

2.1 VOC Wet on Wet Epoxy Primer – Gray

ESU470

DELFLLEET ESSENTIAL[®] ESU470 is a low VOC, non-sanding epoxy primer with a smooth finish. It offers exceptional time to topcoat for high productivity shops looking for the corrosion protection expected of an epoxy and very fast dry times needed for repairs.

Additional Products

- 2.1 VOC Epoxy ESU470
- Hardener ESU479
- Fast Reducer ESR300
- Medium Reducer ESR310

Compatible Surfaces

ESU470 may be applied over:

- Properly prepared steel
- Properly prepared aluminum
- Properly prepared fiberglass
- Properly prepared OE enamel finishes

If sanding bare metal prior to application of ESU470, use 120-180 grit (steel and aluminum). Sand old finishes with 220-320 grit wet or dry. Always use fresh sandpaper and thoroughly clean all substrates after sanding. Aluminum and carbon steel must be primed immediately after cleaning and sanding.

Selection Of Substrate Cleaner - ONECHOICE[®] Commercial CFX Cleaners

Code	Product	Purpose
CFX435LV	Low VOC Cleaner	Compliant cleaner suitable for removing dirt, grease or other contaminants before or during the painting process
CFX436	Wax & Grease Remover	Suitable for removing dirt, grease or other contaminants before or during the painting process
CFX437	Heavy Duty Wax & Grease Remover	Used to remove heavy milling oils and grease from bare substrates prior to the painting process



Application Guide

Preparation:



- Wash the area to be painted with soap and water, and then clean with CFX436 or CFX437 wax and grease remover.



- Sand substrates with 120 – 180 grit on bare metal and 220 – 320 grit on old finishes and body filler, then re-clean with CFX435LV or CFX436 cleaner.

- Prime all substrates immediately after cleaning.

Number of Coats:



1-2 coats

Film Build:

	Wet Film (per coat)	Dry Film (total)
Minimum	2.5 mils	1.1 mils
Maximum	5.0 mils	2.5 mils

Mixing Ratio:



2 : ESU470
1 : ESU479
1-2 : ESR300/ESR310

Flash Time:



Between coats 10-15 minutes
@ 70°F (21°C)

Pot Life:



Pot life of this product is variable depending on temperature and on activator choice.

6-8 hours after mixing @ 70°F (21°C)/50% RH

NOTE: Heat shortens pot life of this material.

Dry Times:



To Touch: 15 minutes @ 70°F (21°C)



To Handle: 90 minutes @70°F (21°C)



To Tape: 4 hours @ 70°F (21°C)



Flash prior to Bake: 10-15 minutes @ 70°F (21°C)

Force Dry: 30 minutes @140°F (60°C)

Overcoat/ Topcoat: 30-45 minutes @ 70°F (21°C)

Spray Viscosity:



#2 EZ-Zahn 20-30 seconds

Additives:



N/A

Spray Gun Setup:

HVLP

COMPLIANT



Fluid Tip	1.3 – 1.6 mm or equivalent	1.3 – 1.6 mm or equivalent
Air Pressure	8-10 PSI at the air cap max	40-50 PSI at the gun

Consult the Fleet Training Manual Spray Equipment section for additional gun set-up requirements.

Pressure Pot Setup: Starting setup, adjust from here for best results

HVLP

COMPLIANT



Fluid Tip	1.1 – 1.3 mm	1.1 – 1.3 mm
Fluid Delivery	10 – 12 fluid ounces per minute	10 – 12 fluid ounces per minute

Test Properties:

VOC RTS Applied	2.07 lbs. Per US Gallon
VOC per Gallon of Coatings Solids	2.94 lbs.
Volume Solids (RTS)	32.42% – 40.52%
Square Foot Coverage (RTS US Gal 100% Transfer Efficiency) 2:1:1 mix ratio	651 sq. ft. @ 1 mil dry

After 4 days, sand ESU470 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.

Application Guide (continued)

RTS Combinations:	ESU470	ESU470 : ESU479 : ESR3XX :	ESU470 : ESU479 : ESR3XX
Volume Ratio	As Is	2 : 1 : 1	2 : 1 : 2
Applicable Use Category	Primer	Primer	Primer
VOC Actual	154 (g/L)	144 (g/L)	115 (g/L)
VOC Actual	1.29 (lbs/gal)	1.20 (lbs/gal)	0.96 (lbs/gal)
VOC Regulatory (less water less exempt)	203 (g/L)	247 (g/L)	247 (g/L)
VOC Regulatory (less water less exempt)	1.69 (lbs/gal)	2.06 (lbs/gal)	2.06 (lbs/gal)
Density	1493 (g/L)	1274 – 1309 (g/L)	1232 – 1287 (g/L)
Density	12.46 (lbs/gal)	10.63 – 10.92 (lbs/gal)	10.28 – 10.74 (lbs/gal)
Volatiles wt.	27.6 %	47.7 – 49.1 %	56.7 – 58.6 %
Water wt.	0.2 %	0.1 – 0.2 %	0.1 – 0.2 %
Exempt wt.	17.0 %	36.3 – 38.0 %	47.3 – 49.6 %
Water vol.	0.3 %	0.2 %	0.2 %
Exempt vol.	23.5 %	41.8 %	53.4 %

Health and Safety:

Safety Data Sheets (SDS) for the PPG products mentioned in this publication are available through www.ppgcommercialcoatings.com (Safety, SDS Search) or your PPG Distributor.

For additional information regarding this product, see the SDS and LABEL information.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514) 645-1320 AND IN MEXICO 01-800-00-21-400.

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