



MARTIN-SENOUR PAINTS
AUTOMOTIVE DIVISION

High Build Epoxy Primer

6101 Red Oxide
6102 Light Gray

PRODUCT DESCRIPTION

High Build Epoxy Primers provide excellent adhesion to protect against harsh environments and maximize corrosion protection. High Build Epoxy Primers are ideal for Truck Manufacturers, Fleets, and Automotive Refinishers where extended service is important.

TECHNICAL DATA

	6101	6102		
• Color	Red oxide	Light gray	• Flash point (PM)	55°F
• Wt./gallon	10.61	10.75	• Induction time	30 minutes
• Weight solids (sprayable)	50 %	50 %	• Pot life	without 3094 with 3094
• Volume solids(sprayable)	31 %	31 %		24 hours 48 hours
• Coverage/gallon @ 1 mil dry	500 sq.ft.	500 sq.ft.	• Viscosity	#4 Ford Cup #2 Zahn Cup
• Chromate containing	Yes	No		18-20 seconds 22-24 seconds
• Lead containing	No	No	• Impact resistance -	direct
• Flash points(PM)	45°F	45°F	• Humidity resistance @ 250 hours	160 in-lbs
• VOC as applied @ 2:1 (#'s/gal)	4.83	4.89	• Salt spray resistance	Excellent
				450 hours
				500 hours

SURFACE PREPARATION

Bare Substrates: Steel, Galvanized Steel*, Aluminum, or Fiberglass

**Note: With the inconsistencies of galvanized steel, consult your local MARTIN-SENOUR Representative for system recommendations and substrate testing.*

- Solvent clean with Tec/CLEAN™ Surface Cleaner 6384, KLEANZ-EASY® Surface Cleaner 6383 or KLEANZ-EASY II™ Low VOC Surface Cleaner 6388 and wipe dry with a clean, dry cloth.
- Optional for maximum corrosion protection, apply 2-3 medium coats of TRIO/Prime™ Etching Primer 8846 or 8847 or one double coat of Vinyl Wash Primer 8827. Or, treat bare steel areas with IRON ETCH™ Steel Cleaner 6878 followed by TRIPLE ETCH® Phosphate Conversion Coating 6877. Treat bare aluminum with TWIN-ETCH® Metal Cleaner and Conditioner 6879.

Prepainted Substrates: Except refinish lacquer and zinc chromate primer 8829.

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth.
- Solvent clean lacquer surfaces with Tec/CLEAN™ Surface Cleaner 6384. Solvent clean enamel surfaces with Tec/CLEAN™ Surface Cleaner 6384, KLEANZ-EASY® Surface Cleaner 6383 or KLEANZ-EASY II™ Low VOC Surface Cleaner 6388. Wipe dry with clean cloth.
- Grind off paint and remove all rust. Fill as needed using an appropriate body filler. Allow body filler to tack up and shape as needed.
- Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper on a random orbital sander.
- Apply 2-3 medium coats of TRIO/Prime™ Etching Primer 8846 or 8847 to bare metal and body filler. Or, treat bare steel areas with IRON ETCH™ Steel Cleaner 6878 followed by TRIPLE ETCH® Phosphate Conversion Coating 6877. Treat bare aluminum with TWIN-ETCH® Metal Cleaner and Conditioner 6879.

(For the above products refer to the appropriate product label or data page for complete information.)

MIXING

- Stir or shake High Build Epoxy Primer thoroughly before mixing.
- Normal:** Mix by volume 2 parts Epoxy Primer 6101 or 6102 with 1 part Epoxy Activator Hardener 6115. **Pot life - 24 hours.**
For **additional flow and extended pot life** add 2 parts Acrylic Lacquer Thinner 3094: Mix by volume 2 parts Epoxy Primer 6101 or 6102 with 1 part Epoxy Activator Hardener 6115 and 2 parts Acrylic Lacquer Thinner 3094. **Pot life with 3094 - 48 hours.**
- Stir thoroughly and strain. Allow mixture to stand **covered** for an induction time of **30** minutes. Failure to do so will increase drying times.

PRODUCT DATA

APPLICATION

Note: Do not use High-Build Epoxy Primer over refinish lacquer or zinc chromate primer 8829.

- Adjust air pressure at the gun to: **50-55** psi for siphon feed gun
50-55 psi for pressure feed gun
(adjust pot pressure to **8-10** psi).
- Apply **1-2 double coats** at a gun distance of **8-10 inches** allowing each coat to become hand slick (10-15 minutes flash) before applying the next coat. For **maximum corrosion protection** apply two double coats of High Build Epoxy Primer. This will yield the recommended 2.0-2.5 mils dry film thickness.
- For a **Shop Coat**, apply 2 double coats of High Build Epoxy Primer and allow 2 hours minimum dry time before handling and storage.
- Clean spray gun immediately after use with Gun and Equipment Cleaner 3196 or CA-3196.

