

**PRODUCT DESCRIPTION** MFI-575/575B/575W EPOXY MAX Industrial Epoxy Primer is a high build, industrial grade primer that can be applied directly to properly prepared bare steel, galvanized, stainless steel, aluminum, concrete and masonry. This high-performance primer is specially designed for use in the harshest environments, including submersible applications. EPOXY MAX has excellent chemical and abrasion resistance. It meets NSF Standard 61 for tanks, pipes, valves and fittings (US manufacturing only). EPOXY MAX is available in Gray (MFI-575), Black (MFI-575B) and White (MFI-575W).

#### COMPATIBLE SUBSTRATES

Bare Steel	Galvanized Steel	Aluminum
Concrete/Masonry	OEM Coatings	

#### SURFACE PREPARATIONS

Coating performance is dependent on the degree of surface preparation. EPOXY MAX can be applied over abrasive blasted or mechanically cleaned surfaces. All surfaces must be clean, dry and free of all contaminants, including salt deposits. **See detailed surface preparation recommendations by substrate on page 2.**

#### MIXING

**1 Part:** MFI-575/575B/575W EPOXY MAX Industrial Epoxy Primers  
**1 Part:** MFI-576 EPOXY MAX Activator  
*up to 10%:* MFI-400 Series Zero VOC Reducer (Optional)

**NOTE:** Mix by volume and stir thoroughly. Make sure product temperature is between 50°F (10°C) and 90°F (32°C). Dry time can be accelerated by adding 4 oz. MFI-577-4 Accelerator to a 2 gallon ready to spray kit.

#### APPLICATION

Apply 1-2 coats of EPOXY MAX Primer. Allow 30 minutes flash time between coats. EPOXY MAX Primer can be topcoated in a minimum of 6 hours up to 7 days @ 70°F (21°C). If primer sits for more than 7 days it needs to be cleaned, sanded and recoated. **See recommended application equipment on page 2.**

- Must be applied in a well ventilated area.
- Substrate temperature needs to be between 20°F (-6°C) and 122°F (50°C)
- Drying time listed may vary, depending upon film build, temperature, humidity and degree of air movement.
- Excess film thickness will retard dry times and affect the recoat window

#### CURE TIMES

Air-dry for DFT up to 5 mils	32°F (0°C)	50°F (10°C)	70°F (21°C)	90°F (32°C)
Dry To Touch	24 hours	8 hours	2 hours	1 hour
Dry Through	38 hours	14 hours	5 hours	3 hours
Dry To Recoat/Topcoat	24 hours	12 hours	6 hours	3 hours
Max. Recoat w/ EPOXY MAX	90 days	60 days	30 days	14 days
Max. Topcoat w/ Polyurethanes	30 days	21 days	7 days	4 days

**NOTE:** All dry times are cut in half when using MFI-577-4 Accelerator.

#### POTLIFE

32°F (0°C)	50°F (10°C)	70°F (21°C)	90°F (32°C)
24 hours	8 hours	2 hours	1 hour



# INDUSTRIAL COATINGS

## TECHNICAL DATA SHEET

**MFI-575/575B/575W EPOXY MAX  
INDUSTRIAL EPOXYPRIMER**

### ADDITIONAL SURFACE PREPARATIONS

- Steel** Remove all loose rust, dirt, grease and other contaminants from surface. The surface must be abrasive blasted or mechanically abraded. Desired finish will determine how coarse or fine to abrade surface.
- Galvanized Steel** Remove all oil or soap film with a detergent or emulsion cleaner. Lightly blast with a fine abrasive or use a zinc phosphate conversion coating before applying EPOXY MAX. **Not recommended over chromate sealed galvanizing.**
- Aluminum** Remove oil, grease or soap film with a neutral detergent or emulsion cleaner treat with conversion coating or blast lightly with fine abrasive.
- Concrete** Acid etch or abrasive blast new concrete cured a minimum of 14 days.

### APPLICATION EQUIPMENT

- Airless Spray** Standard equipment having a 45:1 or higher pump ratio, with a 0.017 – 0.021 inch fluid tip.
- Conventional Spray** Industrial equipment, such as DeVilbiss MBC or JGA or Binks 18 or 62 spray gun. A moisture and oil trap in the main air supply line, a pressure material pot with mechanical agitator and separate regulators for air and fluid pressures are recommended.
- Brush or Roller** Natural bristle brush or 3/8" nap roller with a solvent resistant core. More than 2 coats may be required to achieve desired thickness.

### TECHNICAL DATA:

Property	Method	Result
Sheen		Semi-gloss
Salt Spray Resistance – 1000 Hrs.	ASTM B117	Excellent
Chemical Resistance		Excellent
Abrasion Resistance		Good
Substrates		CRS, Galvanized Steel, Aluminum, Concrete
Recommended Topcoat(s)		MFI-5000 Series, MFI-5100 Series, MFI-5200 Series, MFI-5300 Series, MFI-5500 Series

### PHYSICAL PROPERTIES:

Property	
Weight per gallon	11.7 lbs./gal.
Weight Solids (%)	55.0 ± 2.0
Volume Solids (%)	85 ± 2.0
Flash Points	
MFI-575/575B/575W Primer	131°F (55°C)
MFI-576 Activator	92°F (33.33°C)
VOC (less exempts)	1.5 lb./gal.
VOC (actual)	1.4 lb./gal.
Coverage (@4mils, no loss)	341 sq. ft./gal.
Shelf Life	12 months

#### See Safety Data Sheet and labels for additional safety information and handling instructions.

- The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels and SDSs of all component, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls, and or lack of Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Always observe all applicable precautions and follow good safety and hygiene practice.
- For additional health and safety information refer to the SDS which can be found at [www.mfisystems.com](http://www.mfisystems.com)

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