



2.1 VOC Epoxy Primer-Grey P330-2200

Description P330-2200 is a grey 2.1 VOC two component epoxy primer which may be used as a primer or as a sealer.

Products	2.1 VOC Epoxy Primer:	P330-2200	
	Activator:	P330-2201	
	Thinner:	P830-2034	Compliant Thinner-Fast
		P830-2035	Compliant Thinner-Medium
	P830-2036	Compliant Thinner-Slow	

Suitable for use over:

Cleaned and sanded steel, galvanized and aluminum, sanded and cleaned fiberglass and SMC, cleaned and sanded cured OEM and refinish coatings.

Compatible

Topcoats: VALUE-PRO VBX, VBPX, VUX

Surface Preparation

SWX350 H2O-So-Clean, SXA330 Wax and Grease Remover, SX1009 2.9 VOC Bug and Tar Remover.

Sanding



Bare metal: Machine sand 180 - 220 grit

Old finishes: Machine sand 320 - 400 grit on primers and old finishes.

Note: P330-2200 Epoxy Primer must be scuffed and re applied if allowed to sit more than 3 days (72 hours).

Mixing



Primer:	P330-2200
Activator:	P330-2201
Thinner:	P830-203x

Primer

2 Parts
1 Part
1 Part

Sealer

2 Parts
1 Part
2 Parts



Pot Life: 3 - 4 hour @ 70°F/21°C

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

Application



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

Refer to manufacturer's inlet pressure requirements.

Coats

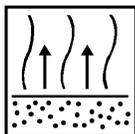


2:1:1 1 - 2 coats used as a primer
2:1:2 2 - 3 coats used as a sealer

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

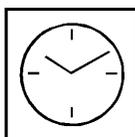
Dry Film Build Per Coat Applied	2:1:1	1.0 mils
	2:1:2	0.7 mils
Square ft. coverage at 1mil	2:1:1	650 Sq. ft., gal. @ 100% transfer
	2:1:2	520 Sq. ft., gal. @ 100% transfer

Flash Time



5-10 minutes between coats @ 70°F/21°C

Drying



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)

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

I.R

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

Clean Up

Clean up equipment immediately after use, using Value-PRO thinner or another suitable solvent. Dispose of waste in accordance with applicable regulations.

PRIMER-SEALER	Primer	Sealer
RTS Combinations:	P330-2200 : P330-2201 : P830-203x	P330-2200 : P330-2201 : P830-203x
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

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

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION:

USA (412) 434-4515; CANADA (514) 645-1320; MEXICO 91-800-00-214