

U-TECH E350 EPOXY PRIMER

DESCRIPTION: U-Tech E350 Epoxy Primer is a low VOC, high solids, HAPs-free, epoxy primer-sealer that can be used in three different ways:

- As a non-sanding primer-sealer that can be topcoated with All U-Tech single stage systems and basecoats providing good build, and excellent adhesion and corrosion resistance.
- As a primer-surfacer that will be sanded for extra smoothness and maximum appearance.
- As a sealer coat applied over aged E350 Epoxy Primer. Surface prep requires only cleaning prior to application of E350 Epoxy Primer as a sealer. No abrasion of the aged primer is required.

PRODUCT & ADDITIVES:

PRODUCT: — E350 Epoxy Primer Gray, Black and Off-White



HARDENERS: — E350 Epoxy Primer Hardener


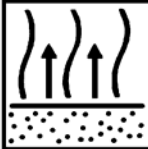


ADDITIVES: — N/A

BASIC RAW MATERIALS:

- E350 Epoxy Primer: epoxy resins
- E350 Epoxy Primer Hardener: modified polyamine resins

APPLICATION:

- | | | | | | |
|----|---|--|----|---|--|
| 1. |  | Contains epoxy resins. When mixed with hardener, also contains polyamides. | 4. |  | Siphon, Gravity or Pressure-feed.

HVLP, Airless, Air-assisted
airless and electrostatic. |
| 2. |  | Mix 2:1 parts by volume
-E350 Epoxy Primer
-E350 Epoxy Primer Hardener | 5. |  | 10 minutes at 70°F (20°C) |
| 3. |  | Use the U-Tech Measuring Stick. | 6. |  | Recoat after 30 minutes at 70°F (20°C).

Dry to sand after 6 hours at 70°F (20°C). |

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SUITABLE SURFACES:

- E350 Epoxy Primer can be applied over the following surfaces:
- Existing finishes, with the exception of thermoplastic acrylic lacquers, degreased and sanded with #P240 to #P320 grit paper dry or #P400 to #P500 grit wet.
 - Steel, degreased and sanded. Remove any mill scale by sandblasting if necessary.
 - Galvanized steel, degreased, and prepped with Scotch-Brite red pad.
 - Aluminum, degreased, and sanded with #P150 to #P180 grit dry or Scotch-Brite red pad, followed by an Akzo Nobel approved metal pretreatment.
 - Fiberglass, (unbroken gelcoat) degreased and sanded with #P180 to #P220 grit dry.
 - Any premium polyester bodyfiller final sanded with #P220 grit dry.
 - Aged E350 Epoxy Primer. Surfaces free of contaminants do not require abrasion prior to seal coat of E350 Epoxy Primer.

NOTE: Chemical cleaners and pretreatments should be pre-approved by Akzo Nobel.

MIXING RATIO: Mix 2 parts by volume of E350 Epoxy Primer with
1 part by volume of E350 Epoxy Primer Hardener
For easy and accurate mixing, use the U-Tech Measuring Stick

SPRAYING VISCOSITY:

25 – 28 sec. ZAHN cup #2 (11 - 13 sec. ZAHN cup #3) @ 70°F (20°C)

POT LIFE: 4 hours at 70°F (20°C)

SPRAY GUN and PRESSURE:

	Fluid Tip	Spraying Pressure	Fluid rate
Siphon feed	1.4–1.7 mm	50–60 psi	
Gravity feed	1.3–1.5 mm	50–60 psi	
HVLP Siphon	1.8–2.2 mm	max. 10 psi (air cap)	
HVLP Gravity	1.3–1.5 mm	max. 10 psi (air cap)	
Pressure feed	1.0–1.2 mm	50–60 psi	12–18 oz per min.
HVLP Pressure feed	0.8–1.0 mm	max. 10 psi (air cap)	10–14 oz per min.
Airless spray	0.011"–0.015"	1500–3000 psi	
Air assisted airless	0.011"–0.015"	700–900 psi	
Electrostatic	1.5–1.7 mm	60–70 psi	

APPLICATION METHOD:

As a wet-on-wet primer-sealer, apply one-two medium flowing coat(s). On breakthrough areas of existing finish to bare metal apply an initial thin coat over these areas, allow a flash time of 5-10 minutes, continue with one medium flowing coat.

As a primer-surfacer that will be sanded, apply two single flowing coats allowing a flash-off time between coats.

As a transport primer on steel, apply two single coats allowing a flash-off time between coats. At 2 mils dry film thickness over steel, E350 Epoxy Primer can remain without topcoat for two years.

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FLASH TIME: 10 minutes at 70°F (20°C)

FILM THICKNESS: Approximately 1.2 – 1.4 mils per single flowing coat. A higher thickness is possible in a single coat, but orange peel will increase.

CLEANING OF EQUIPMENT: Clean equipment with Extra Strong Cleaning Solvent.

DRYING TIMES:

	50°F (10°C)	70°F(20°C)	100°F (38°C)	140°F (60°C)
Recoatable wet-on-wet @ 1-1.4 mil DFT	1 hour	30 minutes	15 minutes	10 minutes
Dry to sand	24 hours	6 hours	2 hours	1 hour

RECOATABILITY: Recoatable after 30 minutes at 70°F (20°C) for 1-1.4 mils dry film thickness. For higher film thickness a recoat time of 45-60 minutes is suggested to optimize topcoat appearance. The maximum recoat time without sanding if primed component remains indoors is 7 days at 70°F (20°C). After this time, sanding is required before topcoating. Exposure to sunlight will reduce maximum time to topcoat without sanding to 24 hours.

SANDING: After the stated "Dry to Sand" time, E350 Epoxy Primer should be sanded with #P400 to #P500 grit paper dry or #P600 to #P800 grit wet before topcoating.

VOLUME SOLIDS: 50.7% in ready-to-spray mixture

STOCK KEEPING:

COLOR: Gray, Black and White

SHELFLIFE: E350 Epoxy Primer: 1 year if stored unopened at room temperature
E350 Epoxy Primer Hardener: 6 months if stored unopened at room temperature

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SAFETY ASPECTS:

FLASH POINT:

Measure using the closed cup method:

- E350 Epoxy Primer 46°F (8°C)
- E350 Epoxy Primer Hardener 53°F (12°C)

READY TO SPRAY VOC:

When mixed 2:1 by volume: 3.5 lb/gal or 420 g/l

NOTICE:

Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of protective equipment when mixing and spraying this material. Protect skin with gloves and spray suit, wear safety glasses or goggles when mixing, and wear a full hood, fresh air-fed respirator while spraying.

DISCLAIMER:

The technical information and suggestions for use made herein are based on Akzo Nobel Coatings Inc. research and experience and are believed to be reliable but such information and suggestions do not constitute a warranty.

Since Akzo Nobel Coatings Inc. has no control over the conditions under which the product is transported, stored, handled, used or applied, buyers must determine for themselves, by preliminary tests or otherwise, the suitability of the products for their purpose.