



User Chart



XPM

Process	Description	Important Notes
Uses	<p>Best suited for applications when time is NOT a factor (this is a next day primer)</p> <p>Best for blasted steel, ferrous metals, fiberglass, galvanized steel, adding build to existing bedliners</p>	<p>Recommended if water contact is a factor in final application</p> <p>Color = Red</p>
Mixing	<p>Mix Ratio: 0.6A:1B</p> <p>Power mix each component of XPM separately, and then combine at a ratio of 0.6 part "A" to 1 part "B" by volume and power mix to a smooth consistency</p> <p>Acetone may be added up to 15% by volume N. Butyl Acetate may be added if local regulations allow</p>	<p>Thinning may be required</p> <p>Low VOC, solvent based urethane primer</p> <p>ALWAYS premix B side component - Not doing this is one of the main causes of primer failure</p>
Surface Preparation	<p>Etch profile should be 1-3 mils before priming with XPM</p>	
Applying	<p>Can be sprayed or rolled on</p> <p>When spraying: Use HVLP gun with tip size of 1.8-2.0 35-40 psi air pressure - Adjust pattern to full fan</p> <p>When rolling: Use a ¼" shed resistant nap roller (remember to "back roll" primer to ensure coating thickness is within spec)</p>	<p>Coating thickness should be 2-3 mils wet (WFT)</p> <p>65% solids by volume</p> <p>5 mil wet (WFT) will achieve a 3 mil dry (DFT)</p> <p>Maximum thickness is 5 mil wet (WFT)</p>
Recoat Window	<p>Recoat window is 10-24 hours @ ambient temperature of 70°F and 50% relative humidity</p>	<p>Pot Life is 45 min - 2 hrs.</p> <p>Safe to apply down to 55°F</p>
Coverage	<p>Coverage area: HVLP - 375 sq. ft. per gallon @ 3 mil wet (WFT) ROLLER - 450 sq. ft. per gallon @ 3 mil wet (WFT)</p>	<p>1 kit = 1 gal "B" and 0.6 gal "A"</p>
Clean up	<p>Use Acetone or MEK to wash brushes, rollers, HVLP guns, pumps and other painting tools.</p>	

**Please refer to the Technical Data Sheet for specific information regarding product performance.*

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