



2.1 VOC Epoxy Primers

274528SP/01 Gray
 274530SP/01 White
 274531SP/01 Black

Matthews 2.1 VOC Epoxy Primers are corrosion resistant primers that provide excellent adhesion to many types of substrates, including stainless steel, and can also be used in areas where a maximum 2.1 VOC is required.

Packaged in Gray, White, and Black, primers can be mixed together to achieve shades from light gray to dark gray.



Features:

Low VOC technology	Environmentally friendly, meets 2.1 VOC regulations
Chromate-free	Meets EPA regulations for chromate restrictions
Available in Black, White, and Gray	Combine together for any shade of gray
Topcoat with any Matthews Acrylic Polyurethane finishes	Versatile, multi-purpose
Compatible over various substrates, including stainless steel	For multiple applications, fewer products to stock
Brush and roll capability	For use in areas where air spraying is prohibited
Epoxy technology	Excellent corrosion resistance, superior adhesion to substrate
Excellent filling properties	Capable of hiding minor metal substrate defects
Easy mix ratio	Less time mixing
Four day topcoat window	No sanding required prior to topcoating within window

Benefits:

Compatible Surfaces:

2.1 VOC Epoxy Primers may be applied over properly prepared:

Steel	Galvanized steel	Body filler
Stainless steel	Aluminum	Masonry
Blasted steel	Fiberglass	Wood
Carbon steel	Previously painted surfaces	

Associated Products:

Catalyst

274529SP/04 2.1 VOC Epoxy Hardener

274528SP/01 Gray, 274530SP/01 White, 274531SP/01 Black

Directions for Use

Surface Preparation: Substrate should be prepared according to Matthews Substrate Preparation Guide prior to primer application.

Mix Ratio:



Mix Ratio for Spraying (by volume)
 274528SP/01 / Gray
 274530SP/01 / White
 274531SP/01 / Black 274529SP/04

4 parts 1 part

- All components should be mixed thoroughly before using
- Strain material after mixing



Pot Life: 4 hours
 Pot-life is the amount of time before spray viscosity doubles. These are estimates based on lab results at 50% relative humidity, 70°F/21°C—results will vary based on application conditions, reducer selection, and accelerator choice.
 Note: mix no more product than can be used within pot life.

Additives:



None

Spray Set Up:



Air Pressure:	Conventional:	40 - 50 psi at the gun*
	HVLP:	10 psi at the cap*

* Refer to spray gun manufacturer recommendations for inlet pressure.



Pressure Pot Fluid Delivery:	8 - 12 Fluid Ounces per Minute
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Gun Set Up:	Siphon Feed:	1.3 - 1.5 mm 0.051 - 0.059 fluid tip
	HVLP:	1.3 - 1.5 mm 0.051 - 0.059 fluid tip
	Pressure Pot:	1.0 - 1.2 mm 0.039 - 0.047 fluid tip

Directions for Use

Application:



Apply:

Apply one to two full wet coats, allowing proper flash time* between coats.
 Apply additional coats as necessary to achieve total dry film thickness.
 *Flash times will vary dependent upon film thickness, temperature, solvent selection, spray gun set-up, application, etc.

Recommended	One Coat	Two Coat
Film Thickness:	Application	Application
	Wet Film Thickness (WFT) 2 - 3 mils	4 - 6 mils
	Dry Film Thickness (DFT) 1 - 1.5 mils (minimum)	2 - 3 mils

Caution: All 2-component crosslinking slows significantly at temperatures below 60°F or 16°C. Never spray or subject freshly painted coatings to these conditions or loss of gloss, decreased durability and improper curing can occur.

Estimated Drying Times:



Air-Dry @ 50% Relative Humidity, 70°F/21°C
 Dust Free 15 - 20 minutes
 Dry to Touch 20 - 30 minutes
 Dry to Handle 30 - 45 minutes
 Dry to Topcoat 30 minutes - 4 days (max)*

*After 4 days, sand with a 220-400 grit dry, or equivalent sanding pad. Do not sand below minimum dry film thickness, otherwise reprime before topcoating.

Equipment Cleaning:

Clean equipment promptly with lacquer thinner or equivalent cleaning solvent.
Note: Do not leave mixed material in equipment.

Technical Data:

VOC Information

VOC Actual RTS	1.28 - 1.29 lbs/gal
VOC Actual RTS	153 - 154 g/L
VOC Regulatory (less water less exempt) RTS	2.09 - 2.1 lbs/gal
VOC Regulatory (less water less exempt) RTS	250 g/L

For complete VOC information, visit MatthewsPaint.com > Quick Links > VOC Data

Performance Characteristics

Volume solids (RTS)	43.7%
Theoretical Coverage (1 mil @ 100% transfer efficiency)	702 sq.ft./RTS gal
Application Conditions - Temperature	60°F (16°C) Minimum 100°F (38°C) Maximum
Application Conditions - Relative Humidity	85% maximum 5° above dew point

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Important: The contents of this package may have to be blended with other components before the product can be used. Before opening the packages, be sure you understand the warning messages on the labels of all components, since the mixture will have the hazards of all its parts. Improper spray technique may result in a hazardous condition. Follow spray equipment manufacturer's instructions to prevent personal injury or fire. Follow directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

See Safety Data Sheet and Labels for additional safety information and handling instructions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION - US (412) 434-4515; CANADA (514) 645-1320; Mexico 01-800-00-21-400
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