



**SHERWIN
WILLIAMS.**

Product Finishes

Catalyzed Epoxy Primer

Red Oxide E61RC22
Catalyst V66TC1

<u>DESCRIPTION</u>	<u>CHARACTERISTICS</u>	<u>SPECIFICATIONS</u>
<p>Catalyzed Epoxy Primer is a two component epoxy primer system offering excellent adhesion and corrosion resistance. Its fast dry makes it ideal for production line application. It is especially suited for use under Polane® Polyurethane topcoats where superior corrosion resistance is needed.</p> <p>Advantages:</p> <ul style="list-style-type: none"> • Very fast drying • Excellent corrosion resistance • No "sweat-in" time required, can be applied immediately after mixing • Long working pot life • Free of lead hazards • Recommended primer under Polane® Polyurethanes for best corrosion resistance on metal • Ideal primer for structural steel, farm and construction equipment, railroad equipment, machinery, transformers, and castings when topcoated with Polane Polyurethanes • Excellent chemical resistance • Ideal for application to untreated steel 	<p>Gloss: <30 units Volume Solids: 30.7 ± 1%, catalyzed & reduced Viscosity: 30-45 seconds #2 Zahn Cup catalyzed & reduced Recommended film thickness: Mils Wet 4.0 - 6.0 Mils Dry 1.2 - 1.8 Spreading Rate (no application loss) 265-424 sq ft/gal @ 1.2-1.8 mils DFT Drying (1.5 mils dft, 77°F, 50% RH): To Touch: 20-30 minutes Tack Free: 1-2 hours To Recoat: 1-2 hours Force Dry: 20 minutes at 140°F Flash Point: 40°F Pensky-Martens Closed Cup Mixing Ratio: 4 parts E61RC22 1 part V66TC1 2 parts R7K54 Pot Life: 8 hours Package Life: 1 year, unopened Air Quality Data (Theoretical): Photochemically reactive Volatile Organic Compounds (VOC) Catalyzed and reduced for application: 4.82 lb/gal, 577 g/L</p> <p>An Environmental Data Sheet is available from your local Sherwin-Williams facility.</p>	<p>General: 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.</p> <p>Aluminum: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</p> <p>Galvanized Steel: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.</p> <p>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.</p> <p>Blasted surfaces: Dry film thickness must be 1 mil greater than the depth of the profile for best corrosion resistance.</p> <p>Testing: Due to the wide variety of substrates, surface preparation methods, and application methods and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.</p>

APPLICATION

Typical Setups

Conventional Spray:

Reducer..... R7K54
Reduction Rate..... 30-40%
30-45 seconds on a Zahn #2

Airless Spray:

Pressure..... 1800 - 2200 psi
Tip013"
Reducer..... R7K54
Reduction Rate..... up to 10%

Cleanup:

Clean tools/equipment immediately after use with Reducer #54, R7K54.

Follow manufacturer's safety recommendations when using any solvent.

Performance Tests

Substrate: Bonderite 1000 panels

Pencil Hardness B min.
ASTMD3363

Salt Spray..... Passes 400 hrs.
ASTM B117

Humidity Passes 1000 hrs.
ASTMD2247

SPECIFICATIONS

Product Limitations:

- Topcoat only with Polane Polyurethanes and catalyzed epoxies.
- If primed parts are stored outside for long periods before topcoating, the chalk must be removed before painting.
- On sand blasted surfaces, apply sufficient film thickness to protect the blast profile. This is typically 1 mil more than the blast profile. Multiple coats may be required.
- Contains Chromates.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION

Thoroughly review product label and Material Safety Data Sheet (MSDS) for safety and cautions prior to using this product.

A Material Safety Data Sheet is available from your local Sherwin-Williams facility.

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

Note: Product Data Sheets are periodically updated to reflect new information relating to the product. It is important that the customer obtain the most recent Product Data Sheet for the product being used. The information, rating, and opinions stated here pertain to the material currently offered and represent the results of tests believed to be reliable. However, due to variations in customer handling and methods of application which are not known or under our control, The Sherwin-Williams Company cannot make any warranties as to the end result.