

Epoxy Primer

EPX Series Primers

EPX-900	Beige Epoxy Primer
EPX-904	Gray Epoxy Primer
EPX-908	Black Epoxy Primer
EPX-950	White Epoxy Primer

EPX Series Primers are all purpose Epoxy Primers that create a superior corrosion resistant undercoating with excellent adhesion properties. Easy to spray and use, this low HAPS primer provides a longer pot life (3 days) than most primers.

To realize the benefits of the EPX Series, apply over properly prepared surfaces such as steel, galvanized steel, aluminum and fiberglass.

Features and Benefits:

- Provides excellent corrosion and chemical resistance
- Has excellent adhesion properties
- Provides a low film build
- Is easy to spray and use

Associated Products:

- EPX-900 Beige Epoxy Primer
- EPX-901 Epoxy Primer Catalyst
- EPX-904 Gray Epoxy Primer
- EPX-908 Black Epoxy Primer
- EPX-950 White Epoxy Primer

Physical Constants: *All values are theoretical, depend on color and are Ready-to-Spray. Actual values could vary slightly due to manufacturing variability.*

	EPX-900 (RTS)	EPX-904 (RTS)	EPX-908 (RTS)	EPX-950 (RTS)
Weight per gallon (US)	8.70	8.62	8.25	8.71
Percent solids (by weight)	37.9%	37.3%	33.4%	33.1%
Percent solids (by volume)	23.4%	23.1%	22.2%	23.4%
VOC	5.40 lbs/gal	5.41 lbs/gal	5.50 lbs/gal	5.40 lbs/gal
HAPs	≤1.4 lbs/gal	≤1.4 lbs/gal	≤1.4 lbs/gal	≤1.4 lbs/gal
Photo-chemically reactive	No	No	No	No
Flashpoint:				
EPX-900 only = 30°F	EPX-904 only = 30°F	EPX-901 only = 40°F		
EPX-908 only = 36°F	EPX-950 only = 30°F			

Directions for Use:

Substrate Preparation:

The surface to be coated must be sanded and free of all contamination (including dust, dirt, oil, grease, and oxidation). Variability can occur with substrates, preparation, application method or environment. Chemical treatment and the use of a conversion coating will improve the performance properties of the coating system.



Substrate	Direct to Substrate
Cold Rolled Steel	Excellent
Hot Rolled Steel	Excellent
Galvaneal	Very Good
Galvanized	Good
Aluminum	Very Good
Plastic / Fiberglass	Surface should be free of all contamination. Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic/fiberglass substrate being used.

Note: For acceptable compatibility between this primer and CPC topcoats please see the CPC Primer/Topcoat compatibility chart (CPCTB01).

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Directions for Use (continued)

Mix Directions:



Mix Directions: Thoroughly agitate component A on mechanical shaker prior to mixing. Stir thoroughly before and occasionally during use. Allow 30 minutes induction period to obtain maximum performance properties.

Thinning: Not usually needed; but can use up to 5% Q60 (MEK), Q30 (Acetone), or Q50 (Aromatic 100). The addition of Q50 and Q60 will raise VOC; please verify the new value is compliant in your area.

Blend Ratio: EPX-9## : EPX-901
1 : 1



Pot Life @ 77°F (25°C): 72 hours



Spray Viscosity Range: #2 Zahn: 15 – 25 seconds (varies by color)

Shelf Life: 2 years unopened
(each component)

Application Equipment:



Conventional/Compliant (with or without pressure pot): 1.4 – 1.8 mm needle/nozzle, 50 – 70 psi at the gun



HVLP (with or without pressure pot): 1.3 – 1.6 mm needle/nozzle, 10 psi at cap or per manufacturer

Airless: 0.013 – 0.015 mm: 1800 – 2600 psi fluid pressure

Air-Assisted Airless: 0.013 – 0.015 mm: 900 – 1500 psi fluid pressure



Brush or Roll: Not recommended

Electrostatic: For improved electrostatic capability, 5 – 10% Acetone (Q30) or MEK (Q60) may need to be added.

Application:



Apply: 1 – 2 medium coats with a 10 – 15 minute flash between coats. Apply only when air, product and surface temperatures are above 60°F (16°C) and when surface temperature is at least 5°F (3°C) above the dewpoint.

Recommended Wet Film Build: 4 – 6 mils

Recommended Dry Film Build: 1 – 1.5 mils

Square Foot Coverage @ 1mil no loss: 356 – 376 sq. ft. depending on primer color

Dry Times:



Air Dry @ 77°F 50% RH:

To Touch: 15 minutes

To Handle: 45 minutes*

To Recoat: 1 hour - 4 days.

After 4 days the primer should be mechanically abraded before topcoating or recoating.

Force Dry @ 140°F: 30 minutes at 140°F after 10 minute flash at 77°F.

** Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.*

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Technical Data*

Performance Properties:

BONDERITE® 1000
EPX-900
no topcoat

Test	ASTM Method	Results
Pencil Hardness	D3363	F
Conical Mandrel	D522	Pass
Adhesion	D3359	5B
Chip Resistance	D3170	7
In Service Temperature Limit **		300°F (149°C)

** As you approach 300°F (149°C) depending on the pigmentation, the color may change, but the film integrity will be maintained up to 300°F (149°C).

Chemical Resistance:

Bonderite 1000
EPX-900
no topcoat

Chemical	ASTM Method	Result
Toluene	D1308	Slight ring
10% NaOH (Sodium Hydroxide)	D1308	Slight fade
10% HCl (Hydrochloric acid)	D1308	Pass
10% H ₂ SO ₄ (Sulphuric acid)	D1308	Slight fade
Gasoline	D1308	Slight ring, yellow
Isopropanol	D1308	Slight ring
Water**	D1308	Pass

** Although resistant to intermittent exposure, this product is not recommended for immersion.

Weather Resistance:

System:
Bonderite 1000
EPX-900
AUE-100

	ASTM Method	Result
Salt Spray – 1000 hours	B117	
Corrosion Creep	D1654	4A – 5A
Scribe Blisters	D714	8D, 6M, 4M
Face Blisters	D714	None
Humidity – 96 hours	D2247	
5 Minute Recovery Adhesion	D3359	5B
1 Hour Recovery Adhesion	D3359	5B
24 Hour Recovery Adhesion	D3359	5B

All tests results assume proper cure and preparation of test substrates. Unless otherwise stated, all results were obtained spraying product direct to metal on *Bonderite 1000*.

* The application and performance property data above are believed to be reliable based on laboratory findings. It is for the buyer to satisfy itself on the suitability of the product for its particular use. Variation in environment, procedures of use, or extrapolation of data may cause unsatisfactory results.

Miscellaneous

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Safety:



These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public.

Safe application of paints and coatings requires knowledge of equipment, materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness.

Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers.

Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.

PRECAUTIONARY INFORMATION

Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal.

KEEP OUT OF THE REACH OF CHILDREN

MEDICAL RESPONSE

Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645-1320 and in MEXICO 01-800-00-21-400. Have label information available.



Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.



PPG Industries
Commercial Coatings
19699 Progress Drive
Strongsville, OH 44149
1-800-647-6050

PPG Canada Inc.
2301 Royal Windsor Drive, Unit #6
Mississauga, Ontario L5J 1K5
1-888-310-4762