- 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.
- Recommended 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. When used over Pettit 6455/044 Metal Primer it forms an excellent, easy to use system for use on all underwater running gear. 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.

PHYSICAL DATA

VEHICLE TYPE.....Chlorinated Rubber

FINISH.....Flat

COLOR.....Burnt Orange

COMPONENTS....One

CURING MECHANISM....Air dry/oxidation

SOLIDS (theoretical)

By weight.....57 ± 2%

By volume....35 ± 2%

COVERAGE.....225 sq. ft/gal. (spray)

280 sq. ft/gal. (brush or roller)

VOC....562 g/l (4.69 lbs/gal)

FLASH POINT....64°F

APPLICATION DATA

METHOD.....Brush, roller, airless or conventional spray.

NUMBER OF COATS....One or two

DRY FILM THICKNESS PER COAT.....
2.0 mils (spray) / 2.5 mils (brush or roller).

APPLICATION TEMP..... 5° F. Min. / 100° F. Max.

APPLICATION HUMIDITY....
0% R.H. min. / 90% R.H. max.

DRY TIME (Hours)

Substrate Temp	To Recoat	To Topcoat
90°F	1	2
70°F	2	4
50°F	4	8
30°F	8	16

If these recommended intervals are exceeded, sand thoroughly with 80 grit sandpaper before recoating or applying bottom paint.

THINNER/ Cleaner 97 Epoxy Thinner

ASSOCIATED PRODUCTS

95 Dewaxer

97 Epoxy Thinner

6455/044 Metal Etching Primer

Pettit Antifouling Paint

www.pettitpaint.com - (800) 221-4466

An **RPM** Company

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 unthinned should be 5.7 to 7.1 mils per coat, which yields 2.0 to 2.5 mils dry film thickness.

Surface Preparation: Coating performance, in general, is proportional to the degree of surface preparation. Follow recommendations carefully, avoiding shortcuts. Inadequate preparation of surfaces will virtually assure inadequate coating performance.

SYSTEMS

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.

Bare Aluminum Hulls or Outdrives: Clean surface to be painted with coarse scotchbrite pads and Pettit 95 Dewaxer. Abrade to clean, bright metal by sandblasting, sanding or wire brushing. Blow off or vacuum sanding residue and immediately apply one thin coat of Pettit 6455/044 Metal Primer. Let dry two hours and 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 smaller vessels. 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.

NOTE: Do not use copper or cuprous oxide based antifouling coatings on aluminum.

Bare Steel: Sandblast or disc sand to a clean, bright finish then remove residue. Immediately apply one thin coat of 6455/044 Metal Primer and allow to dry two hours; follow with two coats of 6627 Tie Coat Primer, allowing the proper dry time between coats (see dry time chart). Apply finish coats.

Stainless Steel, Trim Tabs and Bronze Throughhulls: Follow the "Bare Aluminum Hulls or Outdrives" system above.

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.

TOPCOATS

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.

Topside Finishes: All Pettit, Z*Spar, and Shipendec topside finishes are compatible with 6627 Tie Coat Primer. If the surface is sufficiently smooth, any Pettit, Z*Spar, or Shipendec topside product may be applied directly over 6627. If the surface needs additional smoothing, use Pettit 6149 EZ Prime as a base over the 6627.