



1034 East New York Street  
 Indianapolis, IN 46202  
 317-879-2055  
 800-593-0126  
[www.ACCESSA.biz](http://www.ACCESSA.biz)

**INVIRApoxym PRIMER**

**Description:** A high quality, low VOC polyamide epoxy primer, specifically formulated for electrostatic applications. Formulated with highly effective rust inhibitors, *INVIRApoxym* Primer provides outstanding adhesion, toughness and flexibility.

**Uses:** The ideal primer for quality minded steel fabricators, machine shops, and equipment manufacturers who must prime surfaces which are not totally free from oil and other foreign matter. *INVIRApoxym* Primer is the best-suited primer for acrylic urethanes since it offers the flexibility necessary for these ultra hard finishes.

**Application:** *INVIRApoxym* Primer is designed to be sprayed via electrostatic application; however, this product can be sprayed using all other spray methods. *Invirapoxym* primer is formulated to spray without adjustment through the Ransburg # 2 process. All other spray systems may require small viscosity adjustments (airless tip size .011 - .013).

**Surface preparation and limitations:** It is imperative that all surfaces be properly prepared in order to achieve the adhesion and performance that this product is designed to give. Always follow proper cleaning procedures. Be sure to observe and follow safety precautions as printed on this label. Be sure to observe and follow mixing instructions and induction period (**30 minute induction time**) as outlined on the can label. Failure to follow these instructions may result in sub-standard performance of this product.

**Appearance:** Gray

**Coverage:** 325-375 sq. ft per gallon. It is recommended that a minimum of 3 wet mils be applied to achieve maximum durability.

**Dry times:** At 70° F: To touch – 30 minutes; To handle – 4 hours; To recoat – 4 hours. If the first coat is only a “tack coat” then a full coat may be applied in 15-30 minutes. If re-coated after 72 hours, sanding is required to assure inter-coat adhesion. **Temperature restrictions:** Surface of painted part and air temperature must remain above 60° prior to application for at least 3 hours. The coating temperature must be at 72° F for a minimum of 2 hours before application. Bake schedule 140° - 2 hours, 250° - 30 minutes.

**Flash point:** 105° F

**Mix ratio:** 1 part 6800 to 1 part C2800SG

**Pot life:** 8 hours at 77° F; for every 10 degrees above 77° F deduct 2 hours from the pot life.

**Thinning:** Oxsol

Type	Gloss	Dry Time				Solids		Coverage	VOC	Thinner	Clean Up
Epoxy Polyamide	See Above	Recoat 4 hrs	Handle 4 Hrs	Force See Above	Cure 7 Days	Wt 72.1%	Vol 52.2%	325-375 sq ft per gallon	2.8 per gal or 336 grams per liter	Oxsol	Oxsol

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