



TIE-COAT PRIMER

Application Information

Tie-Coat Primer is a very tough and sandable, non-moisture sensitive single-component polyurethane primer. It contains hybrid polymeric resins which have excellent adhesion characteristics to most painted surfaces, especially that of POR-15, because we have matched and blended the resin components of both coatings to make them fully compatible. Tie-Coat Primer is highly resistant to penetrating topcoats such as enamels, lacquers, and two-component finishes ("penetrating topcoats" Refers to topcoats with especially aggressive solvent bases which can penetrate and ruin a partially cured base coat). But it **must be 100% cured**.

Tie Coat is not a reactive coating (as is POR-15, which reacts to moisture), but its revolutionary adhesion promoters make it an ideal **interlocking prime coat** between POR-15 and various topcoats. It sands to a perfectly smooth finish. It may be used over cured POR-15 coatings up to 6 months (for better adhesion we recommend that it be applied sooner) with no preparation other than cleaning the surface. **Tie-Coat is a Linking Primer not a High Build Primer.**

PRODUCT CHARACTERISTICS

Boiling Point: 177-196°C (350-385°F)

Vapour Density: Heavier than air

Reactivity in Water: None

Odour: Light Aromatic

Evaporation rate (Ether=1): Solvent 4.5

Flash Point: 42.2°C (108°F)

Carcinogens (or potential): none

Conditions to avoid: Sparks, open flame

Current TLV: ACGIH: 100 ppm TWA

Viscosity: Range@77°F:250-500 CPS

Specific Gravity (water=1): 1.32

% Volatile by Volume: 21%

Colour: Bluish-Grey

Volatile organics: 2.33 lbs/gal (270gr/ltr)

Solubility in water: Negligible

Stability: stable under normal conditions

Material to avoid: oxidizing agents

Ceiling Value OSHA PEL: 500

DIRECTIONS FOR USE

Surface Preparation: Surface to be coated should be free of grease, oil, foreign substances. Use **Marine Clean** for this purpose before painting.

Thinning: Thinning is not usually required if brushed on. May be thinned for spraying 5-10% with POR15 Solvent. (10 parts primer to 1 part solvent). Do not thin any more than this as adhesion may be affected.

Application: Stir Tie-Coat thoroughly before using; do not shake as this will create air bubbles. Apply by brushing or spraying a **thin dust coat. Must be applied in temperature of at least 18°C or will not dry.** Subsequent coats (if required) may be applied if fully dry, at no less than 12 hourly intervals. **DO NOT SAND BETWEEN COATS OF PRIMER.** Sand only after final coat of primer has **fully dried (at least 24 hours).** **Thicker coats will need longer.....and may not cure for weeks and may fail.**

N.B. Tie-Coat should not be exposed to rain, dew, etc.

Pressure: Spray at approximately 250 Kpa (35lbs).

The best method for **over-coating POR-15 Rust Preventative Paint** with Tie-Coat Primer is to first clean the surface with **Marine Clean** and then apply a **THIN DUST COAT** of Tie-Coat. Allow a minimum 24hrs or longer (until cured) and then top coating can be done at any stage after this curing time.

Top coating: Allow a **minimum of 24 hours before applying any topcoat over Tie-Coat Primer.** *Failure to allow enough dry time before applying topcoats may result in spidering or crinkling of the finish..* NOTE: In temperatures below 18°C curing times can lengthen considerably (Tie-coat is solvent curing not moisture curing). **Allow extra days for curing in a low temperature environment. Tie-coat will stop curing in temperatures below 12°C.**

Paint Surfaces: Clean with Marine Clean and sand with 240 Grit and then overcoat with Tie-Coat Primer.

Storage & Handling: Store in a tightly closed container and protect from moisture and foreign materials. Ideal storage temperature is 10-27°C.

Summary:

1. Stir, do not shake Tie-Coat Primer before using.
2. Apply **THIN** coats. **Do not sand between coats. Sand only after final coat has dried thoroughly (24 hours).** See note above.
3. As with all solvent-based coatings, use an organic particulate respirator, NIOSH/MASH approved, when spraying or brushing. In closed areas, use an air supplied respirator when spraying.

The information set out in this flier is, so far as can be ascertained, true and accurate, but all recommendations are made without guarantee.

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