



# OxyStik 2K Epoxy Primer

## EP-21

### Description

EP-21 is a two part epoxy primer designed with maximum adhesion and corrosion resistance for protecting metals in harsh service environments including exposure to salt spray from the ocean or treated winter roads. A combination of epoxy polymers, amine adducts, pigments, & extenders make this primer an excellent choice for adhesion & protection applications prior to filling &/or painting.



### Safety

Read all SDS, and label warnings before using this product. For professionally trained painters using proper personal protective equipment. When mixed with other products this product will have hazards of all components. Keep away from extreme heat, sparks, open flames or any other potential ignition sources. Wear all personal protective equipment including the recommended respirator, gloves, and protective eyewear at all times including when opening, mixing/pouring, and applying material. When mixed for use this product contains isocyanates. Persons who have experienced reactions or sensitivity to isocyanates should not use or be exposed to this product. **KEEP OUT OF REACH OF CHILDREN.** In case of chemical or medical emergency call ChemTel 24/7 at 1-800-255-3924 and/or 911.



### Components

EP-21	<i>Oxystik 2K Epoxy Primer</i>
EPA	<i>Oxystik Activator</i>



### Substrates/Undercoats

Apply over cured 2K or OEM vehicle finishes, body filler, fiberglass, steel, or aluminum metals after proper sanding with P220-P400 grit paper and wiping with a ChemKlean surface cleaner. Do not apply over metal treatments including acid etch primers.



### Mixing Instructions

For spray applications mix 1 part EP-21 with 1 part EPA activator by volume. Gently mix then filter through a medium paint filter into your spray gun. Additional reduction may be required for use in an air brush application. This product has a 4 - 6 hour pot life so mix only enough that can be within that time. May be reduced up to 10% UreChem reducer if desired.



**Additives**

See reverse side for main component mix ratios. If fish eyes are observed a 1/2 ounce per sprayable quart of AFE-52 may be used.



**Application/Suggested Gun Settings**

Apply 2-3 medium-wet to wet coats using 50% overlap at a gun distance of 6-10 inches. Allow to flash 15 minutes between coats. Guns should be equipped with 1.3-1.5 mm tips and set for 40-55 PSI for conventional guns or 22-30 psi (trigger pulled) for typical HVLP guns .Fluid settings of 3-4 turns out from hand tight are a good starting point. Gun settings are suggested starting points and adjustments to your specific equipment and spray style are often required. Spray test panels to check effect and adjust as needed.



**Flash/Dry Times @ 75F**

Flash Between Coats	.....	15 minutes
Dry to topcoat	.....	2 hours
Max Time to topcoat	.....	48 hours (sand/clean if exceeded)
Dry to water/fog/dew exposure	.....	24 hours



**Cleanup**

Clean equipment immediately after use. UreChem urethane reducer, lacquer thinner or acetone are commonly used cleaners that are suitable for cleaning up after this product. Check local regulations to ensure compliance.



**Select Tips/Best Practices**

- Do not apply if dew, fog, or rain is present outside or will be shortly after spraying
- Agitate/Stir/Shake material before mixing and before each application. Guns that have been sitting idle with activated material should be agitated by hand and sprayed before proceeding.
- Always spray a test pattern and adjust as needed before proceeding to painting.
- Make sure paint and surfaces are above 60 degrees Fahrenheit and free of dirt, oils, dust, and other surface contaminants to ensure a good bond.
- Install and maintain water/moisture reducing traps and filters in your air systems
- Make sure your shop air is able to provide at least 25% more CFM than equipment specifies

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