### Product Description

**CenturyExtreme™ 184 Series**

**Epoxy Primer**

The **CenturyExtreme™ 184 Epoxy Primer** is a high solid, HAP Free (Hazardous Air Pollutant), VOC Compliant, two component, epoxy coating designed to provide excellent water resistance, corrosion resistance and acid and alkali chemical resistance to properly prepared steel structures. The CenturyExtreme™ 184 Epoxy Primer is easily applied with standard airless spray application equipment and requires no additional thinner or induction time (“sweat-in”). The 184 Series is designed to be used as part of a high performance Epoxy/Urethane system and can be used in conjunction with the Century high-performance finish coats.

Colors Available:
- Salmon

### Recommended Uses

The CenturyExtreme™ 184 Series is intended for use over prepared steel substrates and is recommended in the following areas:
- Heavy Equipment
- Railcar Manufacturing and Refurbishment
- High Performance Steel Tank (Primer, Exterior)
- Marine/Industrial Maintenance
- OEM Fabrication and Maintenance

### Technical Data

- **Coating Type:** Epoxy/Polyamide
- **Finish (60°):** Low Sheen
- **VOC (mixed):** 2.3 lbs. /gal
- **Solids by Weight:** 81 +/- 1%
- **Solids by Volume:** 68 +/- 1%

### Application Data

- **Mixing Ratio:** 1:1 By Volume
- **Pot Life:** 2-3 Hrs. @77°F, 50% RH
- **Coating Thickness:** 3-7 Mil DFT
- **Coverage:** 230 sq.ft. @ 5 mil DFT
- **Dry-to-Touch:** 2-3 hr. @ 77°F
- **Dry-to-Handle:** 3-4 hr. @ 77°F
- **Full Cure:** 7-10 Days
- **Re-coat (77°F):** 3-4 hrs. Min, 72 hrs. Max
- **Airless Tip Size:** 0.015” – 0.019”
- **Airless Spray Pressure:** 2,500 – 3,000 psi

### Surface Preparation

Century Extreme™ 184 Series Epoxy Prime should be applied over a surface prepared to SSPC-SP 6, 7 or 10 with a 1.5-2.0 mil (35-50 micron) abrasive blast profile. Poor surface preparation will reduce the overall performance and service life of the coating. For best results, surfaces should be clean, dry and free of loose rust, dust, dirt, oil, grease, salt deposits or other contaminants. Test an inconspicuous area for lifting or softening of existing coating prior to full application.
Mixing and Thinning

This is a TWO component product and MUST be properly activated prior to use, otherwise it WILL NOT DRY. Power mix each component separately for 3-5 minutes to re-disperse any solids that may have settled during transit. Combine ONE (1) VOLUME of Part A= Activator, with ONE (1) VOLUME of Part B= Base, and mix for 3-5 minutes until uniform. If thinning is desired, reduce with Century thinner, xylene/MEK, or epoxy thinner, adding no more than 3-5% by volume for spray. Consult with Century Industrial Coatings representative for thinning amounts for specific VOC requirements. Mixed components have a 2.0-3.0 hour pot life @ 77˚F. Combine (A&B) and mix only that amount of material which can be applied within 2 hours. Higher temperatures shorten useable pot life. Unmixed components may be sealed in original containers for future use.

Application

Apply only in good weather or in covered areas protected from environmental conditions. Substrate and air temperatures must be at least 5°F (3°C) above the dew point and rising. Avoid painting late in the day when temperatures fall and relative humidity increases toward the dew point. Water condensation on the new film may cause surface imperfections and poor cure. Avoid placing freshly painted components outdoors under wet, rainy conditions. Lower temperatures (< 60°F) will increase dry times. Do not use this product when temperatures fall below 50°F as slow cure will occur and curing may stop completely below 45°F. Temperatures above 90°F will substantially shorten dry times and reduce pot life. Substrate temperatures above 120°F may cause the product to sag, curtain, or run. Application using conventional pressure pot spray, airless spray, or air-assisted airless spray equipment is recommended. These products may be brushed or roller applied in small areas or applied by brush for touch-up. Use nylon or other good quality brushes designed for solvent-based paints. Use ¼” rosin core roller covers designed for solvent-based paints.

Notes

Flush all paint supply lines immediately after application. Clean equipment with MEK, Xylene, or Century thinner. Use soap and water to remove any material from hands or skin. This product does not contain volatile solvents. However, it is important to provide adequate ventilation during application of this coating and ventilate the area until the coating is cured. Provide ventilation and monitor the mist levels to limit exposure to levels below guidelines on the SDS. If unsure of mist levels, use MSHA / NIOSH approved fresh air supplied respirators or full fresh air supplied hoods. Avoid prolonged contact with skin and avoid breathing of spray mist. Persons with hypersensitivity to epoxy/polyamine paints should avoid all contact with this product. It is recommended that persons should wear protective clothing, gloves and use protective barrier creams on hands, face and all exposed body parts. Read and understand the Safety Data Sheet before using the 184 Series. Solid waste generated from use of this product after mixing Parts A&B together is considered non-hazardous. All waste should be disposed of in accordance with local, state, and federal solid waste regulations. Use fiberglass filters for spray booth operations. Follow OSHA regulation 1910.107 (CFR 29) pertaining to spray finishing. Dispose of used filters according to OSHA 1910.107(b) (5) (ii). Information on spray paint regulations and proper disposal may be obtained at the website www.osha.gov.

Contact Century

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