

4.6 VOC Epoxy Primers – Gray/White/Black

ESU460/ESU461/ESU462

DELFLLEET ESSENTIAL[®] 4.6 VOC Epoxy Primer ESU460, ESU461 and ESU462 are two component, non-chrome epoxy primers designed to provide superior corrosion protection and adhesion when applied over properly cleaned and sanded bare metal, fiberglass and painted surfaces.

Additional Products

- 4.6 VOC Epoxy Primer Hardener ESU469

Compatible Surfaces

ESU460, ESU461 and ESU462 may be applied over:

- Properly prepared steel
- Properly prepared aluminum
- Properly prepared galvanized
- Properly prepared fiberglass
- Properly prepared OE enamel finishes

If sanding bare metal prior to application of ESU460, ESU461 or ESU462/ESU469, use 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry. Always use fresh sandpaper and thoroughly clean all substrates after sanding. Aluminum and carbon steel must be primed immediately after cleaning and sanding.

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

Preparation:



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



- Sand substrates, then re-clean with CFX435LV or CFX436 cleaner.

- Prime all substrates immediately after cleaning.

Mixing Ratio:



2 : ESU460, ESU461 or ESU462
1 : ESU469

Pot Life:



Mix only enough material that can be used in 6 – 8 hours. Allow a 15 minute induction period before applying..

8 hours after mixing @ 70°F (21°C)/50% RH.

NOTE: Heat shortens pot life of this material.

Spray Viscosity:



#2 EZ-Zahn 22 – 28 seconds

Additives:



Acetone may be added up to 10% to RTS ESU460, ESU461 or ESU462

Spray Gun Setup:

HVLP

COMPLIANT



Fluid Tip	1.3- 1.6 mm or equivalent	1.3 - 1.6 mm or equivalent
Air Pressure	8-10 PSI at the air cap max	40-50 PSI at the spray gun

Consult the Fleet Training Manual Spray Equipment section for additional gun set-up requirements.

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

HVLP

COMPLIANT



Fluid Tip	1.0 – 1.4 mm	1.0 – 1.4 mm
Fluid Delivery	10 - 12 fluid ounces per minute	10 - 12 fluid ounces per minute

Number of Coats:



1 - 2 coats

Film Build:

Wet Film
(per coat)

Dry Film
(total)

Minimum	2.8 mils	1.0 mil
Maximum		1.5 mils

Flash Time:



Between coats

10 – 15 minutes
@ 70°F (21°C)

Dry Times:



To Touch: 15 minutes @ 70°F (21°C)



To Handle: 30 minutes @ 70°F (21°C)



To Tape: 6 hours @ 70°F (21°C)



Flash prior to Bake: 5 - 10 minutes @ 70°F (21°C)

Force Dry: 30 minutes @140°F (60°C)

Overcoat/
Topcoat: Minimum:15 minutes
Maximum:72 hours
@ 70°F (21°C)

After 3 days, sand ESU460, ESU461 or ESU462 with 400 grit (wet or dry) before proceeding to the next undercoat or topcoat.

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.

Test Properties:

Color	ESU460 Gray ESU461 White ESU462 Black
VOC RTS Applied	4.54 lbs/gal (544 g/L)
VOC per Gallon of Coatings Solids (RTS)	12.45 - 12.55 lbs/gal (1492 -1504 g/L)
Volume Solids (RTS)	36.0 - 36.3%
Square Foot Coverage (RTS US Gal 100% Transfer Efficiency)	577 - 583 sq. ft./gal. @ 1 mil dry, no loss

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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