

BLUE WATER MARINE PAINT

Coal Tar Epoxy Primer™ TECHNICAL DATA SHEET

Revision date:
December 2019



Marine Coal Tar Epoxy Primer is a two component epoxy primer with excellent corrosion resistance and adhesive properties for steel substrates. Ideally applied by spray but can be applied by roller or brush for small surface areas. Generally used as part of systems on surfaces both above and below the waterline. Provides a seamless epoxy coating that renders a water barrier that eliminates any direct path for water migration.

Application: Marine Coal Tar Epoxy Primer can be applied by either airless or conventional spray. For airless spray use a 0.23-0.27thou spray tip and 2400-3000 pounds psi. For conventional spray, use a pressure pot with 10-15 psi and 40-50 psi at the spray tip. Use spray tips designed for high build epoxy primer applications.

Note: If spray applied take special care to avoid skin contact. Coal tar on the skin will lead to skin burns in sunlight.

Suggested Uses: Metal Priming

Colors: Base - Black, Converter - Amber Liquid

Finish: Semi-Gloss

Vehicle Type: Coal Tar Modified Epoxy

Solids By Volume: 80.00 +/- 2.0%

VOC Content: 172 grams/liter (reacted)

Weight per Gallon: 10.50 +/- 0.2 pounds (mixed unit)

Recommended Dry Film Thickness: 7.0-9.0 mils

Coverage: Approximately 183 square feet per gallon at 7.0 mils DFT

Pot life: 5-6 Hours with Standard Cure, 3 Hours with Low Temperature Cure

Shelf Life: 24 Months

Average Dry Time: Dries to touch in about 4 hours at 70-75 deg F. Dries to over coat in 8 hours but with a maximum of 30 days. Can be top coated with other epoxy primers and most antifouling paints.. Choice of top coats is critical as coal tar will bleed into the top coat and change the color. Should never be top coated with topside finishes.

Recommended Reducer: For spray application use Thinner 973 or 976. For roller or brush applications use Thinner 974 or 976

Clean Up: Use Thinner 973 or 976

Recommended Finish: Itself or other epoxy primers.

Surface Preparation: Surface must always be clean, dry and properly prepared prior to painting. Failure to do so will lead to eventually blistering and/or peeling. High pressure fresh water clean and allow to thoroughly dry prior to painting.

General Application: For use as a metal primer in a single or multi-coat system. Can be applied by spray, roller or brush for small areas. Add up to 10-15% by volume for spray, 5-7% for roller or brush. Apply additional coats if needed to meet dry film thickness requirements. See above for maximum over coating times. Allow 20-30 minutes induction time after the Converter is added and before adding any thinner.

Mixing and Thinning: Shake or mix each component thoroughly. Add the Converter Component to the Base Component and stir thoroughly. Continue to stir while using.

Induction Time: 20-30 Minutes at 70-75 deg. F, longer at lower temperatures

Existing Painted Surfaces: First ensure the existing surface is compatible with a two component epoxy and if



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acceptable, thoroughly roughen to provide sufficient tooth for maximum adhesion. Wipe off grinding/sanding dust with Thinner 974, allow to dry and apply the first coat of Marine Coal Tar Epoxy Primer.

Bare Metal Surfaces: Steel: Sand blast with standard angular grit media to a blast profile of 1.5-2.0 mils. Remove blasting dust and apply one or more coats of Marine Coal Tar Epoxy. Allow to properly cure and apply second coat if part of the painting specification.

If grit blasting is not practical, grind the steel surface with a power disc sander with 36-60 grit sanding disc. Once the surface is properly sanded, wipe away all sanding dust and apply the first coat of Marine Coal Tar Epoxy reduced with 15-20% Thinner 974 or 976. Allow to properly dry and apply the second coat.

Note: For full systems using Marine Coal Tar Epoxy Primer please contact your local Blue Water Marine representative.