

Interior Primer 178

Technical Data Sheet: 144 77
P178X

1. Introduction

ALEXSEAL Interior Primer 178 is a two component epoxy based primer which is very fast drying. It can be overcoated quickly with ALEXSEAL N-Series Interior Topcoat 578 and is characterized by low odor. After final drying ALEXSEAL Interior Primer 178 is mechanically resistant and offers a good corrosion protection on all kinds of metal. It can be left without topcoat in areas, where aesthetic features are not required. ALEXSEAL Interior Primer 178 has been approved by IMO Resolution MSC.307 (88)-(FTP-Code 2010) as marine paint with low flame-spread characteristics.

2. Range of application

ALEXSEAL Interior Primer 178 is used for corrosion protection and adhesion promotion on steel and aluminium substrates. After curing it offers a solid primer layer with good chemical and mechanical resistances.

3. Color

Color of mixture: White / Light Gray
Base Material: White / Light Gray
Converter: Clear

4. Coverage

Solids catalyzed without reduction: 68%

Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	Rec. DFT in µm (mils)
Theoretical	4.8	17	183	150 (5)
Practical				
Conventional Air Spray Equipment	3.0	11.0	120	150 (5)
HVLP Air Spray Equipment	3.2	11.8	130	150 (5)
Airless Equipment	3.6	13.2	140	150 (5)
Brush / Roller	4.0	15.0	165	150 (5)

5. Substrate pre-treatment

The substrate must be clean, dry and free from dust, grease, oil and other contamination. ALEXSEAL Interior Primer 178 is applied directly to the properly cleaned and prepared substrate (ideally within 6 hours). To achieve optimum adhesion and performance:
Steel should be prepared by sandblasting to near white metal, SA 2.5 (SSPC – SP10 - 85) or ground (36 to 40 grit) to a 50 - 100 micron (2 - 4 mils) profile.
Aluminium must be sandblasted or ground (36 to 60 grit) to bright clean aluminium with a 50 - 100 micron (2 - 4 mils) profile.
Gelcoat (80-100 grit) and fiberglass (36-60 grit) resin should be ground before an Interior Topcoat application.

6. Trade names & Packaging

P1780	ALEXSEAL Interior Primer 178 White	1 Gal
P1783	ALEXSEAL Interior Primer 178 Light Gray	1 Gal
C1787	ALEXSEAL Interior Primer Converter	1 QT
R1789	ALEXSEAL Interior Primer Reducer Spray & Brush	1 Gal

7. Mixing ratio

Spray:

4 parts by volume	P178x	ALEXSEAL Interior Primer Base 178
1 part by volume	C1787	ALEXSEAL Interior Primer Converter
30% reduction (vol.)	R1789	ALEXSEAL Interior Primer Reducer Spray & Brush
Example: 4 : 1 : 1 1/2 = 30 % reduction		

Brush and Rolling:

4 parts by volume	P178x	ALEXSEAL Interior Primer Base 178
1 part by volume	C1787	ALEXSEAL Interior Primer Converter
Min.15 % reduction (vol.)	R1789	ALEXSEAL Interior Primer Reducer Spray & Brush
Example: 4 : 1 : 3/4 = 15 % reduction		

The amount of reducer required may vary depending on the application conditions. Mixed material must be filtered before application.

Professional Use Only

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8. Application

Viscosity Spray	DIN 4 cup 4mm: ≈ 35 sec (30% Red)
Viscosity Roll	DIN 4 cup 4mm: ≈ 70 sec (15% Red)
Nozzle Size Gravity Gun	1.4 – 1.7 mm (0.055 to 0.067) - Conventional & HVLP
Nozzle Size Siphon Cup	1.6 mm (0.63) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	1.2 to 1.4 mm (0.047 to 0.055) - Conventional & HVLP
Atomizing Pressure	3.0 to 4.0 bar (44 to 58 PSI) - Conventional & HVLP
Pot Pressure	1.0 – 2.0 bar (15 PSI) - Conventional & HVLP

Application by Spraying Apply 2 coats to a total wet film thickness (WFT) of 400 – 500 microns (8 - 10 mils). This will achieve a dry film thickness (DFT) of 200-250 microns (8 – 10 mils).

9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 20% RH, max. 30°C (85°F) 70% RH

Temperature for minimum recoat time	15°C (60°F)	20°C (68°F)	25°C (77°F)	Max Dry Time
Pot Life - approx.	6 hrs	4 hrs	3 hr	N/A
Dust Free	45 min	30 min	20 min	N/A
Tape dry	24 hrs	16 hrs	12 hrs	N/A
Fully cured	10 d	7 d	5 d	N/A
Recoating by spraying with another coat of ALEXSEAL Interior Primer 178	3 hrs minimum	2 hrs minimum	1,5 h minimum	3 months
Recoating by rolling with another coat of ALEXSEAL Interior Primer 178	6 hrs minimum	4 hrs minimum	3 hrs minimum	3 months
Overcoat with other products including ALEXSEAL N-Series Interior Topcoat 578	12 hrs Minimum	8 hrs minimum	6 hrs minimum	14 days

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will affect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum object temperature is 15°C (68°F). Ideal temperature: 25°C (77°F). The minimum application condition should be 3°C (5.4°F) above dew point.

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