

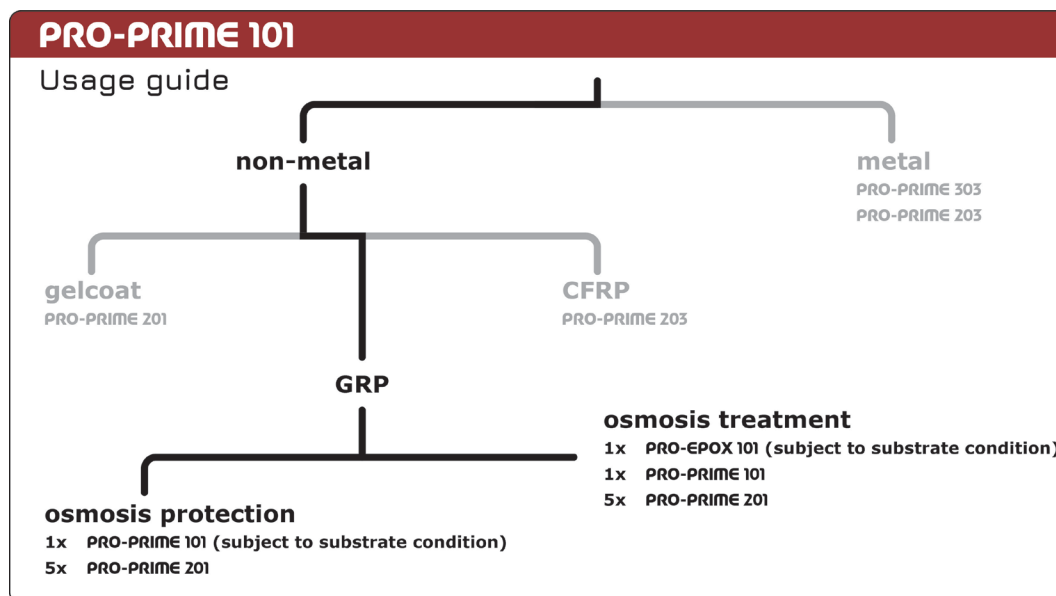
INTRODUCTION

Quick notes:

- Solvent-free epoxy primer.
- Osmosis treatment & protection.
- Use on bare GRP (PE, VE, EP laminates and EP fillers).

PRO-PRIME 101 is an epoxy primer for protection against and treatment of osmosis, used as a base layer on bare hulls. Being solvent-free, there is no risk of solvents being trapped inside hull pores and, hence, reduced chance of osmosis reappearing. Offers improved substrate penetration. For use below the waterline.

PRO-PRIME 101 can be used on its own or as part of the PRO-PRIME System as outlined below.



APPLICATION METHOD

Quick notes:

- Apply 1 coat of 100 µm.

Apply a rich coat using foam roller with light pressure. Promptly correct sags with roller or brush. Use brush for details, e.g. hull strakes and other non-flat areas, and to help cover high porosity areas.

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FEATURES & LIMITATIONS

- For bare GRP (polyester, vinyl ester or epoxy),
- 2:1 by volume,
- solvent-free (0 V.O.C.),
- improved penetration of substrate,
- non-blushing,
- available in blue and green for color alternation of layers,
- easily faired,
- below the waterline use,
- NOT suitable for application on primed hulls or gelcoat.

PRODUCT DATA

PRO-PRIME 101: Properties	
Mix ratio, by volume	2:1
Mix ratio, by weight	100:26
Volume solids, %	100
V.O.C., g/lit	0
Specific weight of mixture, approx., ISO 2811, kg/lit	1.32
Shelf life (in controlled environment), years	2
Packaging, comp. A+B, lt	2

CURING SPEED

PRO-PRIME 101: Curing speed			
	10 °C	20 °C	30 °C
Pot life *, mins	80	40	20
Thin film gel time, mins	240	180	120
Touch dry time, hours	7	5	3
Tack free, hrs	13	9	5
Hard dry / sandable, hrs	36	9	7

[Determined in controlled laboratory conditions. To be used as a guide only.]

