

ARMOURSHIELD® PRIMER QUICK REFERENCE GUIDE

OEM FLEET: EPOXY PRIMERS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
CABS / TRAILERS	GRAY	EF72097P1	EF72090P2 EF72074P2	4:1 2:1.5	5.50	> 45 %	16 - 20	3.58	3.50	3 hours
CABS / TRAILERS	RED OXIDE	EF72108P1	EF72090P2 EF72074P2	4:1 2:1.5	5.50	> 45 %	16 - 20	3.58	3.50	3 hours
CABS / TRAILERS	GRAY & COLORS	EF75081P1	EF75071P2	4:1	3.00	> 50 %	6 - 10	3.50	1.70	3 hours
REFINISHING	COLORS	EF77000 SERIES	EF77000P2	3:1	1.75 +	> 60 %	5 - 6	1.90		3 hours

OEM HIGH BUILD: EPOXY PRIMERS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
HIGH BUILD	GREEN / GRAY	EF75064P1	EF75060P2	4:1	5.00	> 55 %	12 - 15	2.97	0.50	4 hours
HIGH BUILD	RED OXIDE	EF75001P1	EF75015P2	4:1	5.00	> 65 %	20 - 22	2.44	1.30	4 hours

OEM INDUSTRIAL: EPOXY PRIMERS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
GENERAL INDUSTRIAL	GRAY	EF72000P1	EF72000P2	4:1	5.00	> 40 %	16 - 18	4.11	2.60	3 hours
ZINC RICH	GRAY	EF75250P1	EF75250P2	4:1	8.00	> 50 %	7 - 10	3.31	3.30	3 hours

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RAILCAR: DTM EXTERIOR EPOXY PRIMERS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
TANK EXTERIORS ACID CAR	BLACK	EF75066P1	EF75055P2	4:1	4.00	> 55 %	20 - 25	2.99	0.95	NA
TANK EXTERIORS ACID CAR	BLACK	EF75133P1	EF75146P2	3:1	1.25	> 70 %	8 - 10	1.86	0.00	NA
TANK EXTERIORS ACID CAR	WHITE	EF75137P1	EF75146P2	4:1	1.00	> 70 %	6 - 8	1.88	0.00	NA
TANK EXTERIORS GENERAL	WHITE	EF75009P1	EF75055P2	4:1	4.00	> 60 %	15 - 20	2.46	0.26	NA
TANK EXTERIORS GENERAL	GRAY	EF75089P1	EF75055P2	4:1	4.00	> 55 %	20 - 25	2.93	1.55	NA
TANK EXTERIORS GENERAL	BLACK	EF75156P1	EF75146P2	3:1	1.50	> 75 %	5 - 7	1.66	0.55	NA

OEM TANK INTERIOR: EPOXY PRIMERS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
FERTILIZER TANKS	WHITE	EF72028P1	EF72028XP2	4:1	5.00	> 40 %	18 - 20	4.03	3.20	NA
GRAIN BINS	CRÈME	EF74766P1	EF74766P2	1:1	1.50	> 55 %	25 - 30	3.26	1.47	NA
TRANSFORMERS	WHITE	SP71449P1	EF71400P2	4:1	8.00	> 40 %	20 - 25	4.06	2.34	NA
TRANSFORMERS	WHITE	EF75006P1	EF75035P2	4:1	5.00	> 55 %	12 - 16	2.86	0.84	NA

EPOXY ESTER PRIMER										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
INDUSTRIAL	GRAY	EF90103	---	---	---	> 35 %	9 - 11	4.64	4.64	3 hours

TIME TO TOPCOAT: BEST DOI OF TOPCOAT BASED ON 6 MIL WET FILM BUILD OF PRIMER @ 70°F (21°C) AND 50 % RELATIVE HUMIDITY

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TINTABLE EPOXY PRIMERS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TOP TOPCOAT
TINTABLE	YELLOW	SP72093P1	EF72090P2	4:1	5.50	> 45 %	16 - 20	3.86	2.73	3 hours
TINTABLE	RED	EF72094P1	EF72090P2	4:1	5.50	> 40 %	16 - 20	3.98	2.50	3 hours
TINTABLE	BLACK	EF72095P1	EF72090P2	4:1	5.50	> 45 %	16 - 20	3.89	3.60	3 hours
TINTABLE	GRAY	EF72097P1	EF72090P2	4:1	5.50	> 45 %	16 - 20	3.58	3.50	3 hours
TINTABLE	BLUE	EF72098P1	EF72090P2	4:1	5.50	> 40 %	20 - 30	4.07	2.47	3 hours
TINTABLE	WHITE	EF72099P1	EF72090P2	4:1	5.50	> 45 %	16 - 20	3.86	2.62	3 hours

NOTE: EF72091P2 ACTIVATOR CAN BE USED FOR THE TINTABLE EPOXY PRIMERS IF FASTER CURE TIME IS REQUIRED

OEM FLEET: URETHANE PRIMERS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
CABS / TRAILERS	GRAY	EF06297P1	EF10200P2	6:1	2.00	> 40 %	4 - 5	4.32	0.85	30 minutes
CABS / TRAILERS	YELLOW	SP06336P1	EF10100P2	6:1	2.00	> 40 %	5 - 6	4.33	0.20	30 minutes

OEM HIGH BUILD: URETHANE PRIMER										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
HIGH BUILD	OFF WH	EF06536P1	EF10300P2	4:1	2.00	> 40 %	7 - 8	4.48	0.78	30 minutes
HIGH BUILD	GRAY	EF06428P1	EF12200P2	5:1	2.00	> 40 %	10 - 12	4.36	0.78	30 minutes
HIGH BUILD	RED OXIDE	EF06430P1	EF12200P2	5:1	2.00	> 40 %	10 - 12	>4.00	0.78	30 minutes

TIME TO TOPCOAT: BEST DOI OF TOPCOAT BASED ON 6 MIL WET FILM BUILD OF PRIMER @ 70°F (21°C) AND 50 % RELATIVE HUMIDITY

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OEM DTM: URETHANE PRIMER / TOPCOATS										
DESCRIPTION	COLOR	BASE	ACTIVATOR / HARDENER	MIX RATIO	POTLIFE (HOURS)	VOLUME SOLIDS	SAG	VOC	HAPS	TIME TO TOPCOAT
FRAME COATING	BLACK	EF06461P1	EF10200P2	5:1	2.00	> 35 %	8 - 10	4.57	1.42	NA
FRAME COATING	BLACK	EF06002P1	EF10100P2	5:1	2.00	> 30 %	10 - 12	4.82	4.82	NA
GENERAL PURPOSE	ALL	EF16000 SERIES	EF12800P2	3:1	2.00	> 45 %	7 - 12	+/-3.50	0.00 +	NA