

Military Grade 2K Epoxy Primer

1. PRODUCT NAME

26016 A	Red Oxide Epoxy Primer
26016 B	Epoxy Catalyst

2. MANUFACTURER

SIERRA LLC
11400 W. 47th Street Minnetonka, MN 55343

952-938-7223 | 952-938-8084 (fax)
Website: www.sierrapaint.com

3. PRODUCT DESCRIPTION

Red Oxide Epoxy Primer.

- Apply directly properly prepared steel.
- Excellent adhesion to steel.
- Excellent application properties
- Excellent chemical and chip resistance.

4. PRODUCT CHARACTERISTICS & TECHNICAL DATA

Composition and Materials:

- Epoxy/polyamide resin system.
- Aromatic, Ester, Ketone solvents

PHYSICAL PROPERTIES	
Solids Content: (as delivered; mixed)	63.1%; 62.6 by weight 42.8%; 42.9% by volume
Recommended Dry Film Thickness:	1-2 mils dry
Theoretical Coverage:	720 square feet per gallon
Density:	11.13 lbs/gal
Gloss:	50-60 @ 60 degrees
Viscosity: (as delivered; mixed)	58-62 KU @ 77 F 62-65 KU @ 77F
Finish Appearance:	Smooth
Pot Life (@77°F):	4 hours at 70F.

PHYSICAL PROPERTIES

Flash Point:	60°F SFCC
Theoretical VOC: (as delivered; mixed)	4.1 lbs/gal as delivered 3.9 lbs/gal mixed
Shelf Life:	2 years in unopened container

5. RECOMMENDED USES

2K 26016 A&B Epoxy primer is designed for restored vintage military vehicles and equipment. This primer will provide excellent corrosion protection and produce a smooth surface compatible with many topcoat systems.

6. APPLICATION PROCEDURES AND INSTRUCTIONS

Surface Preparation:

Surface should be free of any oil, grease, or dirt. Existing finishes should be degreased and sanded with 280 grit sandpaper. Abrade steel surfaces with 80 grit sandpaper. Apply primer to dry clean surfaces. When sanding old, existing paint be aware that lead may be present. Take precautions to avoid breathing sanding dust. Wash hands before eating.

Steel Preparation - Steel surfaces should be free of oil, grease or dirt. Remove all rust from surface. Sand blast or grind of all contaminants with a grinding wheel followed by 60 to 80 grit sandpaper.

Aluminum Preparation - Not recommended for aluminum.

Galvanized Preparation - Remove all white rust and contaminants. Sand surface with 80 grit sandpaper.

Concrete Preparation - May be applied to concrete that has aged 28 days.

Mixing/Thinning:

Mix color component well before using. Mix 4 parts by volume Part A with 1 part by volume 26016 B Epoxy Catalyst For air spray, reduce by 5-10% with T-4 Epoxy reducer to obtain good spray properties. Allow paint to induct for 30 minutes before spraying.

Application Conditions:

Surface temperatures should be at least 45 F when the paint is applied. Do not apply to wet or damp surfaces. Apply at temperatures that are 5 degrees above the dew point and rising.

7. REFINISHING PROCEDURES AND INSTRUCTIONS

After the maximum recoat time, the topcoat should be abraded with a red Scotchbrite pad or 320 grit sandpaper.

8. CLEANUP, SAFETY AND STORAGE

Cleanup Instructions:

Clean up with T-4 Epoxy reducer and clean up solvent.

Spills and Leaks:

Contain spilled materials and remove with an inert absorbent. Dispose of contaminated absorbent, container and unused content in accordance with local, state and federal regulations. For safety controls, Safety Data Sheets are available from Sierra. This information should be read before using this product.

First Aid:

If you experience difficulty in breathing, leave the area to obtain fresh air. If continued difficulty is experienced, get medical assistance immediately. In case of eye contact, flush immediately with plenty of water for at least 15 minutes and get medical attention immediately. In case of skin contact, wash thoroughly with soap and water. If swallowed, do not induce vomiting. Call a physician immediately.

Storage:

Store indoors and away from heat or humidity. Shelf life is 2 years in unopened container.

9. PACKAGING AND AVAILABILITY

Available in one gallon cans.

Recommended Application Equipment:

Gun Type	Nozzle	Air Pressure
Conventional Gravity Feed	1.4-1.5	45-65
Conventional Pressure Pot	1.0-1.2	45-65
HVLP Gravity Feed	1.4-1.5	7-12 at cap
HVLP Pressure Feed	0.8-1.2	7-12 at cap

PERFORMANCE DATA

Test Method	Results
Pencil Hardness:	F-HB
Reverse Impact:	20 in pounds
ASTM D-3359 Adhesion	5B on clean primed steel
Chemical Resistance 60 min spot test:	Gasoline: No effect Antifreeze: No effect Brake Fluid: Slight softening ATF: No effect Water: No effect. Not recommended for water immersion service.
ASTM B-117 Salt Fog:	300 hours with topcoat
ASTM G-53 QUV 340 A:	NA

TEMPERATURE RATING (dry)

Temperature	Results
Intermittent	300 F
Continuous	200 F

CURING TIMES

Surface Temp. (50% Relative Humidity)	Recoat	Lift Window	Final Cure	Max. Recoat Time
50 F	20 min	None	7 Days	2 Days
90 F	10 min	None	7 Days	1 Day

Revision date: 5/17/17

Conditions of Sale/Limited Warranty

Sierra LLC warrants that its products conform to the label descriptions, are free from manufacturing defects and are fit for the ordinary purposes for which such goods are used. Inasmuch as the use of Sierra's product by others and other factors affecting product performance are beyond Sierra's control, Sierra does not guarantee the results to be obtained. There are no warranties except as stated herein, either express or implied, including limited warranties of merchantability of fitness for a particular purpose. SHOULD ANY SIERRA PRODUCT FAIL TO GIVE SATISFACTORY RESULTS, SIERRA WILL REPLACE THE PRODUCT, OR AT ITS OPTION, REFUND THE PURCHASE PRICE. THIS IS THE SOLE AND EXCLUSIVE REMEDY FOR ANY FAILURE OF SIERRA PRODUCTS TO PERFORM AS WARRANTED AND SHALL ALSO CONSTITUTE LIQUIDATED DAMAGES IN CASE OF LOSS. UNDER NO CIRCUMSTANCES SHALL THE BUYER BE ENTITLED TO ANY OTHER REMEDY OR DAMAGES. REMEDIES FOR INCIDENTAL AND CONSEQUENTIAL DAMAGES ARE SPECIFICALLY EXCLUDED. Sierra does not authorize any person to assume for it any other liability in connection with the sale or use of its products unless specifically authorized by Sierra in writing.

