

2.1 VOC Wet on Wet Epoxy Primer – Gray

ESU470

ESU470 is a non-sanding, low VOC, smooth finish Epoxy Primer designed for high productivity shops looking for the corrosion protection expected of an epoxy and exceptional time to topcoat.

Additional Products

- | | |
|------------------|--------|
| • 2.1Epoxy | ESU470 |
| • Hardener | ESU479 |
| • Fast Reducer | ESR300 |
| • Medium Reducer | ESR310 |

Compatible Surfaces

ESU470 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 ESU470, use 180-210 grit wet or dry. Sand old finishes with 320 to 400 grit wet or dry.

Selection of Substrate Cleaner

Code	Product	Purpose
DX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
DX437	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 DX436 or DX437 wax and grease remover.



- Sand substrates, Sand with 180 – 240 grit on old finishes and body filler, then re-clean with DX436 or DX437.



- Prime aluminum, steel, galvanized, stainless and carbon steel immediately after cleaning

Mixing Ratio:



2 : ESU470
1 : ESU479
1-2 : ESR3XX

Pot Life:

6-8 hours after mixing at 77°F (25°C)



Pressure Feed/HVLP 1.2 – 1.4 mm

Conventional Feed/HVLP 1.4 – 1.6 mm

Air Pressure

HVLP at the air cap 8 – 10 PSI
Conventional at the spray gun 40 – 50 PSI

Number of Coats:



1 – 2 coats

Total Film Build:

	Wet	Dry
Minimum	2.5 mil	1.1 mils
Maximum	5.0 mils	2.5 mils

Flash Times @ 70°F (21°C):



Between coats 10 – 15 minutes

Dry Times:



Dust Free:
68°F (20°C) 15 minutes



Tack Free:
68°F (20°C) 90 minutes



Tape Time:
68°F (20°C) 4 hours



To Topcoat:
68°F (20°C) 30 – 45 minutes

Force Dry:
140°F (60°C) 30 minutes

After 4 days sand ESU470 with 400 grit (wet/dry) before proceeding to the next undercoat/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:

Volume Solids (RTS)	32.42 – 40.52
Film Build Per Coat	0.7 – 1.5
Square Foot Coverage @ 1 mil	649.94

RTS Combinations:

	ESU470 : ESU479 : ESR3XX	ESU470 : ESU479 : ESR3XX
Volume Ratio:	2 : 1 : 1	2 : 1 : 2
Applicable Use Category	Primer	Primer
VOC Actual (g/L)	144	115
VOC Actual (lbs/gal)	1.2	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)	1272 -1306	1231 - 1286
Density (lbs/gal)	10.61 - 10.90	10.27 - 10.73
Volatiles wt. %	47.8 - 49.2	56.8 - 58.7
Water wt. %	0.0	0.0
Exempt wt. %	36.5 - 38.1	47.5 - 49.7
Water vol. %	0.0	0.0
Exempt vol. %	42.0	53.6
Solids vol. % RTS	40.6	32.5
Sq. Ft. coverage @ 1 mil	651	521
Film Build per coat (mil.)	0.5 - 0.7	0.5 - 0.7

Health and Safety

Please refer to Material Safety Data Sheets (MSDS) for full health safety details and storage regulations.

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

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and not to be construed as representations or warranties as to performance, results or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

PPG Industries
Commercial Coatings
We're Everywhere You Look

PPG Industries
19699 Progress Drive
Strongsville, Ohio 44149
1-800-647-6050

PPG Canada Inc.
2301 Royal Windsor Drive
Mississauga, Ontario L5J 1K5
1-888-310-4762