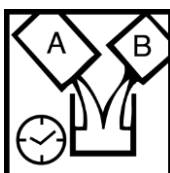


2.1 VOC DTM Urethane

High Solids Urethane Primer-Sealer E2N816, E2W817, E2B818, E2A819

PRODUCT OVERVIEW

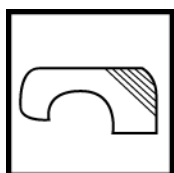
E2N816/E2W817/E2B818/E2A819 High Solids Urethane Primers are air dry or low bake, direct-to-metal, high performance urethane primers designed for Fleet, Truck and Original Equipment Manufacturers that require a VOC compliant system. E2N816/E2W817/E2B818/E2A819 High Solids Urethane Primers have a VOC of 2.1 pounds per gallon and have a range of hardeners to customize cure speed and application. Available in Tan, White, Black, and Gray.



SUITABLE SUBSTRATES

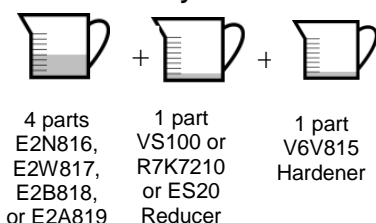
- Cold rolled steel
- Hot rolled steel
- Galvanized steel
- Galvaneal
- SMC
- Aluminum
- Fiberglass

NOTE: Not for use on immersed surfaces. Not for use on surfaces with extended surface temperatures of 250°F or more.



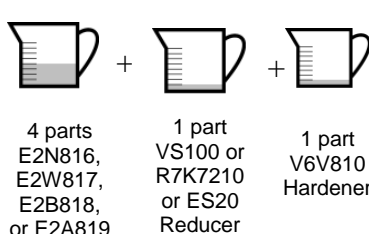
MIXING

Plural System Mix



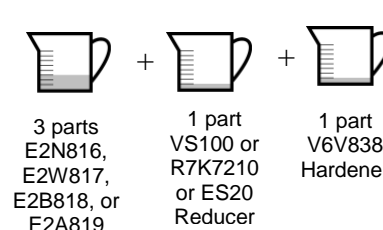
Pot Life: 30-45 minutes

Cup Gun Mix

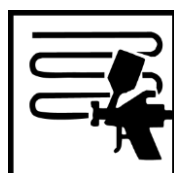


Pot Life: 60-75 minutes

Pressure Pot Mix



Pot Life: 1-2 hours



APPLICATION

Apply 1 wet coat or 2 medium coats of High Solids Urethane Primer-Sealer to achieve a dry film thickness of 2.0-2.5 mils mils.

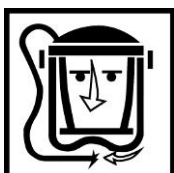
1. HVLP: Adjust air pressure at cap to 8-10 psi.
2. For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.
3. Conventional: For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.

DRYING SCHEDULE

Standard Air dry: at 75°F and 2.0 mils, dry times will be extended by thicker films. Higher temperatures and/or humidity will decrease dry times.

Drying Schedule was tested by using V6V815 w/ 1 oz. GA1097 per sprayable gallon

Hand Slick	<5 minutes
Topcoat	15 minutes
Dust Free	30 minutes
Tack Free	45 minutes
Dry to Sand	1 hour



PERSONAL PROTECTION

- Read all label directions before use.
- Refer to SDS for specific information.
- Wear positive-air respirator when mixing and applying.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety goggles, coveralls, and latex gloves when using product.



SHERWIN-WILLIAMS®
Product Finishes

2.1 VOC DTM Urethane

High Solids Urethane Primer-Sealer
E2N816, E2W817, E2B818, E2A819

PRODUCT DATA SHEET



SURFACE PREPARATION

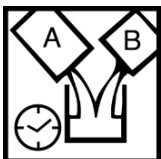
- **Solvent clean** with the appropriate Sherwin-Williams® solvent cleaner, and wipe dry with a clean cloth.
- **Abrade** all bare metal surfaces with 220 or 320 grit sandpaper, or a red Scotch® Brite pad.
- **Apply** body filler to clean bare metal as needed.
- **Solvent clean** again with appropriate Sherwin-Williams® solvent cleaner to remove sand residue.



