

2.1/2.8 Polyurethane Primer

ESU410

ESU410 is a heavy metal-free polyurethane primer. It is gray in color and provides excellent adhesion over a wide variety of substrates. The VOC of ESU410 can be 2.1 or 2.8 depending on solvent choice.

Additional Products

- Hardener for ESU410 ESU419
- Accelerator for ESU410 ESX590

Compatible Surfaces

ESU410 may be applied over:

- Properly prepared steel
- Properly prepared aluminum
- Properly prepared galvanized steel
- Properly prepared fiberglass
- Properly prepared OE Enamel Finishes
- ESU400

If sanding bare metal prior to application of ESU410, use 180 – 220 grit wet or dry. Sand old finishes with 280 – 400 grit wet or dry.

Selection of Substrate Cleaner

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.
DX438	Compliant Cleaner	For use removing dirt, grease and other contaminants in VOC regulated areas.

Application Guide

Preparation:



- Wash the area to be painted with soap and water, and then clean with DX436 or DX437 wax and grease remover. DX438 Low VOC Cleaner should be used in VOC restricted areas.

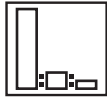


- Sand substrates, then re-clean with DX436, DX437, and DX438.



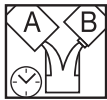
- Prime aluminum and carbon steel immediately after cleaning.

Mixing Ratio:



5 : ESU410
1 : ESU419
6 oz. per RTS gal. : ESX590

Pot Life:



Pot life of this product is 1.5 – 2 hours at 75°F thinned 10% by volume with acetone. Additional acetone may be added for longer pot life. Do not exceed 25% acetone reduction by volume in non-VOC regulated areas.

Additives:



May be reduced up to 25% with Acetone where VOC regulations allow.

*ESX590 Accelerator must be added at 6 oz. per RTS gal.

Total Film Build:	Wet	Dry
Minimum	1.8 mils	1.0 mils
Maximum	2.3 mils per coat	1.3 mils total DFT

Spray Gun Setup:



	HVLP	Conventional
Fluid Tip	1.2 – 1.4 mm or equivalent	1.4 – 1.8 mm
Air Pressure at the cap	10 PSI	55 – 65 PSI at spray gun

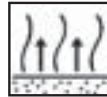
Consult the Fleet Training Manual Spray Equipment section for gun setup requirements.

Minimum Number of Coats:



1 – 2 coats

Flash Time at 70°F (21°C):



Between coats 10 – 15 minutes

Dry Times:



To Touch: 45 minutes Air Dry at 70°F (21°C)
To Handle: 2 hours
Dry: 8 hours
Force Dry: 20 minutes at 140°F (60°C)
To Topcoat: 1 hour at 70°F (21°C)

After 4 days, sand ESU410 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	Gray
Packaged	2.1 lbs. per U.S. gal. max in acetone exempt areas and 2.8 VOC in non-exempt areas.
VOC RTS Applied	2.1 lbs. per U.S. gal. max in acetone exempt areas and 2.8 VOC in non-exempt areas.
Volume Solids (RTS)	64.5% – 66.5%
Square Foot Coverage	922 – 954 sq. ft. at 1 mil applied 5:1:6 oz./RTS gallon
(RTS U.S. gal. 100% Transfer Efficiency)	

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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