

### 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

### Number of Coats:



2 - 3 coats

### Film Build:

Minimum  
Maximum

**Wet Film**  
(per coat)

1.5 mils  
3.0 mils

**Dry Film**  
(total)

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)

### 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  
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

*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.

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**Application Guide (continued)**

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**Test Properties:**

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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

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**Health and Safety:**

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

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

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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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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