

# TIE COAT PRIMER

## General Purpose Primer



- Smooth finish provides an excellent bonding surface for topcoats.
- Can be used as a metal primer or as a tie coat.
- Compatible with all Pettit antifouling bottom paints as well as all Pettit topside paints.
- Applicable above and below the waterline.

6627 Tie Coat Primer is a general-purpose chlorinated rubber type product used as a primer on metal surfaces and as a tie coat between different types of coatings. This versatile product can be used successfully above and below the waterline as a primer and over a variety of coatings as a tie coat. It is compatible with all Pettit antifouling bottom paints and topside finishes. 6627 Tie Coat Primer can also be used on new and bare wood on boat bottoms to seal the wood before applying an antifouling paint.

### TECHNICAL INFORMATION

**VEHICLE TYPE:** Chlorinated Rubber  
**FINISH:** Flat  
**COLOR:** Burnt Orange  
**COMPONENTS:** One  
**CURING MECHANISM:** Air Dry/Oxidation  
**SOLIDS BY WEIGHT:** 57 ± 2%  
**SOLIDS BY VOLUME:** 35 ± 2%  
**COVERAGE:** 225 ft<sup>2</sup>/gal. (spray)  
 280 ft<sup>2</sup>/gal. (brush or roller)  
**VOC:** 562 grams/liter (4.69 lbs/gal) (max)  
**APPLICATION METHOD:** Brush, roller, airless or conventional spray  
**NUMBER OF COATS:** 1 or 2  
**FLASH POINT:** 64°F

**DRY FILM THICKNESS:** 2 mils (spray)  
 2.5 mils (brush or roller)  
**APPLICATION TEMP:** 5°F Min / 100°F Max  
**THINNER:** 97 Epoxy Thinner  
**DRY TIME:** Minimum time in hours

	TO RECOAT	TO TOPCOAT
<b>90°F</b>	1 hr	2 hr
<b>70°F</b>	2 hr	4 hr
<b>50°F</b>	4 hrs	8 hrs
<b>30°F</b>	8 hrs	16 hrs
<b>10°F</b>	3 hrs	3 hrs

The above dry times are minimums.

**ASSOCIATED PRODUCTS:** D95 Dewaxer, 97 Epoxy Thinner, Pettit Antifouling Paint, Pettit Topside Paints, 6980 Rustlok® Primer

Tie Coat Primer is heavily loaded with protective ingredients. As a result of this there is a tendency for settling to occur, especially if the paint has been on the shelf for several months. It is necessary to thoroughly mix the paint before using. If possible shake the can of paint on a mechanical paint shaker. Before using check the sides and bottom of the can to make sure all the pigment has been mixed in. If mixing is going to be done with a wooden paddle or an electric drill mixer, pour off half of the liquid from the top of the can into another can and then properly mix in any settled pigment; then remix the two parts together thoroughly.

Adhere to all application instructions, precautions, conditions and limitations to obtain optimum performance. Refer to individual labels and tech sheets for detailed instructions when using associated products, etc.

Do not thin Tie Coat Primer more than 10% (12 ounces per gallon) or inadequate paint film thickness will occur.

**COATING PERFORMANCE, IN GENERAL, IS PROPORTIONAL TO THE DEGREE OF SURFACE PREPARATION. FOLLOW ALL RECOMMENDATIONS VERY CAREFULLY, AVOIDING ANY SHORTCUTS.**



**APPLICATION INFORMATION:** Shake or stir the 6627 Tie Coat Primer thoroughly. Apply by brush, roller or spray. Thinning is not normally required for brush or roller application, however, small amounts of 97 Epoxy Thinner may be used if necessary, to facilitate application. For spraying, use 97 Epoxy Thinner at levels of 5-10% by volume to ensure a smooth finish with minimal orange peel. Wet film thickness un-thinned should be 5.7 to 7.1 mils per coat, which yields 2.0 to 2.5 mils dry film thickness.

**PREVIOUSLY PAINTED FIBERGLASS SURFACES (OLD TIN COPOLYMERS):** The surface to be painted must be dry, clean and free of any contamination or foreign matter. High pressure wash, scrub, then sand the old bottom paint with 80 grit sandpaper. Apply one coat of 6627 Tie Coat Primer to seal the tin copolymer bottom paint. Allow 6627 Tie Coat Primer to dry 4 hours and apply antifouling paint.

**OUTDRIVES:** Scuff existing paint and primer with 80 grit sand paper, solvent clean surface with 120 Brushing Thinner. Apply two coats of Pettit 6627 Tie Coat Primer, allowing the proper dry time between coats (see dry time chart) before sanding lightly with 80 grit sandpaper and applying appropriate antifouling paint. This is a simplified system for outdrives needing primer or experiencing corrosion. Please consult your Pettit representative or the Pettit Technical Department for more complex, professional systems. Always read the labels or technical data sheets for all products specified herein before using.

**ANTIFOULING BOTTOM PAINT:** All Pettit antifouling bottom paints may be applied directly over 6627 Tie Coat Primer. Allow the 6627 Tie Coat Primer the proper drying time prior to applying antifouling paint.

**BARE STEEL:** Sandblast or disc sand to a clean, bright finish then remove residue. Immediately apply two coats coat of 6980 Rustlok Primer and allow to tack dry; follow with two coats of 6627 Tie Coat Primer, allowing the proper dry time between coats (see dry time chart). Apply finish coats.

**BARE WOOD:** Sand entire surface with 80 grit paper; wash clean with 120 Brushing Thinner. Apply a coat of 6627 Tie Coat Primer thinned 25% with 97 Epoxy Thinner, allow an overnight dry, lightly sand and wipe clean.

**STAINLESS STEEL, TRIM TABS AND BRONZE THROUGHHULLS:** Consult the Underwater Metal Systems technical bulletin.

**TOPSIDE FINISHES:** All Pettit topside finishes are compatible with Tie Coat Primer. If the surface is sufficiently smooth, Pettit enamels may be applied directly over Tie Coat Primer. If the surface needs additional smoothing, use 6149 EZ Prime as a base over Tie Coat Primer followed by the topside product of your choice.

**NOTE:** DO NOT USE COPPER OR CUPROUS OXIDE BASED ANTIFOULING COATINGS ON ALUMINUM.

**MAINTENANCE:** No paint can be effective under all conditions of exposure. Man-made pollution and natural occurrences can adversely affect paint performance. Extreme hot and cold-water temperatures; silt, dirt, oil, brackish water and even electrolysis can ruin a paint. Therefore, we strongly suggest the coating be checked regularly.