General Industrial Coatings

Catalyzed Epoxy Primer (Part A)
2.8 Lbs./Gal. VOC

Black.....E61B283

DESCRIPTION

E61B283 is a high solids, high performance epoxy-polyamide primer.

Advantages:

- No induction time
- Fast dry time
- Excellent salt spray resistance
- Corrosion inhibitive pigments
- Complies with 2.8 *VOC solvent emissions
- Free of lead chromate hazards

* VOC Compliance limits vary from state to state; please consult local Air Quality rules and regulations.

An Environmental Data Sheet is available from your local Sherwin-Williams facility or at www.PaintDocs.Com.

CHARACTERISTICS

60° Gloss: 5 ± 20

Volume Solids:

E61B283 – Part A	69.08 ± 2 %
V66V282 – Part B	39.88 ± 2 %

Viscosity (at 77° F, Zahn cup Signature Series)**:**

E61B283 – Part A	25-35 secs., #3 Zahn Cup
Admixed	25-30 secs, #3 Zahn Cup

Recommended Film Thickness:

Mils Wet	2.8-3.5
Mils Dry	1.8-2.2

Spreading Rate (no application loss)**:**
445-561 ft.^{2}/gal. at 1.8-2.2 mils DFT

Cure: Rate of cure is determined by Pencil Hardness method (ASTM D3363-92a) at 2.0 mils DFT, 50% RH.

16 hours	2B
24 hours	HB
40 hours	3H
144 hours	5H
Ultimate	6H

Time will vary due to various parameters such as mass of substrate, type of oven, etc. Coating must be tack free to topcoat for maximum holdout. Test substrate was standard Q-Steel panels, 0.032" x 6" x 12" (0.8 x 152 x 305 mm).

Drying: 2.0 mils at 70° F, 50% RH (ASTM D1640)

To Touch	60-90 minutes
Tack Free	2.5-3.5 hours
To Hard	6-8 hours
To Topcoat	1 hour

Film must be set up before topcoat is applied. Use the drying schedule as a guide for testing. Allow at least a 5-minute flash-off time.

Flash Point (Pensky Martens Closed Cup)**:**

E61B283 – Part A	76° F
V66V282 – Part B	63° F
Admixed	63° F

Mixing Ratio (by volume)**:**

E61B283 - Part A	4 Parts
V66V282 - Part B	1 Part

Potlife: 4 hours

Air Quality Data:
Volatile Organic Compounds (VOC)
(admixed, maximum) 2.36 lb/gal, 283 g/L

Recommended Storage: Inside, sealed container, 40-120° F, no freeze hazard. Protect from moisture.

Package Life: 1 year, unopened

SPECIFICATIONS

General: All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance. Consult Metal Preparation brochure CC-T1 for additional details.

Aluminum: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.

Galvanized Steel: If untreated, prime with RoHS Compliant Wash Primer, P60G10 or Industrial Wash Primer, P60G2.

Steel or Iron: Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility and performance prior to full scale application.

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APPLICATION

Typical Setups

Reduction: Product may be reduced by 4%. If reduction is needed to optimize application, R6K10 (MEK), R6KCV34 (MIBK), R6K18 (N-Butyl Acetate), or similar solvent can be used.

May be applied by:	Conventional
	Airless
	Air Assisted Airless
	Electrostatic
	HVLP
Conventional Spray:	
Air Pressure	45-65 psi
Airless Spray:	
Pump	28 to 1
Tip	411
Air Pressure	2300-2700 psi
Air Assisted Airless Spray:	
Pump	10 to 1
Tip	411
Atomizing Air	65 psi
Electrostatic Spray:	
Mixed Paint	0.7-0.9 megaohms
HVLP Spray:	
Air Pressure	50-80 psi

Air surface temperature range is 60-100° F. Surface temperature must be at least 5° F above the dew point. Do not apply in fog, rain, or condensing humidity.

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

Cleanup: Clean tools/equipment immediately after use with R6KCV34 (MIBK), R6K10 (MEK), or any or other epoxy reducing solvent.

Follow manufacturer's safety recommendations when using any solvent.

ADDITIONAL INFORMATION

1. Coating performance is based on the degree of surface preparation. The better the preparation, the better the resulting performance.
2. Degrease surface prior to cleaning. Organic solvents, alkaline solutions, steam, hot water with detergents or other systems that will completely remove surface contamination may be used.
3. Remove all loose mill scale, rusting and old coatings before new coating is applied. Typically brush off blast cleaning and power tool cleaning will accomplish this.
4. Coat with primer as soon as possible after surface preparation. If the time exceeds 24 hours between cleaning and coating, the surface must be inspected for rusting or re-cleaned.

CAUTIONS

FOR INDUSTRIAL SHOP APPLICATION ONLY

Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please visit your local Sherwin-Williams facility or www.PaintDocs.Com.

Please direct any questions or comments to your local Sherwin-Williams facility.

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