

2.1 VOC Epoxy Primer Gray

ESU480

DELFLLEET ESSENTIAL[®] ESU480 is a 2.1 VOC epoxy primer that offers exceptional adhesion over a wide array of substrates. This non-sanding primer provides a smooth finish and fast topcoat times, making this the product of choice in high productivity shops.

Additional Products

- 2.1 VOC Epoxy Primer ESU480
- 2.1 VOC Epoxy Hardener ESU489

Compatible Surfaces

ESU480 may be applied over:

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

If sanding bare metal prior to application of ESU480, use 80 grit (stainless steel) or 120-180 grit (steel and aluminum).

Sand old finishes with 220-320 grit wet or dry.

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, and then clean with CFX436 or CFX437 wax and grease remover.



- Sand substrates with 180 – 240 grit on old finishes and body filler, then re-clean with CFX435LV or CFX436 cleaner.

- Prime all substrates immediately after cleaning.

Mixing Ratio:



4 : ESU480
1 : ESU489

Pot Life:



Pot life of this product is variable depending on temperature and on activator choice.

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

NOTE: Heat shortens pot life of this material.

Spray Viscosity:



#2 EZ-Zahn 25 seconds

Additives:



N/A

Spray Gun Setup:

HVLP

CONVENTIONAL

Fluid Tip 1.3 - 1.5 mm or equivalent 1.3 - 1.5 mm or equivalent



Air Pressure 10 PSI at the air cap 35 PSI at the spray gun

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

HVLP

CONVENTIONAL

Fluid Tip 1.3 - 1.5 mm 1.3 - 1.5 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
Maximum

2.3 mils
6.8 mils

1.0 mils
3.0 mils

Flash Time:



Between coats

10 – 15 minutes @ 70°F (21°C)

Dry Times:



To Touch:

15 minutes @70°F (21°C)



To Handle:

90 minutes @ 70°F (21°C)



To Tape:

3-4 hours @70°F (21°C)



Flash prior to force dry:

10-15 minutes @ 70°F (21°C)

Force Dry:

25 minutes @ 140°F (60°C)

Overcoat/
Topcoat:*

30-45 minutes @ 70°F (21°C)

*After 4 days, sand ESU480 with 400 grit (wet or dry) before proceeding to the next undercoat or topcoat. Do not sand to below minimum dry film thickness over bare metal.

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:

ESU480 Volume Solids (packaged)	40.7 %
Volume Solids (RTS)	44.1 %
Square Foot Coverage (RTS US Gal 100% Transfer Efficiency) 4:1 mix ratio	707 sq. Ft. @ 1 mil dry

Application Guide Continued

RTS Combinations:	ESU480	ESU489	ESU480 : ESU489
Volume Ratio:	As Is	As is	4 : 1
Applicable Use Category	Primer	Primer (Hardener)	Primer
VOC Actual (g/L)	117	291	152
VOC Actual (lbs/gal)	0.98	2.43	1.27
VOC Regulatory (less water less exempt) (g/L)	217	321	248
VOC Regulatory (less water less exempt) (lbs/gal)	1.81	2.68	2.07
Density (g/L)	1467	990	1371
Density (lbs/gal)	12.24	8.26	11.44
Volatiles wt. %	33.6	42.3	43.4
Water wt. %	0.1	0.0	0.1
Exempt wt. %	35.6	12.9	32.3
Water vol. %	0.1	0.0	0.1
Exempt vol. %	46.1	9.5	38.8

**Health and Safety - Improper handling & application of products could impact product safety and performance.
Read the product label and MSDS before use.**

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

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