

## EP210

### 2.1 VOC HB Epoxy Primer

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#### DESCRIPTION

EP210 is a high build Epoxy Primer with multiple VOC capabilities, depending on the catalyst and reducer used. It has been formulated for excellent adhesion and corrosion resistance when used on various types of substrates including properly prepared steel and aluminum. EP210 is compliant with all applicable air regulations including Rule 1151 in the SCAQMD when used with EX21 or EX405.

#### COMPONENTS

- EP210-series Primer
- EX21/EX355/EX405 Epoxy Catalyst
- S9860/S9870/S9885/S9895 Fast/Medium/Slow/Very Slow Standard Reducers
- S065/S075 Fast/Medium/Slow – Zero VOC Reducers

#### MIXING RATIO

<u>Catalyst</u>	<u>Reducer</u>	<u>VOC</u>	<u>Mixing Ratio (base:catalyst:reducer)</u>
EX21/EX405	S065/S075	2.1	1:1:0.5-1
EX355	S065/S075	3.5	1:1:0.5-1
EX405	S9860/S9870/S9885/S9895	3.5	1:1:0.5-1

\*Stir product while adding reducer to mixture\*

May be reduced 25%-50% with S9860/S9870/S9885/S9895 reducers for National Rule compliance.

May be reduced 25%-50% with S065 or S075 for 2.1 VOC.

#### POT LIFE AT 77° F

8 hours

#### CLEAN UP

Use NORTHSTAR Lacquer thinner or zero VOC solvents. (Check local regulations)

#### PHYSICAL DATA

Solids wt. (as mixed)	42-47%
VOC as mixed	2.1-3.5
Color	Dark gray, medium gray (MG), light gray (LG), white (W), black (B), cat yellow (Cat)

#### DRY / FLASH TIMES

##### Air Dry at 77° F

Flash between coats

15-45 minutes, depending on Catalyst used

To sand @77°F

With EX21 & EX355 = 16-24 hours

To topcoat @77° F

With EX405 = 8 hours

With EX21 & EX355 = 30-45 minutes

With EX405 15-30 minutes

## Force Dry

Flash time before force dry

15 minute flash

Force dry time

30 minutes @140°F

## GUN SETUPS

### Conventional

Gravity Feed

1.5 mm – 1.8 mm

Siphon Feed

1.5 mm – 1.8 mm

## AIR PRESSURES

### Conventional at Gun

Gravity Feed

35 – 45 psi

Siphon Feed

40 – 50 psi

HVLP at cap

8 – 10 psi

## SURFACE PREPARATION

Use **NORTHSTAR** Clean Wipe (S10) or Wax & Grease Remover (S20) to clean substrate free of grease, dirt, and foreign contaminants.

## APPLICATION

- Apply medium wet coats over substrate to desired film thickness
- Allow 15-45 minutes between coats, depending on catalyst used
- Sand after 48 hours when using EX21 or EX355; sand after 24 hours when using EX405
- Clean gun after spraying is completed
- Do not reduce with S085 Reducer

## SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.