

PRODUCT MANUFACTURER:

LINE-X LLC
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DESCRIPTION:

LINE-X XPM is a high solids, two-component, urethane primer with outstanding adhesion to properly prepared steel, ductile iron and galvanized substrates. It is specifically formulated to provide excellent anti-corrosive properties and accept fast-set and standard-set high build polyurethane topcoats.

Use LINE-X XPM as a primer for properly prepared steel, ductile iron and galvanized metals prior to the application of LINE-X spray-on products. Use as an intercoat primer to bond various topcoats to fastset, standard-set and/or aged polyurethane and polyurea elastomers.

APPLICATION GUIDELINES:

Remove all oil, grease or other contaminants from the surface to be coated in accordance with SSPC-SP 1.

Steel and Ductile Iron:

Non-Immersion: Abrasive blast to a commercial blast in accordance with SSPC-SP 6 and obtain a 1.5-3 mil (38-70 µ) angular anchor pattern.

Immersion: Abrasive blast to a near white blast in accordance with SSPC-SP 10 and obtain a 1.5-3 mil (38-70 µ) angular anchor pattern.

Galvanized (New): Scrub vigorously with a 1:1 mix of MEK/Toluene to remove the residual lubricant inherent to the galvanizing process.

Galvanized (Aged): Remove visible rust by sweep blasting or mechanical cleaning.

Other: Contact a LINE-X representative for specific recommendations.

	Normal	Minimum	Maximum
Material	75-90°F (24-32°C)	65°F (18°C)	100°F (38°C)
Surface	75-90°F (24-32°C)	45°F (7°F)	110°F (43°C)
Ambient	75-90°F (24-32°C)	45°F (7°F)	110°F (43°C)
Humidity	30-50%	0%	85%

APPLICATION CONDITIONS

Surface temperature must be 5°F (3°C) above the dew point.

Mixing

Power mix each component of LINE-X XPM separately, then combine at a ratio of 0.6“A” to 1 “B” by volume and power mix to a smooth consistency.

Thinning

Thinning may be required. Acetone may be added up to 15% by volume. N. Butyl Acetate may be added up to that allowable by local regulations.

Pot Life

Material Temperature	Time
60°F (15°C)	1 ½ - 2 hours
75°F (24°C)	1 ½ hours
90°F (32°C)	45 minutes

Drying/Cure Time

These times are based on a 30-50% RH. Excessive film thickness, cooler temperatures or inadequate ventilation will require longer cure times and could result in premature failure.

Surface Temperatures

	50-69°F (10-21°C)	70-89°F (21-32°C)	90-110°F (32-43°C)
Surface Dry	12-18 hours	6-10 hours	3-5 hours
Hard Film	18-24 hours	10-12 hours	4-6 hours
Recoat-min	18-24 hours	10-12 hours	4-6 hours
Recoat-max	24 hours	24 hours	24 hours
Full cure	5 days	4 days	3 days



TECHNICAL DATA SHEET – LINE-X® XPM

If LINE-X XPM has exceeded its maximum recoat time or full cure time contact your LINE-X representative for recommended recoating procedures.

TYPICAL PROPERTIES:

Solids by Volume	65% ± 2
Volatile Organic Compounds	0.83 lb/gal (99 g/l)
Theoretical Coverage (DFT)	1040 ft ² /gal @ 1 mil (2.48 m ² @ 1 mm)
Recommend WFT (Do not exceed 5 mils per coat)	2 – 3 mils (50 – 75 μ)
Number of Coats	1
Mix Ratio (by volume)	0.6”A” : 1”B”
Shelf Life @ 60-90°F (16-32°C)	Part A-6 mos. Part B-12 mos.
Color	Red
Adhesion to sandblasted steel	ASTM C297 1750 psi – 1910 psi
Salt Spray Test	ASTM B117
3,000 hrs. Rating 10 when used as prime coat for polyurethane and polyurea coatings.	

CLEAN UP & SAFETY

Use acetone, MEK or a 1:1 blend of MEK and Toluene to wash brushes, rollers, spray guns & pumps and other painting tools.

Read the Material Safety Data Sheet (MSDS) and container labels for detailed health and safety information. Do not apply LINE-X XPM in enclosed areas without adequate air exchange and ventilation. All application personnel must use respirators rated for organic vapors, or in confined spaces wear fresh air respirators or fresh air hoods. Wear protective clothing, gloves and eye protection. Breathing fumes or contact with the skin may cause severe allergic reactions. This product contains flammable solvents! Keep away from all sparks, flames and hot surfaces. This product is intended for industrial use by properly trained professional applicators only.

MATERIAL STORAGE:

LINE-X XPM needs to be protected from moisture contamination. Store drums and pails in a dry location at 55-80°F (11-27°C). Materials must be kept above 50°F (10°C).

PRODUCT USER RESPONSIBILITIES:

Users of LINE-X XPM product are responsible for reading the general guidelines, product data sheets, specifications and material safety data sheets (MSDS) before using this material. Printed technical data and instructions are subject to change without notice. For additional information or for current technical data instructions, contact a LINE-X representative or visit www.LINE-X.com.

PRODUCT DISCLAIMER:

All guidelines, recommendations, statements, and technical data contained herein are based on information and tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. It is the user's responsibility to satisfy himself, by his own information and test to determine suitability of the product for his own intended use, application and job situation. User assumes all risk and liability resulting from his use of the product. We do not suggest or guarantee that any hazards listed herein are the only ones which may exist. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements, whether in writing or oral, other than those contained herein shall not be binding upon the manufacturer, unless in writing and signed by a corporate officer of the manufacturer. Technical and application information is provided for the purpose of establishing a general profile of the material and proper application procedures. Test performance results were obtained in a controlled environment and LINE-X LLC makes no claim that these tests or any other tests accurately represent all environments.

