# Product Finishes

## 2.8 VOC Catalyzed Epoxy Primer

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<th>DESCRIPTION</th>
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<td><em><em>2.8 VOC</em> Catalyzed Epoxy Primer</em>* is a high solids, two component, epoxy polyamide 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.</td>
<td>Gloss: Less than 20 units (60°)</td>
<td><strong>General</strong>: Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties. Consult Metal Preparation Brochure CC-T1 for additional details.</td>
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<td>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. • 2.8 VOC complying catalyzed epoxy primer</td>
<td>Volume Solids: 61 ± 2% catalyzed &amp; reduced</td>
<td><strong>Aluminum</strong>: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</td>
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<td>Not Stocked—Special Order Only: Black .................................E61B283</td>
<td>Viscosity: Suggested application - catalyzed &amp; reduced 25-30 seconds #3 Zahn Cup</td>
<td><strong>Galvanized Steel</strong>: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</td>
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| Spreading Rate (no application loss): 445-561 sq.ft./gal. @ 1.8-2.2 mils DFT | Drying (2.0 mils dft, 77°F, 50% RH): To Touch: 1-1½ hours Tack Free: 2½-3½ hours To Topcoat: 20 minutes To Pack: 24 hours Force Dry: 30 minutes at 140°F | **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. |

| Mixing Ratio: by volume 4 parts Epoxy Primer 1 part V66V282 0.2 Part (4%) Reducer | Flash Point: 63°F Pensky-Martens Closed Cup | **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. |
| Pot Life: 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 lb/gal, 283 g/L • Volatile Organic Compounds (VOC) catalyzed and reduced, maximum 2.8 lb/gal, 335 g/L | An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.paintdocs.com. | |

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

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

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## APPLICATION

**Typical Setups**

**Reduction:** For 2.8 lb/gal VOC maximum, reduce up to 4% with MEK, MIBK, n-butyl acetate, or 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-.070

**Airless Spray:**
- Pressure: 2300-2700 psi
- Tip: 0.011-.015"

**Air Assisted Airless:**
- Air Pressure: 20-30 psi
- Fluid Pressure: 800-1200 psi
- Tip: 0.011-.015"

**Electrostatic Spray:**
- Polarity should be 0.7-1.5 megohms.
- Use less polar solvent to adjust

**HVLP:**
- Air Pressure (at cap): 10 psi
- Fluid Pressure: 8-10 psi
- Cap/Tip: 0.055-.070

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

Follow manufacturer’s safety recommendations when using any solvent.

## ADDITIONAL INFORMATION

- This product must be properly catalyzed before using.
- Surface preparation is important for performance. The better the preparation, the better the performance.
- Do not apply at temperatures under 60°F.
- 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.
- If parts have been stored for longer than one week after priming, they must be sanded before topcoating.
- On blasted surfaces, primer must be at least one mil greater than the profile to ensure best corrosion resistance.

### Performance Tests

**Substrate:** 24 gauge Bonderite® 1000 panels

**Primer:** 2.0 mils DFT, 2.8 VOC Catalyzed Epoxy Primer

**14 day cure**

**Salt Spray Test**
- ASTM B117 ................. 500 hours
- 1/16” creep maximum, no blisters

**Humidity**
- ASTM D2247, 100°F, 100% RH... 1000 hours
- 1/16” creep maximum, no blisters

**Conical Mandrel**
- ASTM D633 ..................... passes 1/4” mandrel

**Impact Resistance, Direct**
- ASTM D2794 ...................... 20 in lb

**Impact Resistance, Reverse**
- ASTM D2794 ...................... 10 in lb

**Pencil Hardness**
- ASTM D3363 ..................... 4H
- Primed panels (as above) topcoated with 1.5 mils dft Polane HS Plus, cured 14 days
- Salt Spray Test
- ASTM B117 ...................... 1500 hours
  - no blisters, no adhesion loss

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## CAUTIONS

### FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review 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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