



Product Finishes

2.8VOC Catalyzed Epoxy Primer

White..... E61WL6

Catalyst..... V66V282

DESCRIPTION

2.8 VOC Catalyzed Epoxy Primer White, E61WL4 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.

Advantages:

- 2.8 VOC complying* catalyzed epoxy primer
- Excellent corrosion resistance - over 500 hours salt spray
- Free of lead and chromate hazards
- Fast dry time
- No induction or "sweat-in" time required
- May use plural component equipment
- Excellent holdout of topcoat
- Application versatility - apply at 2.8 VOC using various spray equipment setups
- Excellent chemical resistance
- Pass 1500 hours salt spray when topcoated with Polane® HS Plus Polyurethane.
- Excellent primer for farm and construction equipment, machinery, transformers, structural steel and castings when topcoated with Polane Polyurethane

CHARACTERISTICS

60° Gloss: ≤20 units

Volume Solids(%): 61.2 ± 1
catalyzed & reduced

Viscosity: 25-30 seconds#3 Zahn Cup
catalyzed & reduced

Recommended film thickness:

Mils Wet 3.0 - 3.6
Mils Dry 1.8 - 2.2

Spreading Rate (no application loss)
545- 446 ft²/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

Flash Point: 76°F Seta Flash Closed Cup

Mixing Ratio (by volume):

4 parts E61WL6
1 part V66V282
0.2 part (5%) Reducer

Pot Life: 4 hours

Package Life: 1 year, unopened

Air Quality Data:

Photochemically reactive
Volatile Organic Compounds (VOC)
catalyzed & reduced, maximum
2.8 lb/gal, 331 g/L

An Environmental Data Sheet is available from your local Sherwin-Williams facility.

SPECIFICATIONS

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.

Aluminum: If untreated, prime with Industrial Wash Primer P60G2 or Kem Aqua® Wash Primer E61G520 first, then follow with 2.8 VOC Catalyzed Epoxy Primer.

Galvanized Steel: If untreated, prime with Industrial Wash Primer P60G2 or Kem Aqua® Wash Primer E61G520 first, then follow with 2.8 VOC Catalyzed Epoxy Primer.

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: Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion, compatibility, and performance prior to full scale application.

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

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:

Gun Binks Model 7
Air Pressure 30 psi
Fluid Pressure 10 psi
Cap/Tip 63PB/68SS

Airless Spray:

Pressure 2300-2700 psi
Tip011"

Air Assisted Airless:

Air Pressure30-40 psi
Fluid Pressure 800-900 psi
Cap/Tip 222-608/ .011"

Electrostatic Spray:

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

HVLP (Binks Mach I):

Air Pressure 60 psi
Fluid Pressure10-15 psi
Cap/Tip 97/94

Cleanup:

Clean tools/equipment immediately after use with reducing solvent. Follow manufacturer's safety recommendations when using any solvent.

SPECIFICATIONS

Product Limitations

- 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, do not reduce more than 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

CAUTIONS

Thoroughly review product label 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.

LABEL CAUTIONS

SEE CONTENTS STATEMENT ON LABEL.

Contents are FLAMMABLE. Vapors may cause flash fires. 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. VAPOR HARMFUL. Use only with adequate ventilation.

Wear an appropriate properly fitted vapor/particulate respirator (NIOSH approved) during and after application, unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Adequate ventilation required when sanding or abrading the dried film. If adequate ventilation cannot be provided wear an approved particulate respirator (NIOSH approved). Follow respirator manufacturer's directions for respirator use.

Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.

FIRST AID: If INHALED: If affected, remove from exposure. Restore breathing. Keep warm and quiet.

If on SKIN: Wash affected area thoroughly with soap and water. Remove contaminated clothing.

Launder before re-use. If in EYES: Flush eyes with large amounts of water for 15 minutes. Get medical attention. If SWALLOWED: Call Poison Control Center, hospital emergency room, or physician immediately.

SPILL AND WASTE: Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and Local regulation regarding pollution.

DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE.

Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

Abrading or sanding of the dry film may release crystalline silica which has been shown to cause lung damage and cancer under long term exposure.

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This product must be mixed with other components before use. Before opening the packages, READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS.

WARNING: This product contains chemicals known to the State of California to cause cancer and birth defects or other reproductive harm.

DO NOT TAKE INTERNALLY. KEEP OUT OF THE REACH OF CHILDREN.
FOR INDUSTRIAL USE ONLY.

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.

Columbus Regional Lab
D. Gellert
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