

3.5 VOC Primer Surfacer

ESU440

ESU440 is a high build gray polyurethane primer surfacer that offers excellent sanding characteristics and gloss holdout. The ranges of activators available are designed to provide maximum application flexibility.

Additional Products

- | | |
|---------------------------|--------|
| • 3.5 VOC Primer Surfacer | ESU440 |
| • Hardener | ESU449 |
| • Fast Activator | ESX500 |
| • Standard Activator | ESX510 |
| • Slow Activator | ESX520 |
| • Very Slow Activator | ESX530 |

Compatible Surfaces

ESU440 may be applied over:

- ESU400 Wash Primer
- ESU420/421 3.5 VOC Epoxy Primers
- ESU430 Epoxy Primer
- ESU460/461/462 4.6 VOC Epoxy Primers
- ESU470 2.1 VOC Epoxy Primer
- ESU480/481/482 2.1 VOC Epoxy Primers
- Cured, cleaned and sanded OEM and other cured coatings
- Sanded and cleaned fiberglass and SMC
- Sanded and cleaned body filler (Apply 2 full coats over sensitive finishes, completely overlapping substrate)

Selection of Substrate Cleaner - ONECHOICE[®] Commercial CFX Cleaners

Code	Product	Purpose
CFX435LV	Low VOC Cleaner	Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process
CFX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
CFX437	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 CFX435LV, CFX436 or CFX437 cleaner.



- Sand with 180 – 240 grit on old finishes and body filler, then re-clean with CFX435LV or CFX436 cleaner.



- Apply ESU440 immediately after prepping and cleaning acceptable substrates and/or coatings.

Mixing Ratio:



6 : ESU440
1 : ESU449
1 : ESX500/ESX510/ESX520/ESX530

Pot Life:

Pot life of this product is variable depending on temperature and on activator choice.



ESX500 @ 70°F (21°C)/50% RH 1.5 hours
ESX530 @ 70°F (21°C)/50% RH 4 hours

Spray Viscosity:
#2 EZ Zahn 20-25 seconds
#3 EZ Zahn 10-13 seconds

NOTE: Heat shortens pot life of this material.

Additives:



N/A

Spray Gun Setup:

HVLP

COMPLIANT



Fluid Tip	1.3 - 1.7 mm or equivalent	1.3 - 1.7 mm or equivalent
Air Pressure	8-10 PSI at the air cap	50-60 PSI at the spray gun

Pressure Pot Setup: Starting setup, adjust from here for best results

HVLP

COMPLIANT



Fluid Tip	1.2-1.4 mm	1.2-1.4 mm
	10 PSI at the air cap	45-60 PSI at the spray gun

Fluid Delivery	10-14 fluid ounces per minute	10-14 fluid ounces per minute
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Number of Coats:



2 - 3 coats

Film Build:

Wet Film
(per coat)

Dry Film
(total)

Minimum	1.5 mils	3.0 mils
Maximum	3.0 mils	4.5 mils

Flash Time:



Between coats

5 – 10 minutes
@ 70°F (21°C)

Dry Times:



To Touch:

5-10 minutes @70°F (21°C)



To Handle:

20-30 minutes @70°F (21°C)



To Tape:

2-4 hours @ 70°F (21°C)



To Sand:

1.5 – 3 hours
Sanding times are dependent on the activator used.

Air Dry:
Force Dry:

16 hours in service
30 minutes @140°F (60°C)

To Recoat /
Topcoat:

30 minutes to 72 hours
before sanding @ 70°F (21°C)

Final coat of ESU440 must be sanded before topcoating.

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.

Application Guide (continued)

Test Properties:

VOC RTS Applied (less exempts)	3.49 lbs. per U.S. gallon
Volume Solids (RTS)	38.97%
VOC per Gallon of Coatings Solids	6.68 lbs.
Square Foot Coverage (RTS US Gal 100% Transfer Efficiency)	625 sq. ft. @ 1 mil

Health and Safety:

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.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.

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