



POR-15 TIE-COAT

Application Information

PRODUCT DESCRIPTION:

POR-15® Tie-Coat Primer is a very tough and sandable high-build single-component polyurethane. It contains special resins with excellent adhesion characteristics for most painted surfaces, especially POR-15®, and it is highly resistant to penetrating topcoats such as enamels, lacquers, and two-component finishes. It isn't moisture-sensitive and is very stable. POR-15® Tie-Coat Primer is not a reactive coating, but its revolutionary adhesion promoters make it an ideal interlocking prime coat between POR-15® and various topcoats. It sands to a perfectly smooth finish. Tie-Coat Primer may be used over well-seasoned POR-15® coatings, even if they are more than a year old, with no special preparation other than cleaning the surface.

Surface Preparation: Surface to be coated should be free of grease, oil, and foreign substances. POR-15 Marine Clean is ideal for this.

The best method for overcoating POR-15 Rust Preventive Paint with Tie-Coat Primer is to first clean the surface with Marine Clean and then apply a coat of POR-15 Self-Etching Primer, following directions on the can; then, overcoating with Tie-Coat can be done at any stage, or lightly sand the POR-15 Rust Preventive Paint with 320 grit sand paper and topcoat with Tie-Coat.

Painted Surfaces

Clean with Marine Clean and paint with POR-15 Self-Etching Primer following directions on the can; then overcoat with Tie-Coat; or clean with Marine Clean and sand with 240 grit and then overcoat with Tie-Coat Primer.

Thinning: Tie-Coat Primer may be thinned up to 10% with POR-15 Solvent (10 parts Primer to 1 part Solvent).

Thinning may not be required if primer is to be brushed on. Application: Stir Tie-Coat thoroughly before using. Do not shake as this will create air bubbles. Apply by brush or spray. Apply in thin coats. If applied too heavily, drying time will be lengthened considerably. If a second coat is desired, wait a minimum of 12 hours before applying. You may sand between coats of primer, but adhesion will be better if you do not. Sand after final coat of primer has fully dried (24 hours). Spray at approximately 35 lbs(240Kpa) pressure.

Topcoating

Allow a minimum of 24 hours before applying any topcoat over Tie-Coat Primer. Failure to allow enough time before applying topcoats may result in spidering or crinkling of finish.

Note: In temperatures below 64°F (18°C) cure times can lengthen considerably. Tie-Coat is solvent-cured not moisture-cured, so allow extra days for curing in a low temperature environment. Tie-Coat will not cure in temperatures below 52°F(12°C).

Product Characteristics:

Boiling Point: 350-385°F / 177-196°C

Vapor Density: Heavier than air

Reactivity in water: none

Odor: Light aromatic

Viscosity: Range@77°F(25°C): 250-500 CPS

Specific Gravity (water = 1): 1.32

% Volatile by volume: 21%

Evaporation rate (Ether = 1): Solvent, 4.5

Color: Bluish-Gray

Volatile organics: 2.33 lbs/gal (270 gr/ltr)

Flash point: 108°F / 42.2°C

Solubility in water: negligible

Carcinogens (or potential): none

Stability: stable under normal conditions

Conditions to avoid: Sparks, open flame

Materials to avoid: oxidizing agents

Current TLV:

ACGIH: 100 ppm TWA

Ceiling value OSHA PEL: 500

VOC 270 g/l

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