EPOLON™ II
RUST INHIBITIVE EPOXY PRIMER

**PRODUCT INFORMATION**

**PRODUCT DESCRIPTION**
EPOLON II RUST INHIBITIVE EPOXY PRIMER is a high performance, exterior/interior, lead and chromate free, high solids, two component, rust inhibitive, catalyzed polyamide epoxy steel primer. Specifically engineered for corrosion protection and chemical and weather resistant properties. Formulated for excellent flow and uniform finish when applied by brush, roller or spray where one coat, high build application is desired.

- Corrosion resistant
- Long pot life
- One year recoatability
- Long term durability
- Chemical and abrasion resistant
- Outstanding application properties

**PRODUCT CHARACTERISTICS**

**Finish:** Low Sheen
**Color:** Off White, Gray
**Volume Solids:** 67% ± 2%, ASTM D2697, mixed
**Weight Solids:** 81% ± 2%, mixed
**VOC (EPA Method 24):** Unreduced: <300 g/L; 2.50 lb/gal
**Mix Ratio:** 1:1 by volume

**Recommended Spreading Rate per coat:**

<table>
<thead>
<tr>
<th>Wet mils (microns)</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>2.0</td>
<td>75</td>
<td>150</td>
</tr>
<tr>
<td>67</td>
<td>100</td>
<td></td>
</tr>
</tbody>
</table>

**Dry mils (microns)**

<table>
<thead>
<tr>
<th>Coverage sq ft/gal (m²/L)</th>
<th>Theoretical coverage sq ft/gal (m²/L) @ 1 mil / 25 microns dft</th>
</tr>
</thead>
<tbody>
<tr>
<td>270</td>
<td>1072</td>
</tr>
</tbody>
</table>

**Dry Heat Resistance**

ASTM D2485
250°F (121°C); Intermittent 275°F (135°C)

**Direct Impact Resistance**

ASTM D2794
32 in. lb.

**Corrosion Resistance**

ASTM D5894, 1008 hours, 3 cycles
Rating 10, per ASTM D714 for blistering; Rating 10 per ASTM D1654 for corrosion

**Exterior Durability**

Three years at 45° South, 2% salt solution, sprayed twice daily (Monday through Friday)
Rating 10 per ASTM D610, no disbonding, no pin point rusting, less than 1/16” rust creepage at scribe

**Prohesion**

ASTM G53, Annex A5, 2500 hours
Rating 10 per ASTM D610, no disbonding, no pin point rusting, less than 1/16” rust creepage at scribe

**Salt Fog Resistance**

ASTM B117, 2000 hours
Rating 10 per ASTM D610, no disbonding, no pin point rusting, less than 1/16” rust creepage at scribe

**Recommended Uses**
For use over prepared steel surfaces:
- Refineries
- Storage tanks
- Paper mills
- Power plants
- Off shore structures
- Marine applications

Not recommended for nonferrous metal

**Performance Characteristics**

**Substrate**: Steel
**Surface Preparation**: SSPC-SP10
**System Tested**:
1 ct. Epolon II Primer @ 3.5 mils (87.5 microns) dft
1 ct. Epolon II Multi-Mil @ 3.5 mils (87.5 microns) dft
1 ct. Poly-Lon HP @ 2.0 mils (50 microns) dft

<table>
<thead>
<tr>
<th>Test Name</th>
<th>Test Method</th>
<th>Results</th>
</tr>
</thead>
<tbody>
<tr>
<td>Adhesion</td>
<td>ASTM D4541</td>
<td>715 psi</td>
</tr>
<tr>
<td>Corrosion</td>
<td>ASTM D5894</td>
<td>1008 hrs, 3 cycles</td>
</tr>
<tr>
<td>Weathering</td>
<td>ASTM D2794</td>
<td>32 in. lb.</td>
</tr>
<tr>
<td>Direct Impact Resistance</td>
<td>ASTM D2485</td>
<td>250°F (121°C); Intermittent 275°F (135°C)</td>
</tr>
<tr>
<td>Exterior Durability</td>
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<td>Rating 10 per ASTM D610, no disbonding, no pin point rusting, less than 1/16” rust creepage at scribe</td>
</tr>
</tbody>
</table>

Epoxy coatings may darken or yellow following application and curing.

**Drying Schedule @ 4.0 mils wet (100 microns):**

<table>
<thead>
<tr>
<th>@ 50°F/10°C</th>
<th>@ 77°F/25°C</th>
<th>@ 120°F/49°C</th>
</tr>
</thead>
<tbody>
<tr>
<td>50% RH</td>
<td></td>
<td></td>
</tr>
<tr>
<td>To touch</td>
<td>5 hours</td>
<td>4 hours</td>
</tr>
<tr>
<td>To handle</td>
<td>16 hours</td>
<td>8 hours</td>
</tr>
<tr>
<td>To recoat:</td>
<td>minimum:</td>
<td>24 hours</td>
</tr>
<tr>
<td>maximum:</td>
<td>1 year</td>
<td>1 year</td>
</tr>
</tbody>
</table>

If maximum recoat time is exceeded, abrade surface before recoating.

