

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.

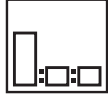


- Sand substrates, then re-clean with DX436, DX437 or DX438.



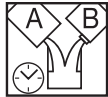
- Prime aluminum, stainless and carbon steel immediately after cleaning.

Mixing Ratio:



3 : ESU420/ESU421
1 : ESU429
1 : ESR300/ESR310

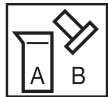
Pot Life:



6 – 8 hours after mixing at 77°F (25°C).
Mix only enough material that can be used in 6 – 8 hours.

NOTE: Heat shortens pot life of this material.

Additives:



N/A

Spray Gun Setup:



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

Number of Coats:

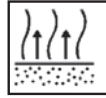


1 – 2 coats

Total Film Build:

	Wet	Dry
Minimum	3.5 mils	1.2 mils
Maximum	5.5 mils	2.0 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: 30 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 ESU420/ESU421 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	ESU420 White ESU421 Gray
VOC RTS Applied	Maximum 3.50 lbs. per U.S. gal.
VOC per gal. of Coatings Solids	6.64 lbs.
Volume Solids (RTS)	35.5% – 37.5%
Square Foot Coverage (RTS U.S. gal. 100% Transfer Efficiency)	470 – 480 sq. ft. @ 1 mil

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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