



DESCRIPTION	Primer 460 SPX is a two-component polyurethane epoxy hybrid primer used to increase the adhesion of urethane elastomers to other elastomeric compounds or as a tie coat to fiberglass gel coats, fiberglass parts and some metal surfaces. Primer 460 SPX cures at ambient temperatures and provides strong bond that in many cases exceeds the strength of the elastomer. The primer may be applied by spraying, brushing or dipping. In service at ambient temperatures it is resistant to fresh and salt water, many chemicals and environmental conditions.																		
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MIXING AND APPLICATION	<p>Both primer components should be at room temperature before mixing. Primer 460 is a two-component material and equal amounts by volume of component A and component B must be mixed together until well blended. Once mixed, the primer will remain usable for two hours.</p> <p>Standard techniques used in airless paint spray work well with Primer 460 SPX. A proper size spray tip should be adjusted to obtain an even spray pattern at the lowest pressure. The primer should be applied in a thin wet coat beginning at the bottom of the item being primed. Runs should be avoided and excess primer should be wiped or brushed from the surface. Poor adhesion of the urethane elastomers to the metal will occur if the primer is applied too thickly. When applying the primer to an elastomeric or fiberglass substrate that has been roughened, the primer should be used to prepare the old elastomer surface to a "suede appearance".</p> <p>Substrates must be properly before primer is applied. For elastomeric substrates, loose elastomer must be cut away and all traces of oil, grease or dirt must be removed with a detergent or solvent. The surface must then be buffed with a wire wheel or very course sandpaper to produce a "suede-like" texture. Buffing too quickly or with too much pressure will create heat and produce an unacceptable sticky surface. All edges or joints should be tapered or "feathered". When Primer 460 SPX is used as a tie coat between urethane topcoats the first coat of primer should dry 30 minutes before topcoat or other urethanes and urethane base coats are applied.</p> <p><i>Preparation of steel surfaces #3 bite metal grip blast profile is recommended before the application of Primer 460 SPX, then remove dust with dry solvent wipe (toluene). Apply Primer 460 SPX to prepared steel surface within a 4 hour period of preparation and allow to dry for at least 1 hour (no more than 4 hours) at 72 °F before applying Speedliner Epic Castable.</i></p> <p>Coverage obtained with Primer 460 SPX will depend on the porosity or roughness of the substrates being primed. Typical coverage will range from 100 to 400 square feet per gallon. The dry film thickness when priming smooth substrates should be approximately one mil per coat. Overspray and waste must be taken into account when estimating the quantity of material required for a particular job.</p>																		



MIXING AND APPLICATION CONT.	<p>Primer 460 SPX dries to a slightly tacky film in approximately 30 minutes at room temperature at which time urethane elastomers may be applied. If Primer 460 SPX is to be cast and heat cured, the primer should be allowed to dry for one hour to allow all solvents to evaporate.</p> <p>Primer 460 SPX may be applied with a brush or with standard airless spray equipment having a minimum air fluid pressure ratio of 15:1. Fluid pressures of 1,500 psi or less will provide a good spray pattern with a .013 to .020 inch orifice spray tip. The spray machine should be equipped with Teflon or nylon hose and a 100-mesh outlet filter. A tip filter may be required for small tips. The spray should be conductive and the spray machine should be grounded to an earth ground when spraying.</p> <p>Note: Equipment must be clean when used to spray primer. Contaminates such as oil or grease in the spray equipment will interfere with the primer bond. Equipment should be flushed with M.E.K. before using equipment to spray primer.</p>
CLEAN UP	<p>Dispose of all empty Primer 460 SPX component containers in accordance with local, state and federal regulations. Empty component containers can be rendered non-hazardous by rinsing the containers with a small amount of mixed material and allowing the solvents to evaporate. The containers will then contain non-hazardous cured urethane.</p>
STORAGE AND SHELF LIFE	<p>Primer 460 SPX components are shipped from the factory in sealed containers that are purged with dry nitrogen. The containers should be kept tightly sealed and stored in a cool and dry area that is protected from direct sunlight and moisture. Storage temperatures should not exceed 80°F. Shelf life of factory sealed containers stored under these conditions is one year. Containers that have been opened should be resealed immediately after material has been removed in order to prevent moisture contamination and solvent evaporation. Resin component containers should be purged with dry nitrogen if the contents are not used within 24 hours after opening.</p>
SHIPPING CLASS	Class 92.5 Hazardous