psi
Air Pressure @ Gun Conventional 40 -45 psi



Technical Data & Physical Properties:

Color:	Gray	
Catalyst:	SE-678	
Mix Ratio	4:1	Reducer Optional
Pot Life 4 hrs @ 70°F(21°C) 50% RH.		Sprayable V.O.C.* 2.1 lbs/gal
Number of Coats : 1-2		Dry film Thickness (DFT) 1.5-2.0 mil
Flash Time 10-15 minutes		Recoat w/o sanding 48-72 Hrs
Dry to Sand 70F(21C) 50% RH 24 hours @70°		Air Dry 70°F (21°C) 50% RH 30-60 mins.
Force Dry 20 mins. @140°F (60°C)		Solids by 49.65 w/w % By Weight
Coverage Sq. Ft. / gal @ 1 mil* 389 sq. ft.		Solids by 60.24 v/v % By Volume

**(Note) The topcoat window of SE-678 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 SE-678 and then topcoat.**