SPRAY GUN TYPE	MANUFACTURER	SPRAY GUN MODEL	NOZZLE	ORIFICE SIZE	AIR CAP
Siphon Feed	Binks	#7B/C Gold	66	.070 "	66SK
Siphon Feed	DeVilbiss	JGA502	EX	.070"	80
Siphon Feed	Sharpe	975	1-975-04-70N1	.070"	1-71-02MO
Siphon Feed	Sharpe	775-P1-CC-70	1-71-04-70	.070"	1-71-02CC
Siphon Feed	Sharpe	971	1-71-04-70	.070"	1-71-02CC
Gravity Feed	Sharpe	SGF	1.8 mm	.071"	#10 Red
Gravity Feed	DeVilbiss	GFG616	FW	.062"	43
Gravity Feed	Optima	800	1.5 mm	.059"	1.5 mm
Gravity Feed	SATA	SATA Jet 90	1.4 mm	.055"	Nozzle Set
Gravity Feed	SATA	SATA Jet B	1.4 mm	.055"	Nozzle Set
Gravity Feed	SATA	SATA Jet H	2.0 mm	.079"	Nozzle Set
HVLP	Binks	Mach I	92	.046"	97P
HVLP	Iwata	LPS	*	.098"	*
HVLP	DeVilbiss	JGHV530	EX	.042"	33
HVLP	Mattson	Gold Cartridge	*	.040"	*
HVLP	Sharpe	PTE	*	.046"	*
HVLP	SATA	Jet/B-NR92	1.5/1.7 mm	.059/.067"	Nozzle Set
HVLP	Accuspray	Accuspray	*	.036"	9

*Use one supplied

DRYING SCHEDULE

Dry times are based on the recommended dry film thickness of 2.0 mils.

- Air dry times @ 75°F and 50% R.H.**
 - As a Shop Coat 2 hours
 - To Recoat 1 hour
- Force dry times to recoat**
 - 140°F 30 minutes
 - 160°F 20 minutes

Note: Refer to the vehicle manufacturer for maximum allowable force dry temperature of vehicle.

RECOATING

- After **72 hours dry**, scuff sand High Build Epoxy Primer with 320 grit or finer treated sandpaper to insure proper adhesion.
- Do not recoat** with Acrylic Lacquer or SYNTHOL® Enamel. **Note:** If top coating with **uncatalyzed** Acrylic Enamel, allow system **one week dry time** for maximum chip resistance.

PRODUCT AT-A-GLANCE

PRODUCT **High Build Epoxy Primer** **6101 Red Oxide or 6102 Light Gray**

USE

- A high build, fast drying epoxy primer primarily for fleet use.
- Ideal for harsh environments where corrosion protection is important.
- Can be used as a shop coat for storing metal parts until topcoating step.
- 6101 is a lead-free alternative for the fleet industry.
- 6102 is a lead-free and chromate-free alternative for the fleet industry.

SUITABLE SUBSTRATES

- Steel
- Galvanized steel*
- Aluminum
- * See previous page for details
- New fiberglass
- Properly aged enamel substrates
- OEM lacquer
- Tec/PRIME® Primer-Surfacers
- Vinyl Wash Primer
- TRIO/Prime™ Etching Primer
- Tec/AQUA™ Primer-Surfacers

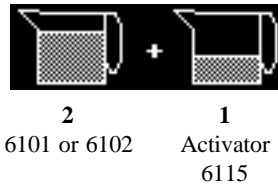
SURFACE PREPARATION

- **Wash** surfaces with a mild detergent in hot water. Rinse well and wipe dry with clean cloth.
- **Solvent clean** with the appropriate solvent cleaner, and wipe dry with a clean cloth.
- **Grind** repair area to remove paint and all rust as needed.
- **Apply body filler** to clean bare metal as needed.
- **Sand** all areas to be refinished and featheredge all broken film areas.
- **Treat** bare metal with an appropriate metal conditioner or etching primer.

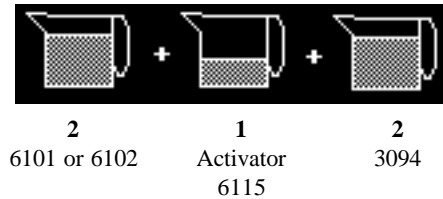
MIXING

Stir or shake Epoxy Primer thoroughly before mixing.

Normal Mix



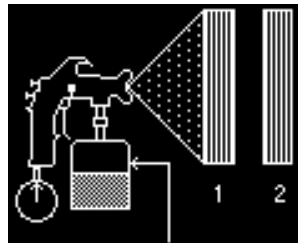
For additional flow and extended pot life



APPLICATION

Siphon Feed

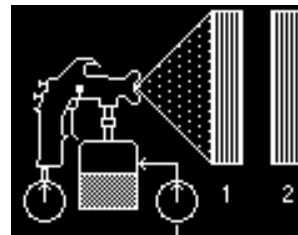
Apply **1 - 2** double coats. Allow each coat to become hand slick.



50 - 55 psi pot life:
24 hours (normal)
48 hours (3094)

Pressure Feed

Apply **1 - 2** double coats. Allow each coat to become hand slick.



50 - 55 psi with pot pressure: 8-10 psi
 Pot life: **24 hours (normal)**
48 hours (3094)

Time to Recoat
1 hour



As a shopcoat: **2 hours**

RECOAT

- NITRAM® Acrylic Urethane
- NITRAM® Low VOC Acrylic Urethane
- NITRAM® Basecoat/Clearcoat
- Tec/BASE® Basecoat/Clearcoat
- Tec/BASE® HS Basecoat/Clearcoat
- Martin-Senour Acrylic Enamel (catalyzed)
- UREGLO™ Polyurethane Enamel
- Tec/ONE-STAGE™ Acrylic Urethane
- Tec/GLO™ High Performance Urethane

NOTES

- Scuff sand with 320 or finer grit treated sandpaper after 3 days dry time before topcoating. Repriming after sanding is not necessary for adhesion.
- For optimum corrosion resistance, 2.0 mils (dry) is recommended.
- Reduce Epoxy Primer only with 3094 Acrylic Lacquer Thinner. Do not substitute.
- Clean up with 3094
- Do not use over refinish acrylic lacquer or refinish acrylic lacquer basecoat/clearcoat, and zinc chromate primer 8829.

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- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear a NIOSH approved organic vapor respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety glasses, coveralls, and rubber gloves when using product.

