

# Product Information

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## EPW115 Waterborne Speed Prime

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### Product Description

EPW115 Waterborne Speed Prime is a gray primer-surfacer based on the latest 1K waterborne technology which has been optimized for use under Envirobase® High Performance waterborne basecoat. It can be applied direct to metal without the need for a pretreatment or etch primer and delivers an alternative to traditional urethane primer-surfacers for collision centers that wish to be on the cutting edge of the latest refinish technology as well as reducing VOC emissions. The simple application along with the air dry speed of EPW115 Waterborne Speed Prime allows sanding in as little as thirty minutes producing a high speed, quality repair.

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### Preparation of Substrate:



- Wash the area to be painted with soap and water, then clean with appropriate PPG cleaner such as DX330, SXA330 or SWX350.



- Sand the bare metal areas completely with 180-280 grit abrasive and clean. Sand old finishes with 320-400 grit dry by hand or machine.
- Aluminum substrates must be primed within 8 hours of sanding and cleaning.



- Carbon steel must be primed immediately after sanding and cleaning
- EPW115 may be applied to properly prepared and cleaned bare metal.
- For bare plastics, an appropriate PPG plastic adhesion promoter must be applied prior to the application of EPW115.

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## Application Guide:

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### Mixing Ratio for EPW115 Waterborne Speed Prime

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**EPW115 Waterborne Speed Prime**

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**T494 Thinner**

**10% by weight (13% by volume)**

- EPW115 Waterborne Speed Prime should be thoroughly hand shaken prior to use.
- T492 Adjuster and T595 High Temp/Low Humidity thinner are not recommended for use with EPW115.

**Note:** EPW115 is reduced with T494 Thinner at 10% by weight or 13% by volume. Reduction accuracy is important, therefore it is recommended to reduce by weight using a mixing scale. Reducing by weight is not the same as reducing by volume. See mix table below or refer to PaintManager™ for additional mixing volumes.



Pot life\* @ 68°F / 20°C

24 hours

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### Cumulative Mix by Weight in Parts (Grams) for EPW115 Waterborne Speed Prime

Product	4 oz. / ¼ Pint	8 oz. / ½ Pint	16 oz. / 1 Pint	32 oz. / 1 Quart	64 oz. / 2 Quart
EPW115	<b>154.5</b> (137.0)	<b>309.0</b> (274.0)	<b>618.0</b> (548.0)	<b>1235.9</b> (1095.9)	<b>2471.8</b> (2191.8)
T494	<b>170.0</b> (150.7)	<b>340.0</b> (301.4)	<b>679.9</b> (602.9)	<b>1359.7</b> (1205.7)	<b>2719.5</b> (2411.4)

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### Additives:

None

**Note:** When used on plastic parts, EPW115 Waterborne Speed Prime does not require the use of a flexible additive.

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### Spray pressure:



HVLP : 10 psi at the cap

Compliant: 25 - 35 psi at the gun

Fluid Tip: 1.6 -1.9 mm

**Note:** For best overall results, refer to the spray gun manufacturers recommendations for optimum inlet air pressures.

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### Application:



Apply: 3 - 5 wet coats

Film Build: 0.8 - 1.0 mils per coat.

**Note:** For optimal performance, the minimum dry film build must be 2.5 mils or more after sanding. For film builds less than 2.5 mils, SX1071 Etch Prime must be used.

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### Flash off at 68°F/20°C:



Between Coats: Use air drying equipment, approximately 3 - 5 minutes or until dried to a matte finish.

**Note:** Do not use a spray gun as an air drier.

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### Drying Times:



Dry To Handle 68°F / 20°C Immediately after flash off once the surface becomes uniformly matte in appearance.

Dry to Sand 68°F / 20°C Approximately 30 minutes after flash off of the final coat. Humidity may affect dry times.

**Note:** After sanding, EPW115 may be top coated. If the sanded primer has been allowed to stand for more than 24 hours, it must be cleaned, lightly scuff sanded, re-cleaned prior to top coating.

IR (Infrared) Not to exceed 100°F / 38°C metal temperature

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## Compatible Topcoats:

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Once sanded, EPW115 Waterborne Speed Prime may be over coated with:

ECS2x Series A Chromatic LV Sealer

ECS6x Series A Chromatic LV Sealer

Envirobase® High Performance Waterborne Basecoat

Deltron® DBC or Global® BC basecoats must be applied over an appropriate 2K urethane sealer.

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## Equipment Cleaning:

Mixed material may be stored in an approved sealed plastic container for up to 24hrs. All spray equipment should be cleaned after each use with SWX100 Waterborne Gun Cleaner.

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## VOC Data

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### RTS Combinations:

### EPW115 : T494

Weight Ratio:	1 : 10%
Applicable Use Category	Primer
VOC Actual (g/L)	36
VOC Actual (lbs./gal)	0.30
VOC Regulatory (less water less exempt) (g/L)	86
VOC Regulatory (less water less exempt) (lbs./gal)	0.72
Density (g/L)	1283
Density (lbs./gal)	10.71
Volatiles wt. %	48.7
Water wt. %	45.9
Exempt wt. %	0.0
Water vol. %	59.1
Exempt vol. %	0.0

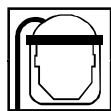
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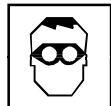
## Health and Safety

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



- 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 and MSDS's of all the components, since the mixture will have the hazards of all its parts.
- Improper handling and use, for example, poor spray technique, inadequate engineering controls and/or lack of proper Personal Protective Equipment