Commercial Performance Coatings

CPCPB436

Wet-on-Wet Epoxy Primer - Gray

EWP-435

EWP-435 is a two-component, 3.5 VOC compliant, high solids chrome-free corrosion inhibitive primer. It is specially designed for applications where a short wet-on-wet application window is desired (can be top-coated with catalyzed urethane after 10 minute flash). This product has excellent primer characteristics including excellent corrosion protection.

Features and Benefits:

- Wet-on-wet capable epoxy primer (topcoat in 10 minutes)
- 3.5 lb/gal VOC compliant
- Short-filled to allow for easy kit use

Associated Products:

- EWP-435 Wet-on-Wet Epoxy Primer - Gray
- EPE-371 Catalyst

Physical Constants:

All values are theoretical, depend on color and are Ready-to-Spray. Actual values could vary slightly due to manufacturing variability.

	EWP-435	EWP-435 w/ EPE-371
Percent solids (by weight)	76.2%	73.1%
Percent solids (by volume)	55.8%	53.9%
HAPs	≤ 0.14 lbs/gal	≤ 0.14 lbs/gal
Photo-chemically reactive	No	No
Volume Ratio	As Is	4 : 1
Applicable Use Category	Primer Sealer	Primer Sealer
VOC Actual	382 (g/L) 3.19 (lbs/gal)	395 (g/L) 3.30 (lbs/gal)
VOC Regulatory (less water less exempt)	381(g/L) 3.18 (lbs/gal)	395 (g/L) 3.30 (lbs/gal)
Density	1607(g/L) 13.4 (lbs/gal)	1471 (g/L) 12.26 (lbs/gal)
Volatiles wt. %	23.8	26.9
Water wt. %	0.0	0.0
Exempt wt. %	0.0	0.0
Water vol. %	0.0	0.0
Exempt vol. %	0.0	0.0
Flashpoint (Pensky-Martens)		
EWP-435	92ºF (33ºC) PMCC	
EPE-371	80ºF (27ºC) PMCC	

PPG

EWP-435

Directions for Use

Substrate Preparation:

The surface to be coated must be sanded and free of all contamination (including dust, dirt, oil, grease and oxidation). A chemical treatment (or conversion coating) will improve adhesion and performance properties of the finished coat. Variability can occur with substrates, preparation, application method or environment. We recommend that adhesion and system compatibility be checked prior to full application.

Metal	Direct to Substrate
Cold Rolled Steel	Excellent
Hot Rolled Steel	Excellent
Galvaneal	Not Recommended
Galvanized	Excellent
Aluminum	Excellent
Plastic / Fiberglass	Excellent*

Note: For acceptable compatibility between this primer and CPC topcoats please see the CPC Primer/Topcoat compatibility chart (CPCTB01).

** It is recommended that the customer should trial the product for adhesion and compatibility using all substrates.*

Mix Directions:

Mix Directions:	Mix thoroughly prior to and occasionally during spraying
Thinning:	In non-regulated areas, up to 5% of Q70 (MAK) or Q80 (Xylene) may be added. The addition of 5% solvent will bring sprayable VOC to 3.70 lbs/gal.
Blend Ratio:	**EWP-435 : EPE-371**
	4 : 1
Pot Life @ 77°F (25°C):	8 hours
Spray Viscosity Range:	#3 Zahn: 12 – 20 seconds
Unopened Shelf Life:	EWP-435 9 months EPE-371 24 months

Application Equipment:

Conventional (with or without pressure pot):	1.4 – 1.8 mm needle/nozzle, 45 – 55 psi at the gun
HVLP (with or without pressure pot):	1.4 – 1.8 mm needle/nozzle, 10 psi at cap or per manufacturer
Airless:	.011 – .015 mm: 1800 – 2400 psi fluid pressure
Air-Assisted Airless:	.011 – .015 mm: 900 – 1300 psi fluid pressure: 20 – 40 psi atomizing air
Brush or Roll:	Not recommended
Electrostatic:	No recommendation

Application:

Apply:	1 – 2 medium coats
Recommended Wet Film Build:	2.4 – 3.0 mils
Recommended Dry Film Build:	1.25 – 1.5 mils
Square Foot Coverage @ 1mil no loss:	864 ft^2

Dry Times:

Air Dry @ 77°F 50% RH:

To Touch*:	30 – 40 minutes
To Handle*:	$1^1/_2$ – 2 hours
To Recoat/Topcoat**:	10 minutes to 14 days with a CPC polyurethane topcoat. Must be abraded after 14 days.
Force Dry @ 160°F:	Flash 10-15 minutes @ ambient; then 15 - 20 minutes at 160 - 180°F

* Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.

** After 14 days, the coating must be mechanically abraded and cleaned prior to topcoating.

EWP-435

Technical Data*

Performance Properties:

Test	ASTM Method	Results
Pencil Hardness	D3363	F – 3H (6H after 14 days cure)
Adhesion - Steel	D3359	5B
Adhesion - G90 Galvanized	D3359	5B
Impact (direct/indirect)	D2794	80/40 in·lb
In Service Temperature Limit		250°F

Weather Resistance:

Tested System:
BONDERITE®1000
EWP-435
AUE-360

	ASTM Method	Result
Salt Spray – 1000 hours	B117	
Corrosion Creep	D1654	5A
Scribe Blisters	D714	None
Face Blisters	D714	None
Humidity – 1500 hours	D2247	
Corrosion	D1654	10A
Blistering	D714	None
Rusting	D1654	None

All tests results assume proper cure and preparation of test substrates. Unless otherwise stated, all results were obtained spraying product direct to metal on *Bonderite* 1000.

* The application and performance property data above are believed to be reliable based on laboratory findings. It is for the buyer to satisfy itself on the suitability of the product for its particular use. Variation in environment, procedures of use, or extrapolation of data may cause unsatisfactory results.

Miscellaneous:

EWP-435

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Safety:

These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment, materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness.

Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers.

Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645-1320 and in MÉXICO 01-800-00-21-400. Have label information available.

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.

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