

# Product Information

## EPW115 Waterborne Speed Prime

### Product Description

ENVIROBASE® High Performance EPW115 Waterborne Speed Prime is a Direct to Metal (DTM) primer-surfacer. This market leading 1K waterborne technology is ideal for spot and speed lane repairs. EPW115 Waterborne Speed Prime eliminates the bare metal etch step and can be sanded in as little as twenty minutes producing a high quality and speedy repair.

### Preparation of Substrate



- Wash the area to be painted with soap and water, then clean with appropriate PPG cleaner such as SX330, SXA330 or SWX350.
- Sand the bare metal areas completely with 180-220 grit abrasive and clean.
- Sand old finishes with 220-320 grit dry by hand or machine and clean.
- Glass reinforced plastic (GRP), fiberglass and body filler 180-220 grit abrasives and clean.
- E-coat must be thoroughly sanded with 180-220 grit abrasive and cleaned.
- Aluminum substrates must be primed within 8 hours of sanding and cleaning.
- Carbon steel, Galvanized and Galvaneal must be primed immediately after sanding and cleaning.
- EPW115 may be applied to properly sanded and cleaned bare metal.
- For bare plastics, an appropriate PPG plastic adhesion promoter must be applied prior to the application of EPW115.

**Do Not** use SU4902 Adhesion Wipe prior to applying SU4903 or SUA4903 Advance Plastic Bond because the wipe is not compatible with EPW115.

## APPLICATION GUIDE:

### Surface Preparation Notes:



Apply EPW115 directly to cleaned and sanded bare metal without etch primer.

EPW115 application over plastics requires a PPG plastic adhesion promoter.

Note: EPW115 is not compatible with SU4902 Adhesion Wipe.

Body filler must be sanded with 180 dry grit to provide a rough surface for good mechanical adhesion. Remove sanding dust over body filler with air pressure, do not use liquid cleaners over porous surface.

### Mixing Ratio:



**EPW115**                      **Waterborne Speed Prime**                      **1**  
**T494**                      **Thinner**                      **10% by weight (13% by volume)**

Shake EPW115 Waterborne Speed Prime for 2 minutes on shaker using DEX620 WB Shaker Collar before its first use.

**Note:** T492 Adjuster and T595 High Temp/Low Humidity thinner are not recommended for use with EPW115.



**Pot Life:**                      24 hours at 70°F (21°C)

### Cumulative Mix by Weight in Parts (Grams) for EPW115 Waterborne Speed Primer

	Product	4 oz. / ¼ Pint	8 oz. / ½ Pint	16 oz. / 1 Pint	32 oz. / 1 Quart
	EPW115	<b>154.5</b> (137.0)	<b>309.0</b> (274.0)	<b>618.0</b> (548.0)	<b>1235.9</b> (1095.9)
	T494	<b>170.0</b> (150.7)	<b>340.0</b> (301.4)	<b>679.9</b> (602.9)	<b>1359.7</b> (1205.7)

### Optional Additives:



None

**Note:** Do not use flexible additives in EPW115 Waterborne Speed Prime

### Spray Gun Set-up and Pressure:



**HVLP:**                      10 psi at the cap  
**Compliant:**                      29-40 psi at the gun  
**Fluid Tip:**                      1.4-1.8 mm

**Note:** For best overall results, refer to the spray gun manufacturers recommendations for optimum inlet air pressures.

### Application:



**Apply:**                      3-5 wet coats  
**Film Build:**                      0.8-1.0 mils per coat



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**Film Build:**                      0.8-1.0 mils per coat

EPW115 Waterborne Speed Prime can be rolled on. Apply using reverse priming technique with a foam roller to achieve a smooth surface.

**Note:** For optimal performance with either spray or roller application, the minimum dry film thickness must be approximately 2 mils after sanding over bare metal areas.

### Flash Off at 70°F (21°C):



**Between Coats:**                      Dehydrate wet film with air knife until surface is dried to a matte finish.  
Approximately 1-3 minutes

**Note:** Air movement over the surface wicks moisture up from the substrate.  
Recommend DEX610 Air Knife tool

## Drying Times:



**Dry to Handle:**  
70°F (21°C)

Immediately after the surface becomes uniformly matte in appearance.



**Dry to Sand:**  
70°F (21°C)

Approximately 30 minutes after final coat is uniformly matte in appearance.  
High humidity and low temperature may adversely affect dry times.

**Note:** When sanded EPW115 primer stands for more than 24 hours, it must be lightly scuff sanded and re-cleaned prior to top coating.

Note: Never use ammonia based cleaners (glass cleaners) over EPW115.



**IR (Infrared):**

Not to exceed 120°F (49°C) metal temperature.

## Compatible Topcoats:

**Once sanded, EPW115 Waterborne Speed Prime may be over coated with:**

ECS2x Series A-Chromatic LV Sealers

ECS6x Series A-Chromatic LV Sealers

ECS8x Series A-chromatic LV Sealers

*Envirobase* High Performance Waterborne Basecoat

DELTRON® DBC basecoats must be applied over an appropriate 2K urethane sealer

GLOBAL REFINISH SYSTEM® BC basecoats must be applied over an appropriate 2K urethane sealer.

## Storage and Handling:

EPW115 Waterborne Speed Prime should be stored in a cool, dry place away from sources of heat.  
During storage and transportation, temperature must be maintained at a minimum of 41°F (5°C) and a maximum of 120°F (49°C). Avoid exposure to frost or freezing conditions.

## Equipment Cleaning:

Mixed material may be stored in an approved sealed plastic container for up to 24 hours. All spray equipment should be cleaned after each use with SWX100 Waterborne Gun Cleaner.

## Technical Data:

RTS Combinations	EPW115 : T494
Applicable Use Category	Primer
Weight Ratio:	1 : 10%
VOC Actual (g/L)	36
VOC Actual (lbs./ US gal.)	0.30
VOC Regulatory (less water, less exempt (g/L)	86
VOC Regulatory (less water, less exempt (lbs./ US gal.)	0.72
Density (g/L)	1283
Density (lbs./ US gal)	10.71
Volatiles wt. %	48.7
Water wt. %	45.9
Exempt wt. %	0
Water vol. %	59.1
Exempt vol. %	0
RTS Solids vol. %	36.05
Sq. Ft. Coverage at 1 mil. at 100% transfer efficiency	578

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## HEALTH AND SAFETY

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See Safety Data Sheet and Labels for additional safety information and handling instructions.

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- 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 and SDS of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.
- Provide adequate ventilation for health and fire hazard control.
- Follow company policy, product SDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS.
- Store waterborne and solvent borne waste separately. A competent agent with appropriate certification must handle all waterborne wastes. Wastes must be disposed in accordance with all Federal, State, Provincial and local laws and regulations.
- Always observe all applicable precautions and follow good safety and hygiene practices.

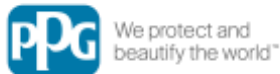
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### Emergency Medical or Spill Control Information: (412) 434-4515; In Canada (514) 645-1320

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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 are not to be construed as representations or warranties as to performance, result, 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.

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