



TECHNICAL INFORMATION

2.8 VOC CATALYZED EPOXY PRIMER GRAY E61AV2801

CHEMICAL COATINGS

PRODUCT DESCRIPTION

E61AV2801 when blended with V93VY9 will result in a high solids epoxy-polyamide primer. This coating can be used for texturing as well as a smooth coating. The fast dry time of this product allows for early topcoating.

Advantages:

When properly mixed, a coating with the following attributes is obtained.

1. VOC less than 2.8 lbs/gal.
2. Fast dry time
3. Lead and chromate free
4. Texturable
5. High build capability
6. Excellent resistance properties

CHARACTERISTICS

(Theoretical)

Part A:	E61AV2801
Part B:	V93VY9

Density (lbs/gal):	
E61AV2801	15.0
V93VY9	7.8

Percent NVM (wt):	
E61AV2801	90.0
V93VY9	61.3

VOC (lbs/gal):	
E61AV2801	2.0
V93VY9	2.7

Surface Preparation: Coating performance is based on the degree of surface preparation. The better the preparation the better the resulting performance.

The following guidelines should be used:

1. Degrease surface prior to cleaning. Organic solvents, alkaline solutions, steam, hot water with detergents or other systems that will completely remove surface contamination may be used.
2. Remove all loose mill scale, rusting and old coatings before new coating is applied. Typically, brush-off blast cleaning and power tool cleaning will accomplish this.
3. Coat with primer as soon as possible after surface preparation. If the time exceeds 24 hours between cleaning and coating, the surface must be inspected for rusting or re-cleaned.
4. For further information consult Metal Preparation Brochure CC-T1.

CHARACTERISTICS (Continued)

Pretreatment: Substrates should be free of dirt, oils and other contaminants. Best performance occurs when the coating is applied over zinc phosphate pretreated steel, slightly less corrosion resistance will occur over iron phosphitized steel.

APPLICATION

Mixing Ratio (by volume):

E61AV2801	4 Parts
V93VY9	1 Part

Reduction: As Necessary

Recommended reducers:
MEK, MIBK, n-Butyl Acetate, i-Propyl Acetate, R7K84

VOC: (EPA Method 24)

Unreduced:	2.4 lbs/gal
Reduced 15%	2.8 lbs/gal

Potlife:

Unreduced	2 Hours
Reduced 15%	4 Hours

Coverage: 950 Sq Ft/Mil
Reduced 15%

Wet Film: 8.3 – 13.3 mils

Dry Film: 5 – 8 mils

Gloss 60°: 5 – 20

Air and surface temperature range: 50 - 100°F. Surface temperature must be at least 5°F. above the dew point. Do not apply in fog, rain or condensing humidity.

The dry film thickness must exceed the blast profile by at least 1 mil.

Clean-Up: Please follow the instructions carefully for clean-up of lines, guns, pumps, mixers, etc.

1. Clean up immediately after application.
2. Use an epoxy reducing solvent. MIBK or MEK for clean-up.

Drying and Curing: Film must be set up before topcoat is applied. Use the following schedule as a guide for testing. Also, allow at least a 5 minute flash-off time.

APPLICATION (Continued)

Dry time @ 2.0 mils DFT, 50% RH, 70°F (ASTM D1640)

Touch	.75 – 1.5 Hours
Tack Free	1 – 2 Hours
Hard	8 - 10 Hours
Topcoat (minumin)	.5 – 2 Hours

Dry time @ 2.0 mils DFT, 140°F

Touch	<30 Minutes
Tack Free	<30 Minutes
Hard	<30 Minutes
Topcoat	<30 Minutes

Time will vary due to various parameters such as, mass of substrate, type of oven, etc. Coating must be tack free to topcoat for maximum holdout. Test substrate was standard Q-Steel panels, 0.032" x 6" x 12" (0.8 x 152 x 305 mm).

CAUTIONS

WARNING! Contents are **FLAMMABLE**. Keep away from heat, sparks and open flame. During use and until all vapors are gone; keep area ventilated. Do not smoke. Extinguish all flames, pilot lights and heaters. Turn off stoves, electric tools and appliances, and any other sources of ignition.

USE ONLY WITH ADEQUATE VENTILATION. Avoid breathing vapor and spray mist. Avoid contact with skin and eyes. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.

DO NOT TAKE INTERNALLY

KEEP OUT OF THE REACH OF CHILDREN

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 above 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 or guaranties as to the end results.

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