* Note that pot life is highly dependent on volume of mixture and container size. Employ the usual epoxy

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resin techniques (e.g. temperature controlled large shallow container) in order to achieve a reasonable working life.

PRO-PRIME 101 will continue to cure for 2-7 days. This does not prevent recoating/overcoating.

RECOAT AND OVERCOAT TIMES

Quick notes:

- Recoat and overcoat without fairing after the current coat has gelled and while still tacky.

PRO-PRIME 101 can be overcoated with the following:

- PRO-PRIME 201 / epoxy primers and tie coats,
- PRO-FILL series / epoxy fillers,
- PU based top-coats and their respective tie coats,
- Antifouling coatings, and tie coats for 1K / silicon / Teflon based antifouling.

GENERAL RULE

'Gel-to-tack-free window': As a rule of thumb, recoating and overcoating without fairing must be done within the 'gel-to-tack-free window'. After this time, fairing is necessary.

SUBSTRATE POROSITY

- **Recoat, porous substrates:** In cases where the primer is readily absorbed on application, apply the subsequent layer back-to-back.
- **Recoat, non-porous substrates:** Recoat within the 'gel-to-tack-free window'.
- **Overcoat:** Use the 'gel-to-tack-free window' to overcoat with a PRO-PRIME or PRO-FILL product.

PRO-PRIME 101: 'Gel-to-tack-free window'			
	10 °C	20 °C	30 °C
Recoat/overcoat window, hrs	3-18	1.5-6	3/4-4

CONSUMPTION

Quick notes:

- Up to 6 m²/lt.

Expect consumption at approx. 6 m²/lt. However, when applying a first layer on a bare hull, coverage can drop down to 3 m²/lt, subject to porosity.

SURFACE PREPARATION

Quick notes:

- Abrade hull to grade 180.
- Clean thoroughly with dry cloths and pressurized air if available.

Both preparation and application should be carried out in optimal conditions, namely temperature in the range of 10-30 °C (ambient, substrate and product) and normal humidity levels. Following application, if temperature drops, curing will proceed, even close to 0 °C, albeit at lower speeds.

Hulls must be faired to grade 180 and be clean, free of dust, salt, water, grease, oil, wax, silicone, rust and other contaminants deposited over time or during the repair process.

For surfaces free of grease and oils, the recommended way of cleaning is by dry cloth assisted by vacuum dust extractor or compressed air (free of compressor oils). Use a large cloth, apply very lightly and change sides continuously so as to remove dust instead of pressing it on the substrate. Low grade grinding will help with more persistent residues and improve adhesion. Avoid using wet or waxed tissues. As an alternative, use **PRO-CLEAN IPA**, the fast drying, residue free, isopropyl alcohol solvent.

In the case of oily / greasy substrates, use **PRO-CLEAN X**, the xylene based cleaner. Ensure that no residues remain, either from the initial contaminants or from the cleaner.

Do not apply on substrates lacking cohesion. In such cases, unsound parts of the application surface must be removed.

If filling is required, it should be done after a first layer and overcoated by the remaining layers of primer.

MIXING & APPLICATION

Quick notes:

- Stir each component well in its original container before preparing a mix,
- do not thin,
- in higher temperatures, employ usual techniques to keep mix cool and prolong pot life.

Stir each component well before mixing. Using the indicative data given above, prepare quantities which you will comfortably have the time to apply within the pot life window. Mix the two components until a uniform consistency has emerged. Do not dilute.

PACKAGING

2 lt (1.33 + 0.66),

27 lt (18 + 9).

STORAGE & SHELF LIFE

At least 24 months from the date of manufacture in the original sealed container. The ideal storage temperature is 10-25 °C at normal humidity levels.

SAFETY

Apply in well-ventilated spaces. Follow personal safety guidelines relating to epoxy products, including the use of proper mask and protective clothing. Avoid physical contact with the uncured substances.

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