



General Industrial Coatings

CC-A45

Polane® HP Plus Primer

Mid-Gloss Black..... E61BC32 Catalyst.....V66V55
 Gray E61AC151 Catalyst..... V66VC232

DESCRIPTION

Polane® HP Plus Primer is a high performance, two-component urethane primer for metal substrates. It provides a common catalyst with Polane HP Gen II and Polane SP urethane topcoats. E61AC151 allows for wet on wet application.

This has been developed for use on components and parts in the transportation and automotive/truck & trailer markets

Advantages:

- Excellent hardness
- Excellent corrosion resistance over a variety of pretreatments
- E61BC32 is PACCAR approved to CMT0221, CMT0031 Types 1 and 2, and CMT0048 Type 2 – on iron phosphate aluminum and Chromate aluminum.
- Common catalyst with Polane HP Gen II & Polane SP urethane topcoats
- Offers two catalyst options
- *Complies with 3.5 lbs./gal. VOC
- Formulated to be non-HAP

CHARACTERISTICS

(vary by color)

60° Gloss

E61BC32: 30-40
 E61AC151 Flat

Weight Solids

Part A 69-75 %
 Admixed 69-72 %

Volume Solids:

Part A 47-55 %
 Admixed 50-53 %

Viscosity (Zahn, admixed, at 77° F):

Part A 10-30, #3 Zahn Cup
 Admixed 10-20 secs., #3 Zahn Cup

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

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.PaintDocs.Com.

Recommended Film Thickness:

Mils Wet 3.0-4.0
 Mils Dry 1.5-2.0

Spreading Rate (no application loss):

403-553 ft.²/gal. at 1.5-2.0 mils DFT

Cure:

Air Dry or
 Force Dry
 E61BC32 (2.0 mils) 10 mins. Flash
 30 mins. at 160-165° F
 E61AC151 (1.5 mils) 10 mins. Flash
 30-60 mins. at 140-180° F
 E61AC151: If faster drying is required, add 1-2 ounce(s) of Genesis GA1097 per gallon.
Accelerating the primer will reduce the time to sand, adhesion must be verified.

Air Drying: 1.80 mils at 77° F, 50% RH

To Touch 2 hours
 To Topcoat 5-10 minutes

Mixing Ratio (by volume):

E61BC32 & V66VC232 Catalyst	
E61BC32	5 parts
V66VC232 Catalyst	1 part
E61AC151 & V66V55 Catalyst	
E61AC151	6 parts
V66V55 Catalyst	1 Part
R6K30 (MAK) Reducer	1 part
E61AC151 & V66VC232 Catalyst	
E61AC151	4.5 parts
V66VC232 Catalyst	1.0 Part
R6K30 (MAK) Reducer	0.5 part

Potlife: 2 hours

Flash Point (Pensky-Martens Closed Cup):

Part A 81° F
 V66V55 & V66VC232 117° F

Air Quality Data:

Volatile Organic Compounds (VOC), Less Exempts
 (as packaged, maximum) 3.3 lb/gal, 400 g/L
 (admixed, maximum) 3.3 lb/gal, 395 g/L

Recommended Storage: Inside, sealed container, 40-120° F, no freeze hazard. Protect from moisture.

Package Life: 1 year, unopened

SPECIFICATIONS

General: All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

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: 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.

APPLICATION

Typical Setups

Reduction: E61BC32 is typically applied without reduction. If reduction is needed to optimize application, R6K30 (MAK) can be used. E61AC151 is typically reduced with R6K30 (MAK) prior to application.

May be applied by: Conventional Spray
Air Assisted Airless Spray
HVLP Spray

Conventional Spray:

Air Pressure	55 psi
Fluid Pressure	6 psi
Cap/Tip	0.070 in. / 765
Reducer	R6K30 (MAK)

Air Assisted Airless Spray:

Air Assist Pressure	20 psi
Fluid Pressure	1,500-1,800 psi
Tip	0.411 in.

HVLP Spray:

Fluid Pressure	10 psi
Tip	0.055 in.
Reducer	R6K30 (MAK)

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

Cleanup: Clean tools/equipment immediately after use with R6K30 (MAK) or MEK.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. **This product must be properly activated before using. DO NOT VARY ACTIVATOR RATIO.** The ratio has been established for optimum hardness, flexibility, gloss, and chemical & solvent resistance.
2. **Accelerating E61AC151 with GA1097 will reduce the time to sand; adhesion must be verified.**
3. Do not apply at temperatures under 60° F
4. Surface preparation and pretreatment is critical to performance. Product is designed for Phosphate pretreated steel.
5. If parts have been stored for longer than one week after priming, they must be scuffed or sanded before top coating to ensure removal of any accumulated dust/dirt.
6. Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application. Consult your local Sherwin-Williams representative for system recommendations and substrate testing.
7. Drying time is dependent on film thickness and atmospheric conditions. Heavier film thickness causes slow drying.

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CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review the 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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