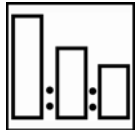


## E380 Epoxy Primer/Sealer

### FOR PROFESSIONAL USE ONLY

Description
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E380 is a high solids 3.5 VOC epoxy primer/sealer, which provides excellent filling over sand blasted metals. E380 dries fast while still maintaining good hold out and a smooth finish.



4	E380 Grey Epoxy Primer
1	E385 Epoxy Hardener



Use U-Tech measuring stick  
# 109

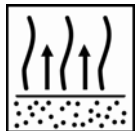


Spray gun set-up:  
1.5-1.9 mm  
HVLP max. 10 psi at air cap

Application pressure:  
40-50 psi ( 3-4 bar )  
o Check gun manufacturer specification



2-3 x 1 coat  
Apply single coats



Between coats  
15 minutes at 70°F (20°C)



Dry Times	70°F (20°C)	140°F (60°C)
Dry to recoat (wet-on-wet)	1 Hour	N/A
Dry to sand	7 hours	2 Hours



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

## E380 Epoxy Primer/Sealer

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#### Description

E380 is a high solids 3.5 VOC epoxy primer/sealer, which provides excellent filling over sand blasted metals. E380 dries fast while still maintaining good hold out and a smooth finish.

#### Product and additives

<b>Product</b>	E380 Grey Epoxy Primer E381 Black Epoxy Primer
<b>Hardener</b>	E385 Epoxy Hardener
<b>Reducers</b>	-
<b>Additives</b>	-

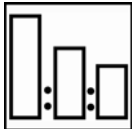
#### Basic raw materials

E380 Epoxy Primer: epoxy resins  
E385 Epoxy Hardener: polyamide resins

#### Suitable substrates

- Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry.
- Any premium polyester bodyfiller sanded with #P180 to #P220 grit dry.
- Aluminum after it has been properly treated with M5700 Alodine<sup>®</sup>. Please refer to the M5700 Alodine<sup>®</sup> TDS.
- Steel, degreased and sanded with #P80 then #P120 grit dry/red pad
- Blasted steel
- Fiberglass gelcoat (unbroken), degreased and sanded with #P220 to #P320 grit dry.

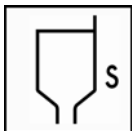
#### Mixing Ratio



4 parts by volume of E380 Grey Epoxy Primer  
1 parts by volume of E385 Epoxy Hardener

For easy and accurate mixing, use U-Tech measuring stick No. 109

#### Viscosity



at 70°F (20°C)

- 18-24 seconds ZAHN #3
- 35-50 seconds DIN #4

#### Spray gun set-up / application pressure



Spray gun	Fluid tip – set-up	Application pressure
HVLP gravity	1.8 – 2.2 mm	max. 10 psi at the air cap
High Transfer gravity	1.4 – 1.8 mm	max. 10 psi at the air cap

## E380 Epoxy Primer/Sealer

### FOR PROFESSIONAL USE ONLY

#### Application process



**As a wet-on-wet sealer.** Apply 1-2 medium flowing coats.

**As a primer surfacer that will be sanded.** Apply 2-3 medium flowing coats, allowing 15 minutes flash-off time between coats.

**As a substrate for polyester products.** Apply one single coat over the damaged area. Allow this to dry for 60 minutes at 70°F (20°C), (or up to 5 hours) before applying polyester filler.

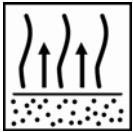
#### Pot-life

8 hours at 70°F (20°C)

#### Film thickness

Per coat: 1.5 mils. (25-40 µm)

#### Flash off



15 minutes between coats

#### Drying times



	70°F (20°C)	140°F (60°C)
<b>Recoatable wet-on-wet</b>	1 Hour	N/A
<b>To sand</b>	7 hours	2 Hours
<b>Recoatable with polyester products</b>	60 minutes per one coat	20 minutes per one coat

#### Sanding



Final dry sanding step #P400-500 before application of topcoats

*Initial sanding steps may be executed with a coarser sanding grit; #P320*



Final wet sanding step #P500-600 before application of topcoats

*Initial sanding steps may be executed with a coarser sanding grit; #P400*

#### Recoatable with

E380 Epoxy Primer/ Sealer can be recoated with U-Tech topcoats and U-Tech primer surfacers for up to 48 hours without sanding. After 48 hours, sanding will be required to insure intercoat adhesion.

Recoatable with polyester products after the stated dry time. E380 Epoxy Primer/ Sealer can be coated with a polyester product. Making it an ideal damage repair system on steel, galvanized steel and aluminum. After the polyester product and the E380 Epoxy Primer/ Sealer have dried, sand the polyester material until



## E380 Epoxy Primer/Sealer

### FOR PROFESSIONAL USE ONLY

satisfied with the repair. For further priming, any U-Tech primer/primer surfacer may be applied that is recommended for the substrates exposed. All U-Tech primers may be applied over sanded E380 Epoxy Primer/ Sealer.

#### Material usage

With recommended application, the theoretical material usage is  $\pm$  sq.ft./gl (m<sup>2</sup>/liter) per coat.

- o *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.*

#### Cleaning of equipment

Clean equipment with solvent borne cleaners

#### VOC

E380 Epoxy Primer Series	3.5 lb/gal	420 g/liter
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#### Product storage

Store products unopened, and used products with closed lids preferably between 60°F-95°F (10°C-35°C)  
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)

- o E380 Epoxy Primer: 2 years
- o E385 Epoxy Hardener: 12 months

### FOR PROFESSIONAL USE ONLY

**IMPORTANT NOTE:** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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