

# 2010

## HYBRID EPOXY PRIMER

### TECHNICAL DATA SHEET

**THIS IS THE PAINT | THIS IS THE SYSTEM | THIS IS i.COLOR.**

#### **2010 DIRECT TO METAL EPOXY HYBRID PRIMER**

**High Performance 2K Primer - 2.1 VOC**

#### **PRODUCT DESCRIPTION:**

2010 is a premium direct to metal and other substrates non-isocyanate epoxy hybrid primer/surfacer/sealer. As a surfacer, it is high build and easy to sand. As a sealer, it is easily applied and provides a smooth topcoat appearance. 2010 2.1 VOC DTM Direct to Metal Primer is formulated to provide excellent adhesion and corrosion resistance for various substrates.



#### **SURFACE PREPARATION:**

##### **STEEL**

1. Clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use.
2. Thoroughly sand surface with P80 grit dry sandpaper or equivalent.
3. Re-clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use
4. Apply 2010 Direct to Metal Epoxy Hybrid Primer.

##### **ALUMINUM**

1. Clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use.
2. Thoroughly sand surface with Red Scuff Pad or equivalent.
3. Re-clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use
4. Apply 2010 Direct to Metal Epoxy Hybrid Primer.

##### **FIBERGLASS (Gel Coat or SMC Surface)**

1. Clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use.
2. Thoroughly sand surface with P220-P320 grit dry sandpaper or equivalent.
3. Re-clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use
4. Apply 2010 Direct to Metal Epoxy Hybrid Primer.

##### **BODY FILLER**

1. Clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use.
2. Apply body filler keeping within the repair area, do not feather edge body filler on the existing finish.
3. Final sand body filler with P150-P220 grit dry sandpaper or equivalent.
4. Final sand surrounding paint finish with P220-P320 grit dry sandpaper or equivalent.
5. Apply 2010 Direct to Metal Epoxy Hybrid Primer.



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## SURFACE PREPARATION CONT'D:

### OEM E-COAT

1. Clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use.
2. If damage exists, feather edge any damaged areas with P320 grit dry sandpaper or equivalent.
3. Re-clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use
4. Apply 2010 Direct to Metal Epoxy Hybrid Primer.

### EXISTING OEM FINISHES

1. Clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use.
2. Thoroughly sand surface with P220 - P320 grit dry or equivalent.
3. Re-clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use
4. Apply 2010 Direct to Metal Epoxy Hybrid Primer within the sanded area of the existing finish.

### PLASTIC

1. Wash area to be repaired with warm soap & water.
2. Clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use.
3. Thoroughly sand surface with "white" or "gold" scuff pad or equivalent.
4. Re-clean repair area with pre-prep wax & grease remover or low VOC cleaner where VOC regulations require use
5. Apply 2010 Direct to Metal Epoxy Hybrid Primer.



## MIXING DIRECTIONS

### HIGH BUILD PRIMER (4:1)

4 PARTS 2010 Primer  
1 PART 2015 Catalyst

### MEDIUM BUILD PRIMER (4:1:1)

4 PARTS 2010 Primer  
1 PART 2015 Catalyst  
1 PART 1070 Zero VOC Reducer

### PRIMER SEALER (4:1:2)

4 PARTS 2010 Primer  
1 PART 2015 Catalyst  
2 PARTS 1070 Zero VOC Reducer



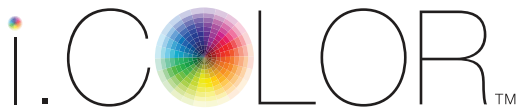
## POT LIFE:

Pot life will be about 2+ hours at 77° F.



## APPLICATION DIRECTIONS:

Adjust air pressure to 40-50 psi at gun for gravity or siphon feed guns. HVLP use 6-10 psi at air cap. Apply 1-2 medium coats, allow a 5-10 minute flash time between coats and before force drying.



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**DRY TIMES AT 77°F:**  
Flash Time 5 - 10 MINUTES  
To Sand 60 - 90 MINUTES



**BAKE TIMES AT 140°F**  
Purge Time 15 MINUTES  
Bake Time 40 MINUTES



**ACCELERATOR & FISHEYE ELIMINATOR:**  
Accelerator and/or Fisheye Eliminator is not recommended for use in this product.



**CLEAN-UP:**  
Clean spray equipment immediately after use with gun wash, or a high quality lacquer thinner, or compliant solvent depending on area regulations.



**TECHNICAL DATA:**

|                          |   |
|--------------------------|---|
| Color:                   | Grey                                    |
| Catalyst:                | 2015                                    |
| Low VOC Reducer:         | 1070                                    |
| Mixing Ratio:            | 4:1, 4:1:1, 4:1:2                       |
| Weight Solids (RTS):     | 50% - 60%                               |
| Viscosity #2 Zahn (RTS): | 16 - 45 seconds #2 Zahn                 |
| Pot Life:                | 2+ hours                                |
| Film Build per coat:     | 1.0 - 2.2 mils per full wet coat        |
| Coverage:                | 498 - 698 sq.ft. per gallon @ 1 dry mil |
| Disposal/Safety:         | See MSDS for this product               |

#### FOR INDUSTRY USE ONLY

##### Read MSDS Before Use

2010 Hybrid Epoxy Primer must be blended with other components before the product can be used. Any mixture of the components will have the hazards of all the components. Before opening the packages, read all warning labels and material safety data sheets. Follow all precautions. This material is designed for application by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

##### SEE MSDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

**NOTE:** iColor products are not recommended for use in temperatures below 65°F. Using iColor products below these temperatures will effect dry times and product performance characteristics.