



AQUA-POXY 914 PRIMER

EPOXY PRIMER: AIR DRY OR HEAT CURE

SERIES E914

TWO-COMPONENT, CORROSION INHIBITING, ADHESION PROMOTING



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DESCRIPTION

Aqua-Poxy 914 is a two-component, high performance epoxy primer designed for universal use over cleaned shot blasted steel, Galvalume®, aluminum, many plastics, and wood. Aqua-Poxy 914 prevents filiform corrosion over aluminum, galvanic corrosion over Galvalume® and galvanized steel, and is an excellent corrosion resistant primer for properly prepared steel.

Sancryl acrylic coatings are recommended for use over Aqua-Poxy 914 primer for superior exterior performance.

OUTSTANDING FEATURES/BENEFITS

- Superior adhesion
- Provides excellent corrosion protection
- Resistant to chemical attack and solvent spills
- VOC compliant
- Solvent-borne lacquers and urethanes may be applied over Aqua-Poxy 914 with excellent results
- Light reflectance of Aqua-Poxy 914 makes it an excellent finish coat for the inside of lighted signs

NOTICE

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet (MSDS), and Technical Data Sheet.

TYPICAL USES

Aqua-Poxy 914 is typically used as a primer for aluminum substrates.

LIMITATIONS

- Applying at temperatures below 50°F, or humidity above 80%, will greatly prolong drying times.
- DO NOT APPLY BELOW 40°F.
- Aqua-Poxy 914 must be protected from freezing.
- Application over steel must be carefully monitored to avoid flash rusting or loss of adhesion due to imperfect surface preparation.
- Surface must be dry to touch when top coated. If top coated when wet, the system cure time will be greatly extended.
- Must be used within 8 hours of mixing.

COMPOSITION AND PHYSICAL PROPERTIES*

Net Weight per gallon	10.4 - 10.82 lbs. (Theoretical)	Vehicle	Epoxy/Polyamide
Weight Solids	43% 46% (Theoretical)	Color	White
VOC + water	1.48 lbs./gal (179g/L)	Color Stability	Not UV Stable
VOC – water	2.85 lbs./gal (344g/L)	Finish	Matte
Mix Ratio	2:1 (2 parts A to 1 part B)	Cleanup	Soap and Water
Viscosity	35 - 45 seconds, #2 EZ Zahn @ 77°F	Thinner/Reduction	Use as supplied
Shelf Life	1 year from date of shipment in unopened containers	Induction Period	None required
Storage Conditions	50° - 100°F	Pot Life	8 Hours
Freeze/Thaw Stability	DO NOT FREEZE	Force Cure:	20 minutes @ 180°F
Coverage Rate**	507 sq. ft./gallon @ 1 mil dry		
Recommended Coats	2		
Dry Film Thickness	1.0 – 1.5 mils on aluminum 1.0 – 1.5 mils on pultruded materials 2.0 – 3.0 mils on Galvalume® 2.0 – 3.0 mils on steel		

* Based on 2A:1B, or 2 part Epoxy/Pigment Emulsion to 1 part Curing Agent

** Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.

IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY

We warrant our products to be free of manufacturing defects and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and are accurate to the best of our knowledge. They are based on technical data we believe to be reliable and are intended for use by persons having skill and "know-how" at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION, THE DATA ON WHICH IT IS BASED OR THE RESULTS OBTAINED FROM ITS USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT. Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders of other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. SANDSTROM PRODUCTS COMPANY

PERFORMANCE AND FUNCTIONAL PROPERTIES		
	CRS Substrate	Aluminum Substrate
Corrosion Protection <i>ASTM B117</i>	334 Hours * ^	1000 Hours ~
Crosscut Adhesion <i>ASTM D3359</i>	5A * ^	5A ~
Flexibility (Mandrel) <i>ASTM D552</i>	1/8 inch *	1/4 inch *
Impact Resistance <i>ASTM D2794</i>	30 inch-pounds ^ 16 inch-pounds *	8 inch-pounds *
Pencil Hardness <i>ASTM D3363</i>	HB ^	HB
* System: Two coats Aqua-Poxy 914 Primer, 1 coat Sandstrom Sancryl 300 ^ Two coats Aqua-Poxy 914 Primer ~ System: One coat Aqua-Poxy 914 Primer, 1 coat Sandstrom Sancryl 300		

GENERAL

For maximum service, the APPLICATION INSTRUCTIONS MUST BE CLOSELY FOLLOWED.

COVERAGE

One gallon of this material will cover 507 sq. ft. with a dry film thickness of 0.001 inches. Coverage depends upon method of application and other variables such as overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

SURFACE PREPARATION

The following surface preparations are recommended for the individual metals listed to develop maximum adhesion, wear life and corrosion protection. Please contact Sandstrom Products Company for substitute surface preparations if recommended steps cannot be followed.

Application on steel. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surfaces with 180-220 grit aluminum oxide. Phosphate IAW MIL-DTL-16232 (weight should be 11-22 g/m²), type M, class 3 or type Z, class 3.

Application on stainless steels. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surfaces with 120 grit aluminum oxide. Passivate the surfaces with ASTM A967, types nitric 1, nitric 2 or nitric 3, as applicable.

Application on aluminum and aluminum alloys. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sulfuric acid anodize IAW MIL-A-8625 and seal the surface.

Application on titanium and titanium alloys. Degrease surface to be coated with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surface with 180-220 grit aluminum oxide and alkaline anodize.

Application on copper and copper alloys. Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surfaces to pass ASTM F22. Sandblast the surfaces with 180-220 grit aluminum oxide. Form a black oxide finish on the surfaces.

IMPORTANT! DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION. Whenever possible, treat both contact surfaces (i.e., the shaft and the bearing).

STIRRING

THIS COATING SHOULD BE STIRRED THOROUGHLY BEFORE USE AND INTERMITTENTLY DURING APPLICATION.

THINNING

None required for spray application. Use as supplied.

APPLICATION

Aqua-Poxy 914 is formulated for conventional or HVLP spray application.

CURING

Aqua-Poxy 914 dries to touch in 20-30 minutes and can be top coated up to four weeks after application if left at room temperature. Full cure and water resistance properties take about one week at room temperature, or within 24 hours after force-curing for 20 minutes at 180°F.

IMPORTANT!

The time begins when the part has reached 180°F, NOT when it is placed in the oven.

CLEANUP

Clean up with soap and water immediately.

REMOVAL

In the event it is necessary to remove Aqua-Poxy 914 Primer, physical removal is best (such as grit blasting, sanding or grinding).

DANGER! USE WITH ADEQUATE VENTILATION.

IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY

We warrant our products to be free of manufacturing defects and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and are accurate to the best of our knowledge. They are based on technical data we believe to be reliable and are intended for use by persons having skill and "know-how" at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION. THE DATA ON WHICH IT IS BASED OR THE RESULTS OBTAINED FROM ITS USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT. Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders of other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. SANDSTROM PRODUCTS COMPANY