



www.medallionrefinish.com

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RS-780/788/789/781 TECHNICAL DATA

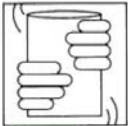
Epoxy Primer

DESCRIPTION:

RS-780 Epoxy Primer is a fast dry, fast curing epoxy that has excellent corrosion resistance and adhesion. This epoxy primer can be used on all properly prepared metals and plastics. **RS-780 Epoxy Primer** can be topcoated with any topcoat system including acrylic lacquer. Available in quarts and gallons and three colors for increased basecoat hiding. (**RS-780** gray, **RS-788** black and **RS-789** white)

FEATURES:

- ✓ Can be topcoated in 30-60 minutes @ 72°F (22.2°C)
- ✓ Can be used as a primer surfacer or a sealer
- ✓ Excellent corrosion resistance even in harsh environments
- ✓ Superior humidity resistance
- ✓ Simple 1 to 1 mix ratio
- ✓ Tintable
- ✓ Excellent color hold-out
- ✓ Superior adhesion to bare steel, sanded fiberglass and etched or sanded aluminum
- ✓ Economically priced



INSTRUCTIONS:

Shake the **RS-780/788/789 Epoxy Primer** thoroughly before mixing.

GUN SETUP:

Conventional Gravity	1.6mm -1.8mm	40-45 psi @ gun
Siphon	1.6mm -1.8mm	40-45 psi @ gun
HVLP gravity	1.6mm -1.8mm	8-10 psi @ gun

MIXING:

Mix 1 part **Epoxy Primer** to 1 part **RS-781 Epoxy Primer Activator**

(Optional) **RS-780 Epoxy Primer** can be reduced 5-10% with **Urethane Grade Reducer**. Adding reducer will increase sprayable V.O.C.'s and decrease dry film thickness (DFT)

(Note) For spray temperatures over 100°F (37.8°C) and 1 oz. of **RS-1899 Retarder Solvent** to improve flow, leveling and cure through.

(Note) Do not apply synthetic enamels over **RS-780 Epoxy Primer**.

Reducers:

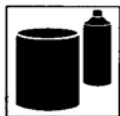
RS-1860	Fast Urethane Grade Reducer
RS-1870	Medium Urethane Grade Reducer
RS-1885	Slow Urethane Grade Reducer
RS-1895	X-Slow Urethane Grade Reducer

RS-780-TDS
Revised 3/11



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TINTING:

RS-780 Epoxy Primer can be tinted using Rubber Seal Universal Primer Tints at no more than 5% by weight (approx. 50 grams per quart of unreduced **RS-780 Epoxy Primer**) **RS-780 Gray**, **RS-788 Black** and **RS-789 White** can be mixed together to product varying gray shades for improved basecoat hiding.



SURFACE PREPARATION:

Wash area with soap and warm water. Thoroughly clean area with **RS-608 Slow Wax and Grease Remover** or **RS-609 Wax and Grease Remover**. **RS-610 Water Base Pre-clean** can be used where VOC restrictions are in effect. All corrosion should be removed and metal prepared as for any paint application. Old finishes must be properly sanded and cleaned with **RS-609 Wax and Grease Remover** (or equivalent). Aluminum must be thoroughly sanded or etched before applying **RS-780 Epoxy Primer**.



Sand area according to body filler manufacturer's recommendations. Reclean with **RS-608**, **RS-609** or **MRS-612**.



APPLICATION:

Apply 1-2 full wet coats of **RS-780 Epoxy Primer** using a good quality spray gun with a 1.6 to 1.8 tip. Allow 10-15 minutes flash time between coats. Dry film thickness should be .75-1.0 mils. Allow 30-60 minutes @ 70°F (21°C) air dry before topcoating. **RS-780 Epoxy Primer** can be baked for 20 minutes @ 140°F (60°C). Allow 60-90 minutes @ 70°F (21°C) cure time before applying polyester body filler over **RS-780 Epoxy Primer**.



SANDING:

Allow **RS-780 Epoxy Primer** to thoroughly cure before sanding. **RS-780 Epoxy Primer** can be lightly sanded after 24 hours.

RUBBER-SEAL®

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Refinish System



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TECHNICAL DATA

Color	Gray, Black & White
Activator/Hardener	781
Reducer	RS-1860,1870,1885,1895 (adding reducer will increase VOC)
Mix Ratio	1:1 Reducer Optional
Pot Life	8 hrs @ 70°F(21°C) 50% RH.
Number of Coats	1-2
Dry film Thickness (DFT)	0.75-1.0 mil
Flash Time	10-15 minutes
Recoat w/o sanding	30-60 minutes
Dry to Sand 70°F(21°C) 50% RH	24 hours
Air Dry 70°F (21°C) 50% RH	30-60 mins. @70°F (21°C)
Force Dry	20 mins. @140°F (60°C)
Gun Set-Up Gravity Feed (HVLP)	1.6mm – 1.8mm
Air Pressure @ Gun HVLP	8 – 10 psi
Air Pressure @ Gun Conventional	40 -45 psi
V.O.C. Limit	5.0 lbs/gal (600 g/l)
Sprayable V.O.C.*	2.92 lbs/gal (318 g/l)
% Solids Sprayable by Weight	33%
Coverage Sq. Ft. / gal @ 1 mil*	389 sq. ft.
Package	4 Gallon 6 Quarts
Number per case	4 6
Shelf Life	12 months

(Note) The topcoat window of RS-780 Epoxy Primer is 30 minutes to 24 hours.
After 24 hours the primer must be scuffed or lightly sanded before topcoating.
After 72 hours sand, re-apply RS-780 and then topcoat.

Material Safety Data Sheet (MSDS) is available on our website
www.medallionrefinish.com