



ORCA AIR DRY V/E PRIMER

PRODUCT APPLICATIONS-

-
- CORROSION TANK / PIPE LINING
- ELEVATED TEMPERATURE TOOLING SURFACE
- IN MOLD BARRIER COAT (BLISTER RESISTANT)
- BELOW WATER LINE MARINE REPAIR
- WATER SLIDES

-PRODUCT FEATURES-

-
- HIGH HEAT DISTORTION
- CORROSION RESISTANT
- LOW POROSITY
- HIGH BUILD
- FDA APPROVABLE COATING

-SURFACE PREPARATION-

-
- PREPARE SURFACE BY SANDING WITH 220g PAPER (ALWAYS NON-STEARATED)
- CLEAN SURFACE WITH IPA (ACETONE IS NOT SUITABLE)

-PRODUCT APPLICATION SUGGESTIONS-

-
- CATALYZE AT 2% W / MEKP INITIATOR (.5-OZ PER QUART)
- UTILIZATION OF HVLP SPRAY GUN OPTIMIZES FINISH
- AIR PRESSURE 25-40 PSI
- MAINTAIN 12-18" DISTANCE BETWEEN GUN AND SURFACE
- OPTIMUM TEMPERATURE OF 77°F
- START WITH FLASH COAT (2mils) WAIT 2 MINUTES THEN START BUILD COATS OF 4 mils PER PASS WAITING APPROX. 5 MINUTES BETWEEN COATS. DURING COOLER TEMPERATURES WAIT 20 MINUTES BETWEEN COATS. IF YOU EXCEED 90 MINUTES, YOU MUST

The information herein is general information designed to assist customers in determining whether Orca products are suitable to their applications. Orca products are intended for sale to industrial and commercial customers. We require customers to inspect and test our products before use and to satisfy themselves as to contents and suitability for their specific applications. **Nothing herein constitute any warranty express or implied, including any warranty of merchantability or fitness for a particular purpose**, nor is any protection from any law or patent to be inferred. The exclusive remedy for all proven claims is limited to replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.

Fiberlay Inc. - 24 S Idaho St Seattle WA, 98134 (800)942-0660

LET CURE, SAND, AND THEN RESUME BUILD COATS.

- OPTIMUM BUILD OF 16 MILS
- ALLOW FULL CURE (24 HOURS) PRIOR TO SAND AND POLISH

GEL TIME:

18-22 min

VISCOSITY:

4300 CPS (RVT #5 @ 20rpm)

CURE TIME:

1-4 HOURS

COVERAGE (16-MILS):

100 sf / gallon

THIX INDEX:

5.22

WEIGHT PER GALLON:

11.3 lbs.

FLASH POINT:

98° F

VOCs:

.68 lbs. / gal.

MONOMER CONTENT:

23%

SHELF LIFE:

6 months @ 68° F

DUST FREE TIME:

30 min @ 77° F

ELONGATION:

5.5 %

HEAT DEFLECTION TEMP:

415°F

Handling & Storage

As with all polyester resin, rate and degree of cure are a function of initiator concentration and of temperature. Resin and work area should be between 70°F and 95°F to ensure satisfactory results. Initiator levels should be within a range of 1.0-3.0% based on weight of resin. The use of initiator levels outside of this range may result in an inadequate cure, with laminates exhibiting moderate to severe post cure after de-molding.

Orca V/E Primer is available in 55-Gallon metal drums.

To ensure maximum stability and maintain optimum resin properties, resins should be stored in closed containers at temperatures below 75°F and away from heat sources and sunlight. All storage areas and containers should conform to local fire and building codes. Drum stock should be stored away from all sources of flame or combustion. Inventory levels should be kept to a reasonable min with first-in, first-out stock rotation.

Safety

Read and understand the Material Safety Data Sheet before working with this product

The information herein is general information designed to assist customers in determining whether Orca products are suitable to their applications. Orca products are intended for sale to industrial and commercial customers. We require customers to inspect and test our products before use and to satisfy themselves as to contents and suitability for their specific applications. **Nothing herein constitute any warranty express or implied, including any warranty of merchantability or fitness for a particular purpose**, nor is any protection from any law or patent to be inferred. The exclusive remedy for all proven claims is limited to replacement of our materials and in no event shall we be liable for special, incidental or consequential damages.

Fiberlay Inc. - 24 S Idaho St Seattle WA, 98134 (800)942-0660