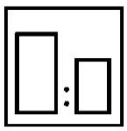
E380 and E381 Epoxy Primer

FOR PROFESSIONAL USE ONLY

Description

E380 is a high solids 3.5 VOC epoxy primer/sealer, which provides excellent filling over sand blasted metals. E380 dries fast while still maintaining good hold out and a smooth finish. E380 has a ready to spray VOC < 3.5 lbs/gal.



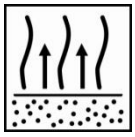
4	E380 Epoxy Primer Grey or E381 Epoxy Primer Black
1	E385 Epoxy Hardener

Use AkzoNobel Measuring Stick

109

Spray gun setup:			Check gun manufacture specification
RP – Pressure Feed	1.4 – 1.7mm	30 – 36psi	12 – 16 oz/min
HVLP – Pressure	1.2 – 2.0mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.5 – 1.9mm	Max 10psi (cap)	

Apply one (1) to three (3) single flowing coats



Between coats	Wet-on-wet with Topcoat
15 min at 70°F (21°C)	1 hour at 70°F (21°C) – one coat

	70°F (21°C)	140°F (60°C)
Dry to recoat (wet-on-wet)	1 hr	N.A.
Dry to sand	7 hrs	2 hrs

Use suitable respiratory protection
AkzoNobel recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

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Suitable Surfaces

Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry
Any premium polyester bodyfiller sanded with #P180 to #P220 grit dry
Aluminum after it has been properly treated with the appropriate aluminum cleaner and pre-
Steel, degreased and sanded with #P80 then #P120 grit dry.
Blasted steel
Fiberglass gelcoat (unbroken), degreased and sanded with #P220 to #P320 grit dry

Existing finishes	#P220 to #P320 grit dry
Polyester bodyfiller	#P180 to #P220 grit dry
Aluminum (Alodine)	#P180 to #P220 grit dry followed by Deoxidine 457 and Alodine 5700 pretreatment
Aluminum (Autoprep)	#P180 to #P220 grit dry followed by Autoprep pretreatment wipes
Steel Blasted Steel	#P80 then #P120 grit dry or red pad
Galvanized steel	#P180 grit dry or red pad
Fiberglass gelcoat (unbroken)	#P220 to #P320 grit dry

Properly degrease substrate prior to sanding with Autoclean surface cleaner and R859 wax and grease remover.

Product and Additives

Product E380 Epoxy Primer Grey
E381 Epoxy Primer Black

Hardener E385 Epoxy Hardener

Basic Raw Material

E380 / E381 Epoxy Primer	Epoxy resins
E385 Epoxy Hardener	Polyamide resins

Product Characteristics

WPG (a-component)	13.3 +/- 0.5 lbs/gal	Gloss	Low
Volume Solids (RTS)	51 +/- 2%	Color	Grey and Black
Theoretical Coverage	817 ft^2/gal @ 1mil – 100%TE	Pot Life (no additives)	8 hr @ 70°F (21°C)

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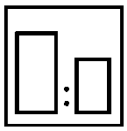
Mixing



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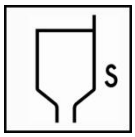
Use AkzoNobel Measuring Stick #109

Viscosity



E380 Epoxy Primer	18 – 24 sec	ZAHN #3 at 70°F (21°C)
	35 – 50 sec	DIN #4 at 70°F (21°C)

Viscosities are reported as Ready to Spray

Spray gun set-up / application pressure

RP – Pressure Feed	1.4 – 1.7mm	30 – 36psi	12 – 16 oz/min
HVLP – Pressure	1.2 – 2.0mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.5 – 1.9mm	Max 10psi (cap)	
HVLP – Siphon Feed	1.8 – 2.2mm	Max 10psi	
Pressure Feed	1.0 – 1.4mm	50 – 60psi	12 – 16 oz/min
Gravity Feed	1.3 – 1.5mm	50 – 60psi	
Siphon Feed	1.4 – 1.7mm	50 – 60psi	
Electrostatic	1.2 – 1.7mm	60 – 70psi	12 – 14 oz/min
Airless Spray	0.011 – 0.015in	1500 – 3000psi	
Air Assisted Airless	0.011 – 0.015in	700 – 900psi	

Application

Wet-on-Wet Primer Sealer - Apply one (1) to two (2) medium flowing coats.

Primer Surfacer (Sanded) - Apply two (2) to three (3) medium flowing coats, allowing 15 minutes flash-off time between coats

Substrate for Polyester Products - Apply one (1) single coat over the damaged area. Allow this to dry for 60 minutes at 70°F (21°C), (or up to 5 hours) before applying polyester filler.

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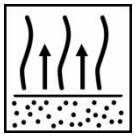
Flash off



15 minutes at 70°F (21°C) between coats

30 minutes at 70°F (21°C) final flash before topcoating – one coat of E380
45 – 60 minutes at 70°F (21°C) final flash topcoating – two or more coats of E380

Dry times

	70°F (21°C)	140°F (60°C)
Recoatable wet-on-wet	1 hr	N.A.
Dry to sand	7 hrs	2 hrs
Recoatable with polyester product	60 min per one coat	20 min per one coat

Dry Film Thickness

1.5 – 3.0 mils

Apply 1.5 – 1.75 mils per coat

Sanding

Final dry sanding step use #P400 – 500 before application of topcoats

Initial sanding steps may be executed with a coarser sanding grit: #P320

Recoatability

E380 Epoxy Primer must be topcoated within 48 hours of parts being stored indoors at 70°F (21°C). After 48 hours of indoor exposure, E350 Epoxy Primer must be sanded prior to topcoating.

E380 Epoxy Primer can be recoated with polyester products after the stated dry times making it an ideal damage repair system on steel, galvanized steel and properly treated aluminum. After the polyester product and the E380 Epoxy Primer have dried, sand the polyester material until satisfied with the repair. For further priming, any U-TECH primer may be applied that is recommended for the substrates exposed. All U-TECH primers may be applied over sanded E380 Epoxy Primer.

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Cleaning of equipment

Clean equipment with extra strong cleaning solvents

VOC

E380 / E381Epoxy Primer	< 3.5 lb/gal	< 420 g/l

VOC is ready to spray at a mix ratio of 4:1

Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

E380 / E381Epoxy Primer	2 years
E385 Epoxy Hardener	1 year

Head Office
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