

E350 Epoxy Primer

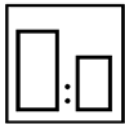
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| Description |
|-------------|
|-------------|

A two-component high solids corrosion inhibitive epoxy primer. E350 Epoxy Primer is a low VOC, high solids, HAPs-Free epoxy primer sealer. E350 Epoxy Primer is a versatile product that can be applied in a couple of different methods:

1. As a wet on wet, non-sanded primer-sealer. Topcoated with U-Tech Single stage systems and basecoat systems
2. As a primer-surfacer that can be sanded for extra smoothness and maximum appearance prior to topcoating.
3. As a transport primer
4. As a sealer coat over aged E350 Epoxy Primer (see Recoatability)
5. As a tintable primer, using (max 10%) U-Tech toners

The ready to spray VOC is 3.5 lbs/gal.



2 E350 Epoxy Primer
1 E350 Epoxy Primer Hardener



Use U-Tech Mixing Stick #103



Spray gun set-up:
1.4-1.7 mm

HVLP max. 10 psi at air cap

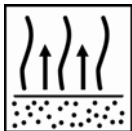
Application pressure:
40-50 psi (3-4 bar)

- o Check gun manufacturer specification



2 x 1 coat

Apply two single flowing coats. Apply second coat after indicated flash off time



Between coats
10 minutes at 70°F (21°C)

Wet on Wet with Topcoat
30 minutes at 70°F (21°C)



Before Topcoat
Dry to Sand

70°F (21°C)

30 minutes
8 hours

140°F (60°C)

10 minutes
1 hours



Use suitable respiratory protection

Akzo Nobel recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information



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Product and additives

| | |
|------------------|--|
| Product | E350 Epoxy Primer (Gray) E351 Epoxy Primer Black E352 Epoxy Primer White |
| Hardener | E350 Epoxy primer Hardener E356 Epoxy Primer Hardener Fast |
| Additives | E359 Flow Additive |

Product Characteristics

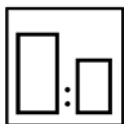
| | | | |
|---------------------|---------------------|----------------------|-----------------------|
| WPG (A component) | 13.7 – 14.5 lb/gal | Gloss | Low |
| Volume Solids (RTS) | 53 –56 % | Color | Black, Grey and White |
| Pot Life | 4 hrs @ 70°F (21°C) | Theoretical Coverage | 857 sq/ft @ 1mil TE |
| Resistivity | 20 – 40 kOhms | | |

Suitable Surfaces

- 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®. Please refer to the M5700 Alodine® TDS.
- Aluminum, degreased and sanded with P180-P220/Red pad
- Steel, degreased and sanded with #P80 then #P120 grit dry/red pad
- Galvanized steel, degreased and sanded with P180/red pad
- Blasted steel
- Fiberglass gelcoat (unbroken), degreased and sanded with #P220 to #P320 grit dry.

Do not apply E350 Epoxy Primer over Thermoplastic Acrylic Lacquers
Chemical cleaners and pretreatments should be pre-approved by Akzo Nobel

Mixing Ratio



2 parts by volume E350 Epoxy Primer
1 part by volume E350 Epoxy Primer Hardener or E356 Epoxy Primer Hardener Fast

Add up to 10% E359 Flow additive for improved appearance

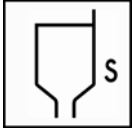
Use U-Tech Mixing Stick #103

NOTE: The E350 Epoxy Primer can be Tinted up to 10% using the U-Tech Toners to accommodate a colored primer, before mixing with the hardener.

