



# General Industrial Coatings

CC-A70

## Duraspar™ Prime High Speed 2K Epoxy

Gray

E61AC161

Catalyst ..... V66VC256

### DESCRIPTION

**Duraspar™ Prime High Speed, E61AC161**, is an AD/FD, VOC compliant, two component coating suitable for use as a primer on metal substrates.

#### Advantages:

- Excellent cure speed
- Fast dry time compared to traditional epoxy primers.
- Superior corrosion resistance
- Excellent adhesion to various metals
- No Induction time
- Wet-on-wet and wet-on-dry application with 2K solventborne urethane topcoats
- Complies with 2.8 VOC solvent emissions
- Free of chromate hazards

### CHARACTERISTICS

**Component A:** E61AC161  
**Component B:** V66VC256

**Weight/Gallon (lbs.):**  
E61AC161 12.6 ± 0.2  
V66VC256 7.6 ± 0.2  
Admixed 12.3 ± 0.2

**Weight Solids:**  
E61AC161 72.9 ± 2 %  
V66VC256 65.1 ± 2 %  
Admixed 71.3 ± 2 %

**Volume Solids:**  
E61AC161 49.0 ± 2 %  
V66VC256 60.6 ± 2 %  
Admixed 50.5 ± 2 %

**Mixing Ratio** (by volume):  
E61AC161 10 Parts  
V66VC256 1 Parts

**Potlife** (at 77° F): 4 hours

**Viscosity** (at 77° F):  
E61AC161 20-25 secs., #2 Zahn Cup\*\*  
Admixed 20-25 secs., #2 Zahn Cup\*\*  
\*\*Signature Series

**VOC** (less exempt solvents):  
E61AC161 3.0 lbs./gal. 359 g/l  
V66VC256 2.6 lbs./gal. 317 g/l  
Admixed 2.8 lbs./gal. 337 g/l

**HAPS:**  
E61AC161 0.21 lbs./gal. solids  
V66VC256 0.00 lbs./gal. solids  
Admixed 0.18 lbs./gal. solids

**Flash Point** (Pensky Martens Closed Cup):  
E61AC161 76° F  
V66VC256 53° F  
Admixed 76° F

**Vol. Solids at Gun:** 50.5 % at 2.8 VOC

**Recommended Film Thickness:**  
Mils Wet 3.0-4.0  
Mils Dry 1.5-2.0  
Mils Dry, Maximum 3.0

**Coverage:** 540 ft.<sup>2</sup>/gal. at 1.5 mils DFT  
(theoretical)

#### Cure:

**Wet-on-Wet:** Allow primer to flash 10-20 mins. prior to topcoat application.

**Air Dry:** Allow the coated part to cure ≥16 hours at 70° F indoors before placing the part outdoors.

**Force Dry:** 10 mins. flash, 30 mins. at 150° F

**Drying:** (1.5-2.0 mils @ 77° F / 50% RH)  
To Touch 30 minutes  
Tack Free 60 minutes  
To Handle 3 hours  
Total (Full Properties) 7 days

#### Performance Tests

Substrate: 24 gauge Bonderite® 1000 P99X cold rolled steel panels

Primer: 1.8 mils DFT, E61AC161  
Cure: 14 days

**Salt Spray Test** (primer only)  
(ASTM B117) 500 hours  
1/16" creep maximum  
no blisters

**Sanding/Scuffing:** If parts have been stored for longer than 72 hours after priming, they must be scuffed or sanded before top coating to ensure removal of any accumulated dust/dirt.

**Recommended Storage:** Inside, sealed container, 60-95° F (15-35° C), 0-90% relative humidity, protected from rain & snow.

**Package Life:** 12 months  
from date of manufacture

\* 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](http://www.PaintDocs.Com).

## APPLICATION

### Typical Setups

To achieve full performance, the product must be mixed until completely homogeneous with a static or mechanical mixer. If using proportionating equipment product, performance needs to be verified. For specific equipment questions, please contact your local Sales Representative or your local Sherwin-Williams facility.

**Reduction:** No additional solvents or additives should be added to the paint.

This product is normally applied without reduction. If reduction is needed to optimize application, R6K18 (Butyl Acetate), R6K38 (T-Butyl Acetate), or similar solvent can be used.

**Substrate Preparation:** 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.

### **Steel (CRS & HRS), Iron & Castings:**

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.

**NOTE:** Substrate, paint and air temperature must be in range of 70-120° F. The substrate must be at least 5° F above the dew point. **If applying at <70° F, the intercoat adhesion needs to be verified.**

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

### **Conventional Spray:**

Atomizing Air Pressure	30-50 psi
Fluid Delivery Rate	8-12 oz./min.
Tip	0.1-1.5 mm

### **Airless Spray:**

Fluid Pressure	1,800-2,700 psi
Tip	0.011-0.015 in

### **Air Assisted Airless Spray:**

Atomizing Air Pressure	30-50 psi
Fluid Pressure	800-1,200 psi
Tip	0.011-0.015 in

### **Electrostatic Spray:**

Resistivity	0.6 megaohms
Atomizing Air Pressure	30-50 psi
Fluid Delivery Rate	8-12 oz./min.
Tip	0.1-1.5 mm

### **HVLP Spray:**

Atomizing Air Pressure	Max 10 psi at cap
Fluid Delivery Rate	8-12 oz./min.
Tip	0.8-1.2 mm

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

**Cleanup:** Clean tools/equipment immediately after use with ketones or acetates.

Follow manufacturer's safety recommendations when using any solvent.

### **Product Limitations:**

- DO NOT VARY CATALYST RATIO.**  
The catalyst ratio has been established for optimum hardness, flexibility, gloss, and chemical & solvent resistance.
- On sandblasted surfaces, apply sufficient film thickness to fully protect the blast profile. This is typically 1 mil more than the blast profile.
- Equipment/application guidelines are only guidelines and individual application/process parameters will dictate exact requirements.
- 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.

## CAUTIONS

Thoroughly review the product label for safety and cautions prior to using this product. A Safety Data Sheet (SDS) and an Environmental Data Sheet (EDS) are available from your local Sherwin-Williams Facility or [www.PaintDocs.Com](http://www.PaintDocs.Com). Please direct any questions or comments to your local Sales Representative or your local Sherwin-Williams facility.

**DO NOT TAKE INTERNALLY**

**KEEP OUT OF THE REACH OF CHILDREN**

**FOR INDUSTRIAL SHOP APPLICATION ONLY**

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**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](http://www.PaintDocs.Com).

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.

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