



EkoPoly Premium / EkoCrylic - Top coat paint E22XXX / E5XXX

EkoPoly Premium and EkoCrylic are High Performance 2 part catalyzed top-coat paints which are flexible, durable, and easy to apply. EkoPoly Premium may be used on Fabric, Metal, Composite, and Wood surfaces. EkoCrylic is for hard surfaces only and may not be used on fabric.

Surface Prep

Surface prep is very important with waterborne coatings. If the primed surface was washed with water it must dry over night. When painting over EkoFill wait 8 hours @75 deg F. before painting. Over EkoPrime or EkoPoxy wait 4 hours @ 75 deg F. before painting. Maximum adhesion is achieved by scuffing the surface with 320 – 400 grit sand paper and/or Red Scotch-Brite to achieve the proper “tooth” for the paint. **ALL sanding residue and other contaminants must be removed prior to painting.** Use tack-rags that are compatible with waterborne coatings and while blowing with clean dry shop air wipe the surface multiple times to remove sanding residue. Use low angle lighting and look across the surface to verify that all sanding residue has been removed. Follow up by wiping the surface **lightly** using a lint free towel saturated with 91% Isopropyl Alcohol to pick up any remaining residue. Let dry 5 min before painting so that all the alcohol has evaporated. You may wish to lightly wipe down the surface with a tack rag one more time to remove any lint from the surface.

Mixing EkoPoly Premium and EkoCrylic

The most precise and efficient way to mix the catalyst and water with the Part A paint is by weight, not volume. We have included instructions for both, however, we strongly recommend mixing by weight. If using volume it is very important to check the viscosity. An inexpensive digital 2000 gram scale is available from Stewart Systems, but may also be sourced from a local department store or other online retailers. If using a viscosity cup it is important to use a Ford #4, or a DuPont M50 if you have one already. (the M50 is no longer available)

Mixing by Weight:

The paint is mixed 4:1:1 by weight. For example, if you use 100 grams of Part A paint, the amount of catalyst needed is 25 grams (25% of Part A amount). Mix the Part A and catalyst thoroughly. Let sit for 5 minutes. Add 1 part distilled water and mix thoroughly. (same amount of water as catalyst). Let sit for 5 minutes, then it is ready to spray. If desired for your particular spray technique, equipment or environment it is permissible to adjust water amount slightly, but be cautious, a little water goes a long way.

Mixing by Volume:

The ratio for mixing by volume is 3:1:1. This different ratio is due to the fact that the specific gravity of the Part A and catalyst are significantly different. Use a mixing cup that has the 3:1:1 ratio. Pour part A up to the desired line on that scale, followed by the catalyst to the correct line on that scale. Mix thoroughly. Allow to stand for 5 minutes. Next, add about 1/2 of the amount of distilled water necessary to bring it up to the next line in that scale. Mix thoroughly and let sit for 5 minutes. Check viscosity with a Ford #4 viscosity cup. The viscosity should be 21-23 seconds on the Ford #4 cup for normal spray applications. If you have an M50 viscosity cup, the desired viscosity is 22-24 seconds. Remember, water can only be added, not removed! Be cautious when adding water.

Use a 125 micron paint strainer when pouring into your gun.



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Caution!! Only use new mixing containers and stir sticks for mixing paint. Do not use any container that had food or other products in them or you risk contaminating the top coat. Never use any thing that may contain oils, fats, solvents or silicone! If you wish to reuse mixing cups, clean with water and EkoClean only, never solvents.

Before painting make sure to verify that your air system is sufficient to run your spray gun. Spray guns require a very large amount of air (typically 13 CFM minimum) to operate properly. Typically you will need a 220V 5 horsepower or greater compressor to run a paint gun. Many poor paint jobs are due to lack of air volume.

Clean up with Soap and Water - Diluted EkoClean works very well. You may also use isopropyl alcohol to remove any remaining residue from spray equipment while it is still tacky.

Spray Pattern Testing – Proper paint gun setup makes a difference!

The Paint may be sprayed with any modern spray gun. We recommend an HVLP, RP, or HE type spray gun. The Devilbiss Finishline and Tekna Pro Lite work very well with our products and may be purchased from Stewart Systems. Follow the manufacturer's instructions regarding set up and testing of the spray gun. ALWAYS spray out test panels first to set up your spray gun. Never learn how to paint on parts you just spent months building. Recommended tip size is 1.2-1.4 mm. Refer to our air system set up guide for details on maximizing air flow to your paint gun. Avoid airflow restrictions as much as possible. It's not just about PSI, you need the proper amount of CFM as well. There is quite a lot of information on the internet regarding spray pattern testing and spray gun set up. Take time to educate yourself on this subject to avoid problems when painting.

Spray application

Apply the paint with a fog-coat/wet-coat. The fog coat is used to build color saturation and the wet coat is what gives you depth and gloss. First spray light dry fog coats, building up to color saturation but **never let the surface become wet and shiny**. The surface should have a texture similar to 1000 grit sand paper. To keep the surface dry when spraying the fog coat hold the gun about 10-12" from the surface and move very quickly with a very tight overlap. By holding the gun a little further from the surface and moving very quickly you avoid getting a wet coat. Let the fogcoat tack up to where it feels like a post-it note sticky tackiness. Use a bare knuckle and lightly touch the surface checking the tack. It should be sticky but with no color transfer. Typical time between tack coat and wet coat is 5-10 minutes minimum. If you feel that you have lost your tack then spray a fast dry fog-coat over the area to bring the tack back up. You don't need color just tack. You can then spray out your wet-coat. Move the gun closer to the surface 6-7" and slow your pace down slightly still maintaining a very tight overlap. You are much better off to bring the surface up to a wet shine by making many passes over the same area instead of moving slowly where the wet gloss comes right behind the gun. Sneak up on the gloss and you will reduce the chance of runs. If the surface does not have the wet look you may get some orange peel in your finish. The full wet gloss should come about 1-2 seconds behind the gun as you layer up the film thickness by making multiple tightly overlapped passes across the surface.

Adding trim colors or re-painting

Let dry overnight. Regardless of how much time has elapsed wipe the surface with Isopropyl Alcohol to remove any surface film before scuffing the surface with Scotch-Brite. Tack-Rag and wipe again with Alcohol before painting. We recommend removing masking immediately after painting so that the edge of the trim paint lays over nicely instead of becoming a hard sharp edge. Removing the masking tape while the paint is still wet also lets you remove any bleed under by wiping with a rag dampened with lacquer thinner.

Recommended application

60-85 deg F - 15-75% humidity

1.2 -1.4 mm nozzle

21-23 seconds in Ford #4 cup, or 22-24 seconds in Dupont M50 after a 5 min induction time

Time between coats Fog-coat to Wet-Coat 5-10 min / Wet-coat to Wet-Coat 35-45 min

Time to dust free 4-5 hours

Time to re-paint or add trim colors 24 hours

Maintain 65° F for 12 hours before allowing to get colder.