SP HIGH HEAT AMBIENT PRIMER is a two-part (A&B) hybrid epoxy resin.

SURFACE PREPARATION
Surface must be clean from oil, tar, rust, grease, salts and films.
1) Use solvent (xylene), if needed, to remove residues.
2) Clean using TSP (Tri-sodium phosphate) or a citrus cleaner to release dirt and degreaser residue.
3) Pressure-wash if possible with 35psi (250 bar) pressure.
4) Salt contamination on a surface can come as a result of salt water, salt air from sea, fertilizer and car exhaust. Use Chlor-Rid or equivalent to decontaminate surfaces if salts are present. Acceptable levels: Nitrates: 5-10 mcg/sq.cm., Sulfates: 5-10 mcg/sq.cm and Chlorides: 3-5 mcg/sq.cm.

MIXING
1) Blend part A & B as packaged, and stir for 3 minutes.

TEMPERATURE
1) Apply between 40°F (4°C) and 150°F (65°C).
2) Maximum temperature for continuous use when cured is 1292°F (700°C). Store product between 32°F (0°C) and 122°F (50°C) according to SDS.

APPLICATION
SP HIGH HEAT AMBIENT PRIMER can be applied by brush, roller or spray.
1) If application by brush, use a soft bristle brush for solvent-base coatings.
2) If application is by roller use a 3/8-inch (9mm) nap for solvent base coatings.
3) If spraying use a standard air pot system at 60 psi (5 bar) pressure or an airless machine pumping 2.5-4.0 gal/min with a 29-31-thousands tip (0.75mm).

MINIMUM SPREAD RATES
4 coats: Each coat is applied at 250 sqft (23.2 sqm) per gallon will give a 5.7 mil (143 micron) dry thickness. Allow two (2) hours between coats.

Apply four (4) coats for a total of 23 mils (570 micron) dry thickness when finished.

CURE TIME
10-20 minutes to touch in 75°F (24°C) heat.