

Epoxy Primer

ESU430

DELFLREET ESSENTIAL[®] ESU430 Epoxy Primer is an all-purpose epoxy undercoat that provides excellent adhesion and corrosion resistance when used over properly prepared metal surfaces.

Additional Products

- Hardener ESU439

Compatible Surfaces

ESU430 may be applied over:

- Properly prepared steel
- Properly prepared aluminum
- Properly prepared galvanized metal
- Properly prepared fiberglass
- Properly prepared OE Enamel Finishes

Surface preparation

When sanding bare metal prior to application of ESU430, use 80 grit (stainless steel) or 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry.

Always use fresh sandpaper and thoroughly clean all substrates after sanding.

Aluminum, stainless steel and carbon steel must be primed immediately after cleaning and sanding.

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 before priming, then re-clean with CFX435LV or CFX436 cleaner.



- Prime all substrates immediately after cleaning.

Mixing Ratio:



Let mixed product digest 15 minutes before using. Stir thoroughly before and occasionally during use.

1 : ESU430

1 : ESU439

Pot Life:



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

72 hours after mixing at 70°F (21°C) Mix only enough material that can be used in 72 hours.

NOTE: Heat shortens pot life of this material.

Spray Viscosity:



#2 EZ Zahn: 20 – 25 sec

Additives:



N/A

Spray Gun Setup:

HVLP

CONVENTIONAL



Fluid Tip	1.2 - 1.4 mm or equivalent	1.4 - 1.6 mm or equivalent
Air Pressure	8-10 PSI at the air cap	40-50 PSI at spray gun
or per MFG recommendation		

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

HVLP

CONVENTIONAL



Fluid Tip	1.0 - 1.4 mm	1.0 - 1.4 mm
Fluid Delivery	10 - 12 fluid ounces per minute	10 - 12 fluid ounces per minute

Number of Coats:



1 - 2 coats

Film Build:	Wet Film (per coat)	Dry Film (total)
Minimum	3.5 – 4.0 mils	1.0 mils
Maximum		1.5 mils

Flash Time:



Between coats 10 – 15 minutes @ 70°F (21°C)

Dry Times:



To Touch: 15 minutes Air Dry@70°F (21°C)



To Handle: 45 minutes@70°F (21°C)

To Tape: 1-1.5 hours@70°F (21°C)



Force Dry: 30 minutes@140°F (60°C)



To Recoat / Minimum 1 hour@70°F (21°C)
Topcoat: Maximum 4 days@70°F (21°C)

After 4 days sand ESU430 with 400 grit (wet or dry) and re-apply 1 coat of ESU430 before proceeding to the next undercoat or topcoat.

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.

Test Properties:

Color	Gray
VOC RTS Applied (less exemptions)	5.41 lbs per U.S. gallon
Volume Solids (RTS)	23% - 24%

Theoretical Coverage:

Sq. Ft. /US gal. Ready-to-spray (RTS), giving 1mil. (25µm) dry film thickness (assuming 100% Transfer Efficiency)	372 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 (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; IN MEXICO 01-800-00-21-400

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