



## PRODUCT

KEP405 (Gray) | KEP406 (Black) | KEP407 (White) | KEP402 (Catalyst)  
2.1 Epoxy Primer

### Product Features:

- Compatible with a wide range of topcoats including waterborne basecoats
- Lead and chromium free
- Excellent adhesion over most substrates
- May be used on most plastics

### Physical Properties:

Pot Life	4 hours @ 70°F
Flash Point:	40°F
Dry Film Build:	1 to 3 mils
Sprayable Viscosity (RTS):	15-18 " #2 Zahn Cup
Weight Solids (RTS):	41.77%
VOC (RTS):	< 2.1 (lb./gal)
Theoretical Coverage:	428 sq. ft. @ 1 mil
Induction Time:	None

### Substrates:

- Steel
- Aluminum
- Fiberglass
- Body Filler
- Some plastics
- OEM Finishes

### Mix Ratio:

**1 : 1**

1 Parts: 2.1 Epoxy Primer  
1 Part: Catalyst

### Mix Ratio (As Sealer)

Add ½ Part XR Series Reducer (For <2.1 VOC)

\* For National Rule areas higher than 2.1 VOC, UR-Series Reducer can be used

**Cold Shop Conditions:** For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure

### Spray Gun Setup:

Type: Gravity or Siphon Feed HVLP  
Tip Size: 1.3 to 1.4 mm  
Pressure: 7-10 PSI

Type: Conventional  
Tip Size: 1.3 to 1.4 mm  
Pressure: 45-55 PSI

### Dry Times (70°F):

Flash: 10-15 minutes between coats  
Sand: 1 to 2 hours  
Topcoat: 30 minutes  
Note: All tests are performed at 70°F, higher temperatures will provide faster drying times.

### Surface Preparation:

Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean dry cloth, then clean with a pre-cleaning product, using generous amounts and changing rags frequently prior to painting

**BARE METAL:** Sand area as necessary to remove any rust or corrosion, repair all body damage. When spraying over ALU-MINUM or STAINLESS STEEL, sand bare metal with 80 grit D.A. paper then clean with PRE-CLEAN.

### PRE-PAINTED SURFACES:

Sand vehicle with 320P grit or finer D.A. or hand sand with 400P grit or finer wet or dry sandpaper and repair all body damage.



Technical Data Sheet  
2.1 Epoxy Primer

**Application:** Apply 1 to 2 medium wet coats allowing 10 to 15 minutes flash time between coats - Film Build is approximately 1 to 1.5 mils per coat (dry film build). After allowing the epoxy to properly dry, topcoat with acrylic or synthetic enamel, basecoat (solvent or waterbased) or single stage acrylic urethane. If the epoxy has cured for more than 24 hours, scuff the surface before priming or topcoating. If filling capabilities are required, prime with a primer surfacer.

**Tips of the trade:** This primer does not need any reduction. At 85°F the primer takes 20 min to flash off, cooler temperatures will cause this time to increase. If spraying over ALUMINUM, sand with 80 grit DA paper and clean thoroughly with a rag soaked in pre-clean product until no black residue transfers to the rag. DO NOT use over galvanized steel.

**Spray Gun Adjustment:** Adjust the material flow according to product viscosity. Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut. Proper spray gun adjustment will determine the final finish, improper adjustment may cause orange peel, runs, poor drying and poor adhesion just to name a few defects.

**Clean Up:** Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

**Application:**  
**Product Safety Info:**

Before using any Custom Shop product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. When mixed, also contains Isocyanate. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.



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