

DTM Chassis Black

EST900

EST900 is a 2.8 VOC two-component, Direct to Metal (DTM) aliphatic polyurethane topcoat. EST900 is an easy-to-use product designed for truck chassis repair and refurbishment. EST900 offers outstanding weather resistance with excellent color and gloss retention. EST900 is a tough, flexible and abrasion resistant product.

Additional Products

- | | |
|------------------------------------|--------|
| • DTM Chassis Black | EST900 |
| • Hardener | ESH200 |
| • Standard Activator (60° - 68°F) | ESX510 |
| • Slow Activator (68° - 76°F) | ESX520 |
| • Very Slow Activator (76° - 88°F) | ESX530 |

Compatible Surfaces

EST900 may be applied over:

- Hot Rolled Steel (HRS) – blast cleaned to minimum SSPC SP-6, blasting profile 1 - 3 mils
- Cold Rolled Steel (CRS) – 80 grit DA
- Previous coating – (epoxy or polyurethane) Must be clean and free from any contamination, and abraded with 180 grit sandpaper.

Selection Of Substrate Cleaner - ONECHOICE® Commercial CFX Cleaners

Code	Product	Purpose
CFX435LV	Low VOC Cleaner	Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX437	Heavy Duty Wax & Grease Remover	Used to remove heavy milling oils and grease from bare substrates prior to the painting process.

Application Guide

Substrate and Preparation:



- Wash the area to be painted with soap and water, and then clean with CFX435LV, CFX436 or CFX437 cleaner.



- Sand with 180 grit on old finishes and body filler, then re-clean with CFX436 or CFX437 cleaner.



- Prime all substrates immediately after cleaning. Steel: Abrasive Blast to SSPC SP-6 or higher with a 1.0-3.0 mil surface profile.

Mixing Ratio:



4 : EST900
1 : ESH200
1 : ESX5xx

Pot Life:



	w/ ESX510	w/ ESX520	w/ ESX530
Pot Life @ 70°F (21°C)	1.5 hours	2.5 hours	6.5 hours

Spray Viscosity:



#3 EZ ZAHN:
15 – 25 seconds @ 77°F (25°C)

NOTE: High heat and humidity will shorten pot life of this material.

Additives:



N/A

Spray Gun Setup:

HVLP

COMPLIANT



Fluid Tip	1.4 - 1.8 mm or equivalent	1.6 – 2.0 mm or equivalent
Air Pressure	Maximum PSI per gun MFG settings	50-65 PSI at the spray gun

Pressure Pot Setup: Starting setup, adjust from here for best results

HVLP

COMPLIANT



Fluid Tip	1.0 – 1.4 mm or equivalent	1.3 – 1.8 mm or equivalent
Fluid Delivery	1.3 – 1.8 fluid ounces per minute	12 – 20 fluid ounces per minute

Number of Coats:



1-2 coats with 10 – 15 minutes flash between coats

Film Build: Wet Film (per coat) Dry Film (total)

Minimum Maximum 2.5 mils 5.0 mils 3.0 mils 6.0 mils

Flash Time:



Between coats Allow 10 minutes @ 70°F (21°C) before force drying 30 minutes @ 140°F (60°C)

Dry Times:

	w/ESX510	w/ESX520	w/ESX530
Dry Film thickness / mils	3.0	3.0	3.0
Dry to touch @ 70°F	1 hour	3 hours	5.5 hours
Dry to handle @ 70°F	2.5 hours	5-6 hours	< 19 hours

Force dry 30 minutes @ 140°F (60°C)

Drying time listed may vary depending upon film build, temperature, humidity and degree of air movement.

Activator	Min time before Recoat	Max time before Recoat
ESX510	30 minutes	2 hours
ESX520	30 minutes	1 Day
ESX530	8 hours	2 days

After above maximum dry times, sand EST900 with 320-400 grit (wet or dry) before applying another coat.

Note: Force drying times are for quoted surface temperature. Additional time should be allowed in the force-drying schedule to allow surface to reach recommended temperature.

Theoretical Coverage:

916 - 956 sq. ft.

Theoretical coverage in sq. ft. /US gal. Ready-to-spray (RTS), giving 1 mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency)

Application Guide (continued)

Physical Characteristics:**4:1:1****EST900 : ESH200 : ESX5X0**

Total Solids By Weight (RTS)	65.3 - 67.8%
Total Solids By Volume (RTS)	57.1 - 59.6%

RTS Combinations:**EST900 color**

Volume Ratio	Package (as is)
Applicable Use Category	Single-Stage Coating
VOC Actual	328.32 (g/L)
VOC Actual	2.74 (lbs/gal)
VOC Regulatory (less water less exempt)	328.32 (g/L)
VOC Regulatory (less water less exempt)	2.74 (lbs/gal)
Density	1289.33 (g/L)
Density	10.76 (lbs/gal)
Volatiles wt.	25.5 %
Water wt.	0.0 %
Exempt wt.	0.0 %
Water vol.	0.0 %
Exempt vol.	0.0 %

Health and Safety:

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.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.

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