# General Industrial Coatings

CC-A24

# 2.8 VOC Catalyzed Epoxy Primer

Gray..... E61A280
White ..... E61W284
Catalyst ..... V66V282
Custom Blend Series ..... E61EX

## DESCRIPTION

**2.8 VOC Catalyzed Epoxy Primer** is a high solids, two component, epoxy poly amide primer offering excellent adhesion and corrosion resistance without the use of chromates. It is especially suitable for use under Polane® Polyurethane topcoats where superior corrosion resistance is needed.

**Advantages:**

- Excellent corrosion resistance - over 500 hours salt spray
- Excellent primer for farm and construction equipment, machinery, transformers, structural steel and castings when topcoated with Polane Polyurethane
- Excellent holdout of topcoat
- Excellent chemical resistance
- May use plural component equipment
- Fast dry time
- Apply by conventional, airless, HVLP or electrostatic spray
- No induction or "sweat-in" time required
- Passes 1500 hours salt spray when topcoated with Polane HS Plus Polyurethane
- *Formulated to meet 2.8 lbs./gal. VOC, less exempts

**Not Stocked - Special Order Only**

Black..... E61B283

*VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.PaintDocs.Com.

## CHARACTERISTICS

**60° Gloss:** < 20 units

**Volume Solids:** 61 ± 2 %
Catalyzed & reduced

**Viscosity:** 25-30 secs., #3 Zahn Cup
Catalyzed & reduced (suggested application)

**Recommended Film Thickness:**

| | |
|---|---|
| Mils Wet | 3.0-3.6 |
| Mils Dry | 1.8-2.2 |

**Spreading Rate** (no application loss)**:**
445-561 ft.$^2$/gal. at 1.8-2.2 mils DFT

**Drying:** 2.0 mils DFT, 77° F, 50% RH

| | |
|---|---|
| To Touch | 1.0-1.5 hours |
| Tack Free | 2.5-3.5 hours |
| To Topcoat | 20 minutes |
| To Pack | 24 hours |
| Force Dry | 30 minutes at 140° F |

**Flash Point** (Pensky Martens Closed Cup)**:** 63° F

**Mixing Ratio** (by volume)**:**

| | |
|---|---|
| Epoxy Primer | 4 Parts |
| V66V282 | 1 Part |
| Reducer | 0.2 Parts (4% by volume) |

**Potlife:** 4 hours

**Package Life:** 1 year, unopened

**Air Quality Data**

Photochemically reactive Volatile Organic Compounds (VOC) theoretical as packaged, maximum, less exempt solvents:
2.36 lbs/gal, 283 g/L

Volatile Organic Compounds (VOC) catalyzed and reduced, maximum,
2.80 lbs/gal, 355 g/L

## SPECIFICATIONS

**General:** All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

**Aluminum:** If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.

**Galvanized Steel:** If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.

**Steel or Iron:** Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

**Testing:** The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility, and performance prior to full scale application.


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## APPLICATION

Typical Setups

**Reduction:** For 2.8 lbs/gal VOC maximum, reduce up to 4% with R6K10 (MEK), MIBK, R6K18 (Butyl Acetate), or R6K30 (MAK). For higher VOC, reduce up to 10% for easier application.

**Conventional Spray:**

| | |
|---|---|
| Air Pressure | 45-60 psi |
| Fluid Pressure | 10-15 psi |
| Tip | 0.055-0.070 in. |

**Airless Spray:**

| | |
|---|---|
| Fluid Pressure | 2,300-2,700 psi |
| Tip | 0.011-0.015 in. |

**Air Assisted Airless Spray:**

| | |
|---|---|
| Air Assist Pressure | 20-30 psi |
| Fluid Pressure | 800-1,200 psi |
| Tip | 0.011-0.015 in. |

**Electrostatic Spray:**

Polarity should be 0.7-1.5 megohms. Use less polar solvent(s) to adjust.

**HVLP Spray:**

| | |
|---|---|
| Air Pressure | 10 psi |
| Fluid Pressure | 8-10 psi |
| Tip | 0.055-0.070 in. |

**Cleanup:** Clean tools and equipment immediately after use with reducing solvent.

Follow manufacturer's safety recommendations when using any solvent.

## ADDITIONAL INFORMATION

1. This product must be properly catalyzed before using.
2. V66V282 catalyst typically has a light clear yellow to amber color and this is considered normal.
3. Surface preparation is important for performance. The better the preparation, the better the performance.
4. Do not apply at temperatures under 60° F.
5. To maintain 2.8 VOC, may reduce up to 4%. For higher VOC, reduce up to 10% for better application. Reduction higher than 10% is not recommended because of low viscosity.
6. If parts have been stored for longer than one week after priming, they must be sanded before topcoating.
7. On blasted surfaces, primer must be at least one mil greater than the profile to ensure best corrosion resistance.
8. Compatible with Opticolor Express and Phoenix colorants. Do not add more than 2 ounces Opticolor express per gallon of paint.

**Performance Tests***

Substrate: 24 gauge Bonderite® 1000 panels
Primer: 2.0 mils DFT, 2.8 VOC Catalyzed Epoxy Primer
Cure: 14 Days, Air Dry

| | |
|---|---|
| Salt Spray Test | 500 hours |
| (ASTM B117) 1/16" creep maximum, no blisters | |
| Humidity (100° F, 100% RH) | 1,000 hours |
| (ASTM D2247) 1/16" creep maximum, no blisters | |
| Conical Mandrel, 1/4" | |
| ASTM D633 | Pass |
| Impact Resistance, Direct | |
| ASTM D2794 | 20 in lb |
| Impact Resistance, Indirect | |
| ASTM D2794 | 10 in lb |
| Pencil Hardness | |
| ASTM D3363 | 4H* |

Primed panels (as above) topcoated with 1.5 mils DFT Polane HS, cured 14 days

| | |
|---|---|
| Salt Spray Test | 1,500 hours |
| (ASTM B117) | no blisters, no adhesion loss |

*Performance test results may vary depending on dry film thickness, substrate tested and post-cure duration.



## CAUTIONS

**FOR INDUSTRIAL SHOP APPLICATION ONLY**

**Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.**

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.PaintDocs.Com.

Please direct any questions or comments to your local Sherwin-Williams facility.

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