SUITABLE SUBSTRATES

- Cold rolled steel
- Hot rolled steel
- Gavanized steel
- Galvaneal
- SMC
- Aluminum
- Fiberglass

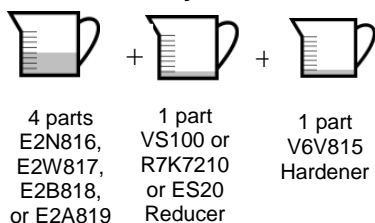
NOTE: Not for use on immersed surfaces. Not for use on surfaces with extended surface temperatures of 250°F or more.



MIXING

- Stir or shake HS Urethane Primer thoroughly before mixing.
- For **Plural System Mix**, mix 4 parts HS Urethane Primer with 1 part VS100 or R7K7210 Reducer and 1 part V6V815 Hardener.
- For **Cup Gun Mix**, mix 4 parts HS Urethane Primer with 1 part VS100 or R7K7210 Reducer and 1 part V6V810 Hardener.
- For **Pressure Pot Mix**, mix 3 parts HS Urethane Primer with 1 part VS100 or R7K7210 Reducer and 1 part V6V838 Hardener.
- Stir thoroughly and strain before mixing.

Plural System Mix



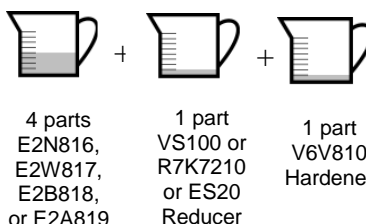
4 parts
E2N816,
E2W817,
E2B818,
or E2A819

1 part
VS100 or
R7K7210
or ES20
Reducer

1 part
V6V815
Hardener

Pot Life: 30-45 minutes

Cup Gun Mix



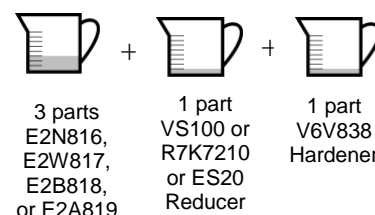
4 parts
E2N816,
E2W817,
E2B818,
or E2A819

1 part
VS100 or
R7K7210
or ES20
Reducer

1 part
V6V810
Hardener

Pot Life: 60-75 minutes

Pressure Pot Mix



3 parts
E2N816,
E2W817,
E2B818,
or E2A819

1 part
VS100 or
R7K7210
or ES20
Reducer

1 part
V6V838
Hardener

Pot Life: 1-2 hours

REDUCER	TEMPERATURE RANGE
VS100	50-75°F
R7K7210 or ES20	75-90°F

NOTES:

- For increased temperatures, R7K7210 or ES20 can be used for improved overspray acceptance and melt-in.
- Up to 2 oz. of GA1097 Accelerator may be added to 1 gallon of Ready To Spray blend of the above to reduce dry times. Each ounce of GA1097 increases the VOC of the product 0.06 lbs/gal.

TINTING: E2N816/E2W817/E2B818/E2A819 can be blended together by volume, or can be tinted by using up 10% by volume of Genesis Monochromatic solid color toners.

Do not use GENESIS® metallic toners to tint product.

2.1 VOC DTM Urethane

High Solids Urethane Primer-Sealer
E2N816, E2W817, E2B818, E2A819

PRODUCT DATA SHEET



APPLICATION

1. HVLP: Adjust air pressure at cap to 8-10 psi.
2. For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.
3. Conventional: For pressure feed applications, adjust air pressure at the gun to 50-55 psi with a fluid delivery of 8-12 ounces per minute.
4. Apply 1 wet coat or 2 medium coats of High Solids Urethane Primer-Sealer to achieve a dry film thickness of 2.0 mils-2.5 mils.

EQUIPMENT

Gun Type

Conventional Gravity Feed
Conventional Pressure Feed
HVLP Gravity Feed
HVLP Pressure Feed

Nozzle

1.3-1.5 mm
0.8-1.1 mm at 8-12 oz/min
1.3-1.5 mm
0.8-1.1 mm at 8-12 oz/min

Air Pressure

50-55 psi
50-55 psi
8-10 psi at cap
8-10 psi at cap

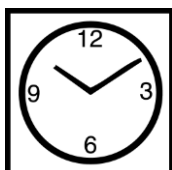
RECOAT

Standard using V6V815 or V6V810 Hardener with or without GA1097 Accelerator

	Min topcoat time w/Accelerator	Min topcoat time w/o Accelerator	Max topcoat time w/ Accelerator	Max topcoat time w/o Accelerator
GENESIS® 3.5/2.8 SS	15-30 minutes	45 minutes	7 days	7 days
GENESIS® Basecoat	15-30 minutes	45 minutes	4 days	7 days
GENESIS® M	15-30 minutes	45 minutes	7 days	7 days
Dimension® 3.5 SS	15-30 minutes	45 minutes	7 days	7 days
Ultra 7000® Basecoat	15-30 minutes	45 minutes	4 days	7 days

When beyond the maximum topcoat time, sanding is mandatory.

