

### 4.6 Epoxy Primer

# ESU460 – Gray ESU461 – White

ESU460 and ESU461 are two-component, non-chrome epoxies designed to provide superior corrosion protection and adhesion when applied over properly cleaned and sanded bare metal, fiberglass and painted surfaces.

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#### Additional Products

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- 4.6 Epoxy Primer Hardener ESU469

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#### Compatible Surfaces

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ESU460 and ESU461 may be applied over:

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

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

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#### Selection of Substrate Cleaner

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Code	Product	Purpose
DX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process.
DX437	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 DX436 or DX437 wax and grease remover.



- Sand substrates, then reclean with DX436 or DX437.



- Prime aluminum, stainless and carbon steel immediately after cleaning.

### Mixing Ratio:



2 : ESU460 or ESU461  
1 : ESU469

### Pot Life:



8 hours after mixing @ 70°F (21°C).  
Allow a 15 minute induction period before applying.

**NOTE:** Heat shortens pot life of this material.

### Additives:



Acetone may be added up to 10% to RTS ESU460 and ESU461.

### 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	40 – 50 PSI at spray gun

### Number of Coats:



1 – 2 coats

### Total Film Build:

	Wet	Dry
Minimum	2.8 mils	1.0 mils
Maximum	4.2 mils	1.5 mils

### Flash Times:



Between coats 10 – 15 minutes

### Dry Times:



To Touch:	15 minutes @ 70°F (21°C)
To Handle:	30 minutes @ 70°F (21°C)
Air Dry:	1 coat = 15 minutes 2 coats = 30 minutes
Force Dry:	30 minutes @ 140°F (60°C)
To Topcoat:	15 minutes @ 70°F (21°C)

ESU460 and ESU461 **must** be scuffed and re-applied if allowed to sit more than three days (72 hours).

**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:

VOC RTS Applied	4.60 lbs / gal. (551 g / l) Maximum
VOC per Gallon of Coatings Solids	12.53 – 12.61 lbs / gal. (1501 – 1511 g / l)
Volume Solids (RTS)	36.0% – 36.5%
Film Build Per Coat	1.0 mil
Square Foot Coverage @ 1 mil	563 – 583 sq. ft. / gal., no loss

## Health and Safety

Please refer to Material Safety Data Sheets (MSDS) for full health safety details and storage regulations.

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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