



Epoxy Primer

EPX Series

CPC 7

Component A

- EPX-900 Beige Epoxy Primer
- EPX-904 Gray Epoxy Primer
- EPX-908 Black Epoxy Primer
- EPX-950 White Epoxy Primer

Component B

- EPX-901 Epoxy Primer Catalyst

RECOMMENDED USE		SURFACE PREPARATION	
EPX Series are all purpose Epoxy Primers that creates a superior corrosion resistant undercoating with excellent adhesion properties when used on properly prepared metal surfaces. It exhibits excellent corrosion resistance and adhesion when applied over properly prepared steel, galvanized steel, aluminum and fiberglass.		The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat.	
		Metal	Recommended Topcoat
			Direct To Properly Treated Substrate
		Cold Rolled Steel	ACR-100, ALK-200, ALK-200/201, AUE-100, AUE-100LG, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG, ALK-300, ALK-300-LG
		Hot Rolled Steel	ACR-100, ALK-200, ALK-200/201, AUE-100, AUE-100LG, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG, ALK-300, ALK-300-LG
		Galvanized	ACR-100, ALK-200, ALK-200/201, AUE-100, AUE-100LG, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG, ALK-300, ALK-300-LG
		Galvaneal	ACR-100, ALK-200, ALK-200/201, AUE-100, AUE-100LG, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG, ALK-300, ALK-300-LG
		Aluminum	ACR-100, ALK-200, ALK-200/201, AUE-100, AUE-100LG, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-400LG, ALK-300, ALK-300-LG
		Plastic / Fiberglass	Surface should be free of all contamination. Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic/fiberglass substrate being used.
		Note: For any substrate, surface preparation, application method or environment not listed in PPG's product literature, the user should trial the product to evaluate the adhesion.	
PHYSICAL CONSTANTS			
Mixed Voc (Varies by color)	5.40-5.60 lbs/gal		
Percent Solids By Weight (Varies by Color)	EPX-900 35 - 39% EPX-904 35 - 39% EPX-908 32 - 36% EPX-950 35 - 39%		
Percent Solids By Volume (Varies By Color)	EPX-900 21 - 25% EPX-904 21 - 25% EPX-908 21 - 25% EPX-950 21 - 25%		
Weight Per U.S. Gallon (Varies By Color)	EPX-900 8.60 - 8.80 EPX-904 8.55 - 8.75 EPX-908 8.15 - 8.35 EPX-950 8.60 - 8.80		
Flash Points (Pensky-Martens)	EPX-900 Pensky-Martens 30°F(-1°C) EPX-904 Pensky-Martens 30°F(-1°C) EPX-908 Pensky-Martens 30°F(-1°C) EPX-950 Pensky-Martens 30°F(-1°C) EPX-901 Pensky-Martens 40°F(4°C)		
Ready To Spray Viscosity (Varies By Color)	#3 Zahn = N/A #2 Zahn = 15 – 25 seconds		
PERFORMANCE FEATURES			
Adhesion	Excellent		
96 Hour Humidity Resistance	Excellent		
In Service Temperature Limitations	300°F		
Water Resistance	Although resistant to intermittent exposure, <i>not recommended for immersion.</i>		
CHEMICAL/SOLVENT RESISTANCE			
10% Sulfuric Acid	Excellent		
10% Ammonia	Excellent		
Xylene	Excellent		
Oil	Excellent		
500 Hours Salt Spray	Excellent		
10% Hydrochloric Acid	Excellent		
10% Sodium Hydroxide	Excellent		
Isopropyl Alcohol	Excellent		
Gasoline	Excellent		

APPLICATION DATA	SAFETY											
<p>Mixing Directions Stir thoroughly before and occasionally during use. Mix equal parts of EPX Series component A with equal parts of EPX-901 component B by volume. Allow 30 minutes induction period to obtain maximum performance properties.</p>	<p>These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public. Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.</p>											
<p>Thinning N/A</p>												
<p>Pot life 72 hours after mixing @ 77°F (25°C). Mix only enough material that can be used in 72 hours. Note: Heat shortens pot life of this material.</p>												
<p>Application Equipment Conventional spray: 50 psi at the gun.</p>												
<p>Drying Times* (4 mils wet @ 77°F(25°C) and 50% relative humidity)</p> <table border="1" data-bbox="212 667 834 926"> <tr> <td>To Touch:</td> <td>15 minutes</td> </tr> <tr> <td>To Handle:</td> <td>45 minutes</td> </tr> <tr> <td>To Dry:</td> <td>4 hours*</td> </tr> <tr> <td>To Topcoat:</td> <td>1 hour to 4 days</td> </tr> <tr> <td>Recoat:</td> <td>After 1 hour, or before 4 days. After 4 days the primer should be mechanically abraded before topcoating or recoating.</td> </tr> <tr> <td>Force Dry:</td> <td>30 minutes @ 140°F(82°C) (Allow 10 minutes air dry)</td> </tr> </table>		To Touch:	15 minutes	To Handle:	45 minutes	To Dry:	4 hours*	To Topcoat:	1 hour to 4 days	Recoat:	After 1 hour, or before 4 days. After 4 days the primer should be mechanically abraded before topcoating or recoating.	Force Dry:
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<p>* This condition does not mean that the paint film has reached full cure. Paint film is not fully cured for 7 days. It is a stage where handling can be achieved without loosening, wrinkling or otherwise marring the film under minimal pressure from fingers or hands.</p> <p>Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.</p>	<p>Precautionary Information Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. KEEP OUT OF THE REACH OF CHILDREN</p>											
<table border="1" data-bbox="191 1125 834 1241"> <tr> <td><i>Recommended Wet Film Build (Unreduced):</i></td> <td>4.0 – 6.0 mils</td> </tr> <tr> <td><i>Recommended Dry Film Build:</i></td> <td>1.0-1.5 mils</td> </tr> </table>		<i>Recommended Wet Film Build (Unreduced):</i>	4.0 – 6.0 mils	<i>Recommended Dry Film Build:</i>	1.0-1.5 mils	<p>Medical Response Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645 - 1320 Have label information available.</p>						
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<p>Film in excess or below these recommended film builds may cause problems such as, adhesion failure, pigment floatation, solvent popping, slow cure, and accelerated gloss and color failure.</p>	<p>Material Safety Data Sheet Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.</p>											
<p>Recommended Spreading Rate 356-380 sq. ft. @ 1.0 mil dry film per U.S. gallon (varies by color). Coverage figures do not include losses due to mixing, transfer or application of coating or losses due to surface irregularities or porosity.</p>		<p>To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.</p>										
<p>Clean Up PPG Urethane Thinner, MEK or xylene.</p>												
<p>Application Precautions and Limitations Apply only when air, product or surface temperature is above 60°F (16°C) and when surface temperature is at least 5°F (3°C) above the dew point. Brush and roller application is not recommended.</p>												