**Drying time is temperature, humidity, and film thickness dependent.**

**Pot Life:**

<table>
<thead>
<tr>
<th>4 hours</th>
<th>4 hours</th>
<th>1 hour</th>
</tr>
</thead>
</table>

**Sweat-in-time:**

<table>
<thead>
<tr>
<th>30 minutes</th>
<th>15 minutes</th>
<th>10 minutes</th>
</tr>
</thead>
</table>

**Shelf Life:**

12 months, unopened
Store indoors at 40°F (4.5°C) to 100°F (38°C).

**Flash Point:**

87°F (30°C) Seta Flash, mixed

**Reducer/Clean Up:**

Reducer #145, R7K145

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continued on back
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**PRODUCT INFORMATION**

**Recommended Systems**

| Steel: | 1 ct. | Epolon II Epoxy Primer | 2.0-4.0 (50-100) |
| Steel: | 1-2 cts. | Epolon II Multi-Mil | 3.0-6.0 (75-150) |
| Steel: | 1 ct. | Epolon II Epoxy Primer | 2.0-4.0 (50-100) |
| Steel: | 1-2 cts. | Hi-Solids Polyurethane | 3.0-4.0 (75-100) |
| Steel: | 1 ct. | Epolon II Epoxy Primer | 2.0-4.0 (50-100) |
| Steel: | 1-2 cts. | Polyon HP Polyurethane | 2.0-3.0 (50-75) |
| Steel: | 1 ct. | Epolon II Epoxy Primer | 2.0-4.0 (50-100) |
| Steel: | 1-2 cts. | Water Based Catalyzed Epoxy | 2.5-4.0 (63-100) |

The systems listed above are representative of the product’s use, other systems may be appropriate.

**Surface Preparation**

Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Refer to product Application Bulletin for detailed surface preparation information.

Minimum recommended surface preparation:
- Iron & Steel: SSPC-SP6/NACE 3, 1-2 mil (25-50 micron) profile

**Surface Preparation Standards**

<table>
<thead>
<tr>
<th>Condition of Surface</th>
<th>ISO 8501-1</th>
<th>BS7979-A1</th>
<th>Swedish Std.</th>
<th>SSPC-SP6/NACE</th>
</tr>
</thead>
<tbody>
<tr>
<td>White Metal</td>
<td>Sa 3</td>
<td>Sa 3</td>
<td>Sa 3</td>
<td>SP 5 1</td>
</tr>
<tr>
<td>Near White Metal</td>
<td>Sa 2.5</td>
<td>Sa 2.5</td>
<td>Sa 2</td>
<td>SP 10 2</td>
</tr>
<tr>
<td>Commercial Blast</td>
<td>Sa 2</td>
<td>Sa 2</td>
<td>Sa 1</td>
<td>SP 9 3</td>
</tr>
<tr>
<td>Brush-Off Blast</td>
<td>Sa 1</td>
<td>Sa 1</td>
<td>Sa 1</td>
<td>SP 4</td>
</tr>
<tr>
<td>Hand Tool Cleaning</td>
<td>Rusted</td>
<td>Rusted</td>
<td>Rusted</td>
<td>Rusted</td>
</tr>
<tr>
<td>Power Tool Cleaning</td>
<td>Rusted</td>
<td>Rusted</td>
<td>Rusted</td>
<td>Rusted</td>
</tr>
</tbody>
</table>

**Tinting**

Do not tint.

**Application Conditions**

Temperature: 50°F (10°C) minimum, 120°F (49°C) maximum
- (air, surface, and material)
- At least 5°F (2.8°C) above dew point

Relative humidity: 85% maximum

Refer to product Application Bulletin for detailed application information.

**Ordering Information**

Packaging:
- Part A and B: 1 gallon (3.78L) and 5 gallon (18.9L) containers
- Weight: 12.9 ± 0.2 lb/gal ; 1.5 Kg/L, mixed

**Safety Precautions**

Refer to the MSDS sheet before use.

Published technical data and instructions are subject to change without notice. Contact your Sherwin-Williams representative for additional technical data and instructions.

**Warranty**

The Sherwin-Williams Company warrants our products to be free of manufacturing defects in accord with applicable Sherwin-Williams quality control procedures. Liability for products proven defective, if any, is limited to replacement of the defective product or the refund of the purchase price paid for the defective product as determined by Sherwin-Williams. NO OTHER WARRANTY OR GUARANTEE OF ANY KIND IS MADE BY SHERWIN-WILLIAMS, EXPRESSED OR IMPLIED, STATUTORY, BY OPERATION OF LAW OR OTHERWISE, INCLUDING MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE.

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Surface must be clean, dry, and in sound condition. Remove all oil, dust, grease, dirt, loose rust, and other foreign material to ensure adequate adhesion.

