

JP390 2.1 VOC Epoxy Primer - Gray

Background

JP390 is a gray 2.1 VOC two component epoxy primer which may be used as a primer or as a sealer.

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Reducers

JR554 (55°F- 65°F), JR555 (65°F- 75°F), JR556 (75°F- 85°F)
Compliant Reducers.

Hardener

JH397 2.1 VOC Epoxy Hardener

Topcoats

JBX 3.5 VOC Basecoat
JBPX 3.5 VOC Acrylic Urethane Basecoat
JLX 2.8 VOC Acrylic Enamel
JTX 2.8 VOC Single Stage

Substrates

Cleaned and sanded steel, galvanized and aluminum
Sanded and cleaned fiberglass and SMC
Cleaned and sanded cured OEM and refinish coatings
JP205 Polyester Primer

Preparation

Surface Cleaning SWX350 H₂O-So-Clean, SXA330 Wax and Grease Remover, SX1009 2.9 VOC Bug and Tar Remover.
Sanding **For use as primer:** 180 - 220 Grit machine on bare steel
For use as sealer: 320 - 400 Grit machine on primer and old finishes

Mixing

Primer:



| | | | | |
|--------------|---|--------------|---|--------------|
| JP390 | : | JH397 | : | JR55X |
| 2 | : | 1 | : | 1 |

Sealer:



| | | | | |
|--------------|---|--------------|---|--------------|
| JP390 | : | JH397 | : | JR55X |
| 2 | : | 1 | : | 2 |

Pot life



3 - 4 hour at 70° (21°C)

Additives

None

Application

Coats



2:1:1 1 - 2 coats used as a primer
2:1:2 2 - 3 coats used as a sealer

Note: When additional reducer is added when sprayed as a sealer, be sure that the minimum recommended film build is maintained. (see below)

Air Pressure



HVLP 8 - 10 psi at the air cap
Compliant 29 - 40 psi at the gun
Conventional 40 - 50 psi at the gun

Gun Setup

1.3 - 1.6 mm or equivalent

Dry Times

Between Coats



5 - 10 minutes at 70°F (21°C)

Air Dry at 70° (21°C)



2:1:1 Primer
60 minutes to topcoat at 70°F (21°C)
2:1:2 Sealer
30 - 40 minutes to topcoat at 70°F (21°C)

Force Dry



2:1:1 Primer
30 minutes at 140°F (60°C) metal temperature and cool down to topcoat

IR (Infrared)



2:1:1 Primer
10 - 15 minutes and cool down to topcoat

Note: JP390 2.1 VOC Epoxy Primer must be scuffed and re applied if allowed to sit more than 3 days (72 hours).

Clean Up

Clean spray guns, gun cups, storage pots, etc., thoroughly with the appropriate clean up solvent such as JT571 0.21 VOC General Purpose Solvent after each use. Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint

Properties

Dry Film Build Per Coat

Applied 2:1:1 1.0 mils
2:1:2 0.7 mils

Square ft. coverage at 1mil

2:1:1 650 Sq. ft., gal. @ 100% transfer
2:1:2 520 Sq. ft., gal. @ 100% transfer

| PRIMER-SEALER | Primer | Sealer |
|--|-----------------------|-----------------------|
| RTS Combinations: | JP390 : JH397 : JR55X | JP390 : JH397 : JR55X |
| Volume Ratio: | 2 : 1 : 1 | 2 : 1 : 2 |
| Applicable Use Category | Primer | Primer-Sealer |
| VOC Actual (g/L) | 144 | 115 |
| VOC Actual (lbs/gal) | 1.21 | 0.96 |
| VOC Regulatory (less water less exempt (g/L) | 248 | 248 |
| VOC Regulatory (less water less exempt) (lbs/gal) | 2.07 | 2.07 |
| Density (g/L) | 1313 - 1349 | 1291 - 1346 |
| Density (lbs/gal) | 10.96 - 11.25 | 10.77 - 11.23 |
| Volatiles wt. % | 49.1 - 50.4 | 58.6 - 60.3 |
| Water wt. % | 0.1 | 0.1 |
| Exempt wt. % | 38.1 - 39.7 | 49.6 - 51.7 |
| Water vol. % | 0.2 | 0.1 - 0.2 |
| Exempt vol. % | 42.0 - 42.1 | 53.6 - 53.7 |

Precautionary Information:

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

Medical Response:

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320.

Material Safety Data Sheet:

Material Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG Distributor.

For additional information regarding this product, see the MSDS and label information.

To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries is constantly improving its coating and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your ShopLine® Distributor for the most up-to-date information.