

## XPrimer

### Product description

This is a two component polyamide cured epoxy coating. Designed as a fast drying, sandable finishing primer. Suitable for properly prepared carbon steel, aluminium, composite and coated surfaces as epoxy and polyurethane systems. Can be used as primer as a part of a complete system in atmospheric and immersed environments.

### Typical use

Exterior and interior areas, including hulls, above and below waterline, superstructures and decks. To be used as finishing primer under Jotun Yachting range of products. Can be used as primer or sealer for fillers in atmospheric and immersed environments. The product is suitable for both professional and consumer application.

### Colours

grey, white

### Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	51 ± 2 %
Gloss level (GU 60 °)	ISO 2813	matt (0-35)
Flash point	ISO 3679 Method 1	25 °C
Density	calculated	1.2 kg/l
VOC-US/Hong Kong	US EPA method 24 (tested) (CARB(SCM)2007, SCAQMD rule 1113, Hong Kong)	440 g/l
VOC-EU	IED (2010/75/EU) (theoretical)	455 g/l

The provided data is typical for factory produced products, subject to slight variation depending on colour.

All data is valid for mixed paint.

Gloss description: According to Jotun Performance Coatings' definition.

### Film thickness per coat

#### Typical recommended specification range

Dry film thickness	50 - 75	µm
Wet film thickness	100 - 150	µm
Theoretical spreading rate	10.2 - 6.8	m <sup>2</sup> /l

## Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

Surfaces with grease, oil or other contamination, wash with recommended Jotun Yachting detergent.

### Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	St 3 (ISO 8501-1)	Sa 2½ (ISO 8501-1)
Stainless steel	The surface shall be machine abraded with non-metallic abrasives or bonded fibre machine to impart a scratch pattern of min. 45 µm to the surface and to remove all polish from the surface.	Abrasive blast cleaning to achieve a surface profile using approved non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Aluminium	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface and to remove all polish from the surface.	Abrasive blast cleaning to achieve a surface profile using approved non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Galvanised steel	The surface shall be clean, dry and appear with a rough and dull profile.	The surface shall be clean, dry and appear with a rough and dull profile.
Shop primed steel	Sa 2 (ISO 8501-1)	Sa 2 (ISO 8501-1)
Coated surfaces	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)	Clean, dry and undamaged compatible coating (ISO 12944-4 6.1.4)
Composite	Polyester based composites must be fully cured before initiating the surface preparation. The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads with grit P100-P160 to impart a scratch pattern to the surface and to remove all polish from the surface.	Polyester based composites must be fully cured before initiating the surface preparation. The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads with grit P100-P160 to impart a scratch pattern to the surface and to remove all polish from the surface.

## Application

### Application methods

The product can be applied by

- Spray:** Use air spray or airless spray. Care must be taken to achieve the specified dry film thickness.
- Brush:** Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.
- Roller:** May be used for small areas. Not recommended for first primer coat. Care must be taken to achieve the specified dry film thickness.

### Product mixing ratio (by volume)

XPrimer Comp A	4 part(s)
XPrimer Comp B	1 part(s)

### Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

### Guiding data for airless spray

Nozzle tip (inch/1000):	15-21
Pressure at nozzle (minimum):	150 bar / 2100 psi

### Guiding data for air spray

Nozzle tip:	Pressure pot: 1.2-1.4 (mm)
Pressure at nozzle (minimum):	2.5-3 bar

Distance from air compressor to filters is to be at least 10 m. The product must only be sprayed by professional users.

## Drying and Curing time

**Substrate temperature** **10 °C** **23 °C** **40 °C**

#### Comp A + Comp B

Surface (touch) dry	2 h	1.5 h	30 min
Walk-on-dry	14 h	6.5 h	3 h
Dry to over coat, minimum	24 h	12 h	9 h
Dried/cured for service	14 d	7 d	3 d

#### Comp A + Comp B + Thinner

Surface (touch) dry	2.5 h	1.5 h	45 min
Walk-on-dry	20 h	9 h	4 h
Dry to over coat, minimum	30 h	16 h	12 h
Dried/cured for service	14 d	7 d	3 d

Drying and curing times are determined under controlled temperatures and relative humidity below 85%, and at the typical DFT for the product.

Drying time will increase with increasing film thickness.

When product is diluted to help spraying with conventional spray equipment, it is required to allow to dry for 48 hours and dry sand the surface with P220/P320.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

## Induction time and Pot life

<b>Paint temperature</b>	<b>23 °C</b>
Induction time	30 min
Pot life	8 h

## Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	120 °C	140 °C
Immersed, sea water	50 °C	60 °C

Peak temperature duration max. 1 hour.

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

Note that the coating will be resistant to various immersion temperatures depending on the specific chemical and whether immersion is constant or intermittent. Heat resistance is influenced by the total coating system. If used as part of a system, ensure all coatings in the system have similar heat resistance.

## Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Previous coat:	epoxy, polyurethane
Subsequent coat:	epoxy, polyurethane

## Packaging (typical)

	Volume (litres)	Size of containers (litres)
XPrimer Comp A	0.6 / 2	0.75 / 2.5
XPrimer Comp B	0.15 / 0.5	0.3 / 0.75

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

## Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

### Shelf life at 23 °C

XPrimer Comp A	24 month(s)
XPrimer Comp B	48 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

## Caution

The product is suitable for both professional and consumer application. The product must only be sprayed by professional users. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

## Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products may fade and chalk when exposed to sunlight and weathering.

## Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.