NOTE: Minimum recoat times will be extended if substrate and/or ambient temperatures are below 70°F.



DRYING SCHEDULE

Standard Air dry: at 75°F and 2.0 mils, dry times will be extended by thicker films. Higher temperatures and/or humidity will decrease dry times.

Drying Schedule was tested by the following mixes:

	Using V6V815 w/ 1 oz GA1097 per Sprayable Gallon	Using V6V810 w/ 1 oz GA1097 per Sprayable Gallon	Using V6V837 w/ 1oz GA1097 per Sprayable Gallon
Hand Slick	<5 minutes	10 minutes	15 minutes
Topcoat	15 minutes	20 minutes	30 minutes
Dust Free	30 minutes	1 hour	1 hour
Tack Free	45 minutes	1 hour	1 hour
Dry to Sand	1 hour	3 hours	3 hours

Bake: 30 minutes at 180°F without accelerator

Dry to sand – after 15 minutes cool down

Dry to recoat – after 15 minutes cool down and a thorough sanding using 320 or 400 grit paper

NOTE: Dry times can be extended by excess film build, low temp, high humidity, high emersion and high surface temperatures.

TOPCOAT

- Dimension® Topcoats
- ULTRA 7000® Basecoat
- GENESIS® M Single Stage
- GENESIS® G4 Basecoat/Clearcoat
- GENESIS® GC Single Stage
- GENESIS® LV Single Stage

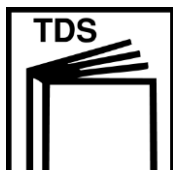


SHERWIN-WILLIAMS®
Product Finishes

2.1 VOC DTM Urethane

High Solids Urethane Primer-Sealer
E2N816, E2W817, E2B818, E2A819

PRODUCT DATA SHEET



TECHNICAL DATA

Mixing Ratio by Volume	With V6V815: 4:1:1 With V6V810: 4:1:1 With V6V837: 3:1:1	Physical Properties	
Max VOC @ 4:1:1	2.03 lbs/gal	Salt Spray 500 hours	Pass
Ready to Spray Volume Solids	59 %	Impact Resistance (direct at 80 in-lbs.)	Pass
Coverage @ 1 mil dry	942-952 FT ² /gal	Humidity 100 hours	Pass
Viscosity (sprayable) Gardener #2 Zahn Cup (ISO calibrated)	At 4:1:1: 13-17 sec At 3:1:1: 15-18 sec	Flexiblity (1/8" conical mandrel)	Pass
Recommended Dry Film Thickness	2.0-2.5 mils	Gloss Holdout (at 15 minute recoat)	Excellent

E2N816, E2W817, E2B818, E2A819 Plural System Mix	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	15.17	1818	12.84	1539
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	12.6	27.1	22.9	41.0
Solids	87.4	72.9	77.1	59
Water	0	0	0	0
Exempt Compounds	0	0	9.7	16.6
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	1.90	228	1.69	203
VOC Less Exempt	1.90	228	2.03	243
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.00	0.000	0.00	0.000

E2N816, E2W817, E2B818, E2A819 Cup Gun Mix	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	15.17	1818	12.88	1543
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	12.6	27.1	22.6	40.1
Solids	87.4	72.9	77.4	59.9
Water	0	0	0	0
Exempt Compounds	0	0	9.7	16.6
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	1.90	228	1.66	199
VOC Less Exempt	1.90	228	1.99	239
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.00	0.000	0.00	0.000



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Product Finishes

2.1 VOC DTM Urethane

High Solids Urethane Primer-Sealer
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PRODUCT DATA SHEET

E2N816, E2W817, E2B818, E2A819 Pressure Pot Mix	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	15.17	1818	12.52	1500
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	12.6	27.1	27.8	45.2
Solids	87.4	72.9	72.2	54.8
Water	0	0	0	0
Exempt Compounds	0	0	16.2	24.8
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	1.90	228	1.44	173
VOC Less Exempt	1.90	228	1.92	230
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.00	0.000	0.00	0.000

To learn more about Sherwin-Williams® products, visit our website at oem.sherwin-williams.com/transportation

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