



Specialty Paints & Products for  
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## **Q-PRIM MP2076™ ADVANCED EPOXY BLACK PRIMER**

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**Q-PRIM MP2076™** Advanced Epoxy Black Primer is a high performance, 2-component, 3.5 VOC, heavy metal free, epoxy coating specifically formulated for a variety of surfaces including steel, galvanized steel, aluminum, fiberglass, wood, previously painted surfaces and many plastics. **Q-PRIM MP2076™** Advanced Epoxy Black Primer is formulated with high performance polyepoxide resins, pigments, additives and solvents to assure the most durable and affordable product available to the sign and related industries. Combine this black epoxy with **Q-PRIM MP2070™** Advanced Epoxy White to create gray shades to complement the topcoat being applied. **Q-PRIM MP2076™** Advanced Epoxy Black is an **Environmentally Friendly** product that is low in HAP's – hazardous air pollutants and low in VOC's – volatile organic compounds.

QHF Environmentally Friendly Product.

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### **APPLICATION:**

1.



#### **Safety:**

Use only NIOSH approved respirators and personal protection equipment recommended for the product used.

*Always review the MSDS – Material Safety Data Sheets before use.*

2. **SURFACE  
PREPARATION:**

#### **Suitable Surfaces:**

Cleaning and substrate preparation for all primers, surfacers and adhesion promoters must be followed utilizing Technical Data Sheet recommendations prior to applying any **Q-PRIM™ Series primer**.

<b>Aluminum:</b>	Sand with #P180 to #P320 grit.
<b>Fiberglass:</b>	Sand with #P180 to #P320 grit.
<b>Steel:</b>	Remove existing rust and oxides by dry sanding with P#80 to #P320 grit.
<b>Plastics:</b>	Cross hatch test for adhesion before production use.
<b>Wood:</b>	Compressed air to clean, test before production use.



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3.



### Surface Cleaning New:

For aluminum, steel, and fiberglass, clean with **Q-SOLV™** Approved Cleaners / Degreasers and sand using power tools to produce a clean bare metal surface and to retain or produce a surface profile. Once cleaned, the surface will be free of all oil, grease, dirt, dust, mill scale, rust, paint, oxide, corrosion products and any other foreign matter. Re-clean with **Q-SOLV™** Approved Cleaners / Degreasers. For Steel or aluminum substrates, immediately apply **Q-PRIM MP2076™** Advanced Epoxy Primer after the substrate has dried or flash rusting may occur.

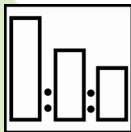
For plastic / ABS type substrates, clean with **Q-SOLV™ CD4402™** or **Q-SOLV™ CD4414™** and perform a cross hatch adhesion test before production run priming. Application of **Q-PRIM™ PP1010™** Specialty Plastic Adhesion Promoter may be required.

For wood, use compressed air to clean. The performance of the primer should be tested and confirmed on the actual substrate due to the wide variety of wood types / substrates.

### Surface Cleaning Previously Painted:

Clean with **Q-SOLV™** Approved Cleaners / Degreasers and scuff sand (400 grit to 600 grit) to produce a surface profile. Once cleaned, the surface will be free of all oil, grease, dirt, dust, loose paint, rust, oxide products or any other foreign matter. Feather edge smooth any areas exposed to bare substrate and spot prime with appropriate primer. Refer to TDS information on selected QHF brand primers before proceeding.

4.



### Mixing Procedure and Ratio:

#### Combine:

4 parts <b>Q-PRIM MP2076™</b>	Advanced Epoxy Black Primer
1 part <b>Q-ACTV PA2072™</b>	Advanced Epoxy Activator
1 part <b>Q-SOLV PR2074™</b>	Advanced Epoxy Reducer

### Mixing Procedure and Ratio – High Film Build:

#### Combine:

4 parts <b>Q-PRIM MP2076™</b>	Advanced Epoxy Black Primer
1 part <b>Q-ACTV PA2072™</b>	Advanced Epoxy Activator
0% - 20% <b>Q-SOLV PR2074™</b>	Advanced Epoxy Reducer

Stir until thoroughly blended and strain before using. Pot life is 4 hours.  
No Induction Time (sweat time) is required.



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**To Make Gray shades:**

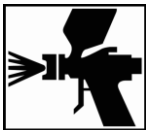
Any combination of White and Black Advanced Epoxy may be mixed together to make gray by weight. Once the shade of gray is mixed, use the below ratios to activate/reduce prior to use.

	<u>White MP2070™</u>	<u>Black MP2076™</u>
Light Gray	75%	25%
Medium Gray	50%	50%
Dark Gray	25%	75%

**Combine:**

4 parts **ABOVE GRAY MIXTURE**    Advanced Epoxy Gray Mixture Primer  
1 part **Q-ACTV PA2072™**        Advanced Epoxy Activator  
Refer to above for **Q-SOLV PR2074™** Advanced Epoxy Reducer mix ratios

5.



**Recommended Spray Equipment:**

Gravity Feed:     1.4 - 1.8 mm  
Siphon Feed:     1.6 – 2.0 mm  
Pressure Feed:   1.0 – 1.2 mm

6. **FILM PROPERTIES:**

Apply 1.5 – 2.0 mils minimum dry film thickness, 1 flowing coat with recommended spray equipment. The application of higher film builds or multiple coats will lengthen flash, dry and cure times. The use of wet and dry film thickness gauges and cross hatch adhesion testers are always recommended.

7. **DRY TIMES:**

Dry to touch / dust free at 75°F is 30 to 60 minutes  
Dry to handle at 75°F is 1-1/2 to 2 hours.  
Dry to pack / ship at 75°F is 24-48 hours minimum.

Recoat anytime within the first three (3) days. After 72 hours sanding is recommended before top coating. A light de-nibbing by hand or machine after 60 minutes, followed by tack wiping. Always allow any freshly de-nibbed surface to recover for 15 to 30 minutes before top coating.



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**NOTES:**

All two component cross linking activation stops or significantly slows at temperatures below 60°F or 16°C. Applying coatings in these types of conditions will result in poor film resistance, decreased performance, reduced chemical resistance and or improper curing.

Can be brushed / rolled with sacrificed appearance by mixing per guideline and thinning to appropriate viscosity.

A natural china bristle brush or ¼” mohair roller is recommended to assist in reducing the amount of orange peel and aid in leveling.

Do not apply if temperature is below 60°F or above 110°F or if the surface temperature is within 5°F of the dew point.

A five minute induction time may assist in better leveling and degree of image.

<b>8. PERFORMANCE PROPERTIES:</b>	Abrasion and mar / scratch resistance:	Excellent
	Alkali resistance:	Excellent
	Water / humidity resistance:	Excellent
	Solvent, acid & salt resistance:	Excellent

Always test surface preparation, primer and topcoat compatibility to determine acceptability before any production run.

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