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Viscosity



25 – 28 sec EZ #2 ZAHN at 70°F (21°C)
11 – 13 sec EZ #3 ZAHN at 70°F (21°C)

Viscosity is Ready to Spray

Spray gun set-up / application pressure



| Spray gun | Fluid tip | pressure | Fluid pressure |
|----------------------|-----------------|-----------------------|----------------|
| Siphon feed | 1.4 – 1.7mm | 50 – 60 psi | |
| Gravity feed | 1.3 – 1.5mm | 50 – 60 psi | |
| HVLP Siphon | 1.4 – 1.7mm | Max 10 psi at air cap | |
| HVLP Gravity | 1.4 – 1.7mm | Max 10 psi at air cap | |
| Pressure feed | 1.0 – 1.4mm | 50 – 60 psi | 12 – 16 oz/min |
| HVLP Pressure feed | 1.0 – 1.2mm | Max 10 psi at air cap | 10 – 14 oz/min |
| Airless spray | 0.011" – 0.015" | 1500 – 3000 psi | |
| Air assisted airless | 0.011" – 0.015" | 700 – 900 psi | |
| Electrostatic | 1.2 – 1.7mm | 60 – 70 psi | 12 – 14 oz/min |

Application process



Wet on Wet Primer Sealer - Apply 1-2 medium flowing coats. For repairs down to bare metal, apply an initial thin coat over area, allow proper flash time and then follow with one medium flowing coat.

Primer Surfacer (Sanded) – Apply (2) two single flowing coats with proper flash time between coats.

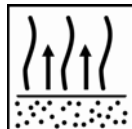
Transport Primer – Apply (2) two single flowing coats followed with proper flash time between coats. See recoatability section.

Dry Film thickness

Primer Sealer – 1.2 – 1.4 mils
Primer Surfacer (Sanded) or Transport Primer – Minimum 2.0 mils

Apply 1.2 – 1.4 mils per coat

Flash Times



10 minutes at 70°F (21°C) between coats

30 minutes at 70°F (21°C) final flash before topcoating (1.2 – 1.4 mil)

45-60 minutes at 70°F (21°C) final flash before topcoating (High Film Thickness)



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Dry Times



E350 Epoxy Primer Hardener

| Object Temperature | Before Topcoat @ (1.2 – 1.4mils) | Dry to Sand |
|--------------------|----------------------------------|-------------|
| 50°F (10°C) | 1 hour | 24 hours |
| 70°F (21°C) | 30 min | 8 hours |
| 100°F (38°C) | 20 min | 2 hours |
| 140°F (60°C) | 10 min | 1 hour |



E356 Epoxy Primer Hardener Fast

| Object Temperature | Before Topcoat @ (1.2 – 1.4mils) | Dry to Sand |
|--------------------|----------------------------------|-------------|
| 50°F (10°C) | 1 hour | 16 hours |
| 70°F (21°C) | 15 min | 4 hours |
| 100°F (38°C) | 15 min | 1 hour |
| 140°F (60°C) | 10 min | 30 min |

Recoatability

E350 Epoxy Primer at a 1.2 -1.4 mil DFT can be topcoated after a final flash of 30 minutes at 70°F (21°C). For higher film thicknesses, allow a 45 – 60 minute final flash for optimum topcoat appearance.

Non-sanded E350 Epoxy Primer must be topcoated within 7 days of parts being stored indoors at 70°F (21°C). After 7 days of indoor exposure, E350 Epoxy Primer must be sanded prior to topcoating.

Non-sanded E350 Epoxy Primer must be topcoated within 24 hours of parts being stored outside. Outside exposure greater than 24 hours and up to 6 months require a power wash and re-application of one (1) coat of E350 Epoxy Primer prior to topcoating.

Do not allow E350 Epoxy Primer to be outside greater than 6 months without topcoating.

Do not apply polyester bodyfillers over E350 Epoxy Primer

Cleaning of equipment

Clean equipment with U-Tech Cleaning Solvent

VOC

| | | | |
|---|-------------------|------------|---------|
| VOC Total (Method 24) | E350 Epoxy Primer | 3.5 lb/gal | 420 g/l |
| VOC is ready to spray at a mix ratio of 2:1 | | | |



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Product storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

| | |
|---------------------------------|----------|
| E350 Epoxy Primer | 1 year |
| E351 Epoxy Primer Black | 1 year |
| E352 Epoxy Primer White | 1 year |
| E350 Epoxy Primer Hardener | 6 months |
| E356 Epoxy Primer Hardener Fast | 6 months |

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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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