

**Product Description: High Holdout Primer System****PRODUCT CODES:** PL-0530 - Gray | PL-1530 - White | PL-3530 - Yellow Oxide | PL-5533 - Red Oxide

**DESCRIPTION:** The EPEC High Holdout primer system was specifically developed for superior gloss holdout of the topcoat. It can also be coated immediately after spraying, allowing for "wet on wet" applications. These fast drying, epoxy ester modified primers exhibit good corrosion and chip resistance. Colors that are currently available include mist white, gray, buff yellow, and red oxide.

**PHYSICAL PROPERTIES:**

Weight Solids: 47%  
Volume Solids: 31% to 34%  
Resin Type: Modified Alkyd  
Gloss: 20 at 60°  
Theoretical Coverage: 530 square feet at 1.0 mil  
Weight per Gallo: 9.2 to 9.5 pounds  
Viscosity: #2 Zahn – 27 to 30 seconds at 77° F  
EPA VOC: 4.9 pounds per gallon

**SURFACE PREPARATION:** The service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits. EPEC High Holdout primer system may be applied over steel, aluminum, or fiberglass.

Steel: Bare steel areas should be treated with iron phosphate conversion coatings and adequate rinsing.  
Aluminum/Galvanized: Aluminum should be treated with appropriate metal cleaners and conditioners. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 to an average profile of 1.5 mils and then coated with two full coats before flash rusting occurs.

**REDUCTION:** EPEC High Holdout primers atomize easily and are ready for spraying without reduction. If reduction is necessary, thin sparingly, usually less than 10% with Xylol.

**APPLICATION:** EPEC primers can be sprayed with all types of application equipment. Airless tip sizes should be in the .011 to .015 range. When used with a heated system, EPEC is ready to spray.

Dry Film Thickness: For best results dry film thicknesses should be approximately 1.0 mil minimum above profile. This will require wet film thicknesses in the range of 3.0 to 4.0 mils. EPEC primers are intended to be used as a thin film coating.

**DRY TIMES:** Recoat times may vary according to film thicknesses and curing conditions, but typically EPEC can be recoated after tack free or approximately 15 to 30 minutes. EPEC can also be force dried to desired hardness at 160°F. After 72 hours or force drying care must be taken to ensure adequate inter-coat adhesion. Typically the primer will then need to be thoroughly scuff sanded after 72 hours for inter-coat adhesion.

**CLEAN UP:** Use Xylol to flush paint lines. N-9000 Gun Cleaner can be used for removing dried coatings.

**PERFORMANCE:** All testing conducted on B-100 panels at recommended DFT  
Weathering Cycle/Corrosion: ASTM D5894 – 1,650 hours – no face rust, no blistering, less than 5 mm creepage

## High Holdout Primer System

Salt Spray:	ASTM B-117 – 240+ hours with less than 1/16" creep from scribe and no face rust
Adhesion:	ASTM D3359 – 100% 5B, No loss
Flex:	ASTM D522 – Passes Conical Mandrel (No cracking)
Impact Resistance:	ASTM D2794 – Direct – 160 inch pounds (No tape pull off)
Hardness:	ASTM D3363 – H to 2H
Gravelometer:	ASTM D3170 – (Chip Resistance) SAE J400 – 5B good chip resistance

**SAFETY PRECAUTIONS:** Contains aromatic solvents. Vapor and spray mist harmful. Use proper respiratory protection. Refer to SDS for specific information. All information subject to change without notice.