



CrossLink

Powder Coatings Inc.



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Epoxy / Hybrid Primers

Epoxy/Polyester Hybrid Primer Powder Coating is a primer undercoat. It should be used when added corrosion protection is needed to provide increased resistance to chemical attack in coastal and marine environments. It can also be employed when the substrate has surface imperfections that would adversely affect the quality of the ensuing topcoat. This coating should not be used as an exterior topcoat, and should be topcoated with a Crosslink exterior grade of powder coating.



Storage Stability:

The maximum storage temperature for this coating is 75°F at 50% Relative Humidity. Under these conditions, a shelf life of 12 months is expected.

Application:

Primer coatings must be undercured and then topcoated. Fully curing the primer and then topcoating may lead to lack of intercoat adhesion. They are designed to be applied by electrostatic spray – manual or automatic. Reclaim is acceptable, provided there is no incident of cross-contamination. When applying Primer Powder Coatings, some experimentation is typical with regard to gun kV settings and air velocities to maximize transfer efficiency and achieve a consistent coating thickness. Curing by means of gas fired convection oven with proper exhausting is the industry norm. Oven profiling is required to evaluate the cure process.

Disclaimer:

We urge you to consult with Crosslink and to perform your own tests to determine the suitability of this product for your particular purposes. The information contained herein is to the best of our knowledge, and is not intended to be exhaustive. It is intended to inform users of the general criteria regarding this coating. We have no control over either the quality or condition of the substrate, the processes of pretreat, application, or curing, or the many factors affecting the use, application or final installed environment of the coated product. We make no guarantee of results, and assume no liability for damages incurred by following these suggestions, or for misuse. We do not accept any liability whatsoever or howsoever arising from the performance of the product or for any loss or damage arising out of the use of the product. Any product liability shall be incurred in writing only. The information contained in this sheet is subject to modification from time to time due to experience and continuous product development.

Metal Preparation and Pretreatment:

A coatings performance is based directly on the pretreatment it receives. A multi stage cleaning and pretreatment system is required to prepare the substrate. A properly operating pretreat system will remove organic and inorganic surface soils, remove residual oxides, and apply a chemical conversion coating to which organic coatings will adhere. Pretreat chemical conversion solutions and rinses should utilize high purity water, and must be based on the substrate. Applicator pretreat solutions and processes must comply with the chemical supplier's procedures and guidelines. Frequent in-plant testing and control of pretreatment is required to insure satisfactory performance of the coating system.

Alternately, abrasive blasting is a process used to remove mill scale, old coatings, and oxides from ferrous and non-ferrous metals. The process leave a defined surface profile on the substrate. Chemical surface preparation may follow the blast procedure. Careful analysis is required to establish the appropriate pretreatment process.

Precautions:

All dusts are respiratory irritants. The coating area must be properly ventilated. If skin contact occurs, wash with mild, soapy water. If eye contact occurs, flush with water immediately and secure medical attention. Dust clouds of any finely divided organic material can be ignited by electrical sparks or open flames. All equipment must be electrically grounded to preclude buildup of static electricity. Ensure adequate oven ventilation when curing this product. See MSDS for further precautions.

Epoxy/Polyester Hybrid Physical Properties and Tests:

Cure Schedule, Peak Metal temperature:	3 minutes at 400 degrees F. to gel only, as a basecoat	
	10 to 25 minutes at 400 degrees F - full cure	
	20 to 30 minutes at 380 degrees F – full cure	
Specific gravity:	1.65 g/cm ³	
Film Thickness:	1.2 to 2.0 mils	
Specular Gloss Values:	75 - Using a 60 degree gloss meter per ASTM D 523	
Impact Resistance	ASTM D 2784	Pass - 160 in/lbs.
Mandrel Bend	ASTM D 522	Pass - 0.25 inch
Crosshatch Adhesion	ASTM D 3359-B	Pass – 5B with no removal
Pencil Hardness	ASTM D 3363	Pass – > 2H
Corrosion Resistance	ASTM B 117	Pass - 4,000 hours
Humidity resistance	ATM D 2247-94	Pass - 4,000 hours