

4.6 VOC Epoxy Primers

ESU460 – Gray

ESU461 – White

ESU462 – Black

DELFLLEET ESSENTIAL® 4.6 Epoxy Primer ESU460, ESU461 and ESU462 are two component, non-chrome epoxy primers designed to provide superior corrosion protection and adhesion when applied over properly cleaned and sanded bare metal, fiberglass and painted surfaces.

Additional Products

- 4.6 Epoxy Primer Hardener ESU469

Compatible Surfaces

ESU460, ESU461 and ESU462 may be applied over:

- Properly prepared steel
- Properly prepared aluminum
- Properly prepared galvanized
- Properly prepared fiberglass
- Properly prepared OE enamel finishes

If sanding bare metal prior to application of ESU460, ESU461 or ESU462/ESU469, use 180-240 grit wet or dry. Sand old finishes with 320-400 grit wet or dry.

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, then clean with CFX435LV, CFX436 or CFX437 cleaner.



- Sand substrates, then re-clean with CFX435LV or CFX436 cleaner.

- Prime all substrates immediately after cleaning.

Mixing Ratio:



2 : ESU460, ESU461 or ESU462
1 : ESU469

Pot Life:



Mix only enough material that can be used in 6 – 8 hours. Allow a 15 minute induction period before applying..

8 hours after mixing @ 70°F (21°C)/50% RH.

NOTE: Heat shortens pot life of this material.

Spray Viscosity:



#2 EZ-Zahn 22 – 28 seconds

Additives:



Acetone may be added up to 10% to RTS ESU460, ESU461 or ESU462

Spray Gun Setup:

HVLP

CONVENTIONAL



Fluid Tip	1.3- 1.6 mm or equivalent	1.3 - 1.6 mm or equivalent
Air Pressure	8-10 PSI at the air cap max	40-50 PSI at the gun

Consult the Fleet Training Manual Spray Equipment section for additional gun set-up requirements.

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	2.8 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 @ 70°F (21°C)



To Handle: 30 minutes @ 70°F (21°C)



To Tape: 6 hours @ 70°F (21°C)



Flash prior
to Bake: 5 - 10 minutes @ 70°F (21°C)

Force Dry: 30 minutes @140°F (60°C)

Overcoat/
Topcoat: Minimum:15 minutes
Maximum:72 hours
@ 70°F (21°C)

After 3 days, sand ESU460, ESU461 or ESU462 with 400 grit (wet or dry) 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	ESU460 Gray ESU461 White ESU462 Black
VOC RTS Applied	4.54 lbs/gal (544 g/L)
VOC per Gallon of Coatings Solids (RTS)	12.45 - 12.55 lbs/gal (1492 -1504 g/l)
Volume Solids (RTS)	36.0 - 36.3%
Square Foot Coverage (RTS US Gal 100% Transfer Efficiency)	577 - 583 sq. ft./gal. @ 1 mil dry, no loss

Health and Safety - Improper handling & application of products could impact product safety and performance. Read the product label and MSDS before use.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and not to be construed as representations or warranties as to performance, results or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.



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