Iron & Steel, atmospheric service
Remove all oil and grease from surface by Solvent Cleaning per SSPC-SP1. Minimum surface preparation is Commercial Blast Cleaning per SSPC-SP6/NACE 3. For better performance, use Near White Metal Blast Cleaning per SSPC-SP10/NACE 2. Blast clean all surfaces using a sharp, angular abrasive for optimum surface profile (1-2 mils / 25-50 microns). Prime any bare steel the same day as it is cleaned or before flash rusting occurs.

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<th>SSPC</th>
<th>NACE</th>
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<tr>
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<td>Sa 3</td>
<td>Sa 3</td>
<td>Sa 3</td>
<td>SP 5</td>
<td>1</td>
</tr>
<tr>
<td>Near White Metal</td>
<td>Sa 2.5</td>
<td>Sa 2.6</td>
<td>Sa 2.6</td>
<td>SP 10</td>
<td>2</td>
</tr>
<tr>
<td>Commercial Blast</td>
<td>Sa 2</td>
<td>Sa 2</td>
<td>Sa 2</td>
<td>SP 6</td>
<td>3</td>
</tr>
<tr>
<td>Brush-Off Blast</td>
<td>Sa 1</td>
<td>Sa 1</td>
<td>Sa 1</td>
<td>SP 7</td>
<td>4</td>
</tr>
<tr>
<td>Hand Tool Cleaning</td>
<td>Rusted C St 2</td>
<td>C St 2</td>
<td>C St 2</td>
<td>SP 2</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>Pitted &amp; Rusted D St 3</td>
<td>D St 3</td>
<td>D St 3</td>
<td>SP 3</td>
<td>-</td>
</tr>
<tr>
<td>Power Tool Cleaning</td>
<td>Rusted C St 2</td>
<td>C St 2</td>
<td>C St 2</td>
<td>SP 2</td>
<td>-</td>
</tr>
<tr>
<td></td>
<td>Pitted &amp; Rusted D St 3</td>
<td>D St 3</td>
<td>D St 3</td>
<td>SP 3</td>
<td>-</td>
</tr>
</tbody>
</table>

Temperature: 50°F (10°C) minimum, 120°F (49°C) maximum
Relative humidity: 85% maximum

The following is a guide. Changes in pressures and tip sizes may be needed for proper spray characteristics. Always purge spray equipment before use with listed reducer. Any reduction must be compliant with existing VOC regulations and compatible with the existing environmental and application conditions.

Reducer/Clean Up .......... Reducer #145, R7K145

Airless Spray
Pressure: 2700 - 3000 psi
Hose: 1/4" - 3/8" ID
Tip: .015" - .019"
Filter: 60 mesh
Reduction: As needed up to 6% by volume

Conventional Spray
Gun: Graco 800N
Fluid Tip: .070" Tip
Air Supply: 20 CFM
Atomization Pressure: 50 - 60 psi
Fluid Pressure: 10 - 20 psi
Reduction: As needed up to 6% by volume

Brush
Brush: Nylon/Polyester or Natural Bristle
Reduction: Not recommended

Roller
Cover: 38" - 1/2" woven with solvent resistant core
Reduction: Not recommended

If specific application equipment is not listed above, equivalent equipment may be substituted.
**APPLICATION PROCEDURES**

Surface preparation must be completed as indicated.

Mix contents of each component thoroughly with low speed power agitation. Make certain no pigment remains on the bottom of the can. Then combine one part by volume of Part A with one part by volume of Part B. Thoroughly agitate the mixture with power agitation. Allow the material to sweat-in as indicated. Re-stir before using.

If reducer solvent is used, add only after both components have been thoroughly mixed, after sweat-in.

Apply paint at the recommended film thickness and spreading rate as indicated below:

<table>
<thead>
<tr>
<th>Recommended Spreading Rate per coat:</th>
<th>Minimum</th>
<th>Maximum</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wet mils (microns)</td>
<td>3.0</td>
<td>6.0</td>
</tr>
<tr>
<td>Dry mils (microns)</td>
<td>2.0</td>
<td>4.0</td>
</tr>
<tr>
<td>Coverage sq ft/gal (m²/L)</td>
<td>270</td>
<td>150</td>
</tr>
<tr>
<td>Theoretical coverage sq ft/gal (m²/L)</td>
<td>1072</td>
<td>26.2</td>
</tr>
</tbody>
</table>

**NOTE:** Brush or roll application may require multiple coats to achieve maximum film thickness and uniformity of appearance.

**Drying Schedule @ 4.0 mils wet (100 microns):**

- @ 50°F/10°C
  - To touch: 5 hours
  - To handle: 16 hours
  - To recoat: minimum 24 hours, maximum 1 year

- @ 77°F/25°C
  - To touch: 4 hours
  - To handle: 8 hours
  - To recoat: minimum 18 hours, maximum 1 year

- @ 120°F/49°C
  - To touch: 30 minutes
  - To handle: 15 minutes

Application of coating above maximum or below minimum recommended spreading rate may adversely affect coating performance.

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