

Epoxy Primer

ESU430

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 for ESU430 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

If sanding bare metal prior to application of ESU430, use 220 – 240 grit wet or dry. Sand old finishes with 320 – 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.



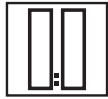
- Sand then re-clean with DX436, DX437, and DX438.



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

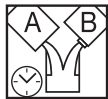
Let mixed product digest 15 minutes before using. Stir thoroughly before and occasionally during use.

Mixing Ratio:



1 : ESU430
1 : ESU439

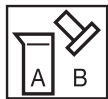
Pot Life:



72 hours after mixing at 77°F (25°C). Mix only enough material that can be used in 72 hours.

NOTE: Heat shortens pot life of this material.

Additives:



N/A

Spray Gun Setup:



	HVLP	Conventional
Fluid Tip	1.2 – 1.4 mm	1.4 – 1.6 mm
Air Pressure	8 – 10 PSI at the cap	40 – 50 PSI at spray gun

Minimum Number of Coats:

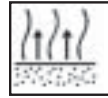


1 – 2 coats

Total Film Build:

	Wet	Dry
Minimum	4.0 mils	1.0 mils
Maximum	6.0 mils	1.5 mils

Flash Time at 70°F (21°C):



Between coats 10 – 15 minutes

Dry Times:



To Touch: 15 minutes Air Dry at 70°F (21°C)
To Handle: 45 minutes
Dry: 4 hours
Force Dry: 30 minutes at 140°F (60°C)
To Topcoat: 1 hour at 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	5.41 lbs. per U.S. gal.
Volume Solids (RTS)	23% – 24%
Square Foot Coverage	372 sq. ft. at 1 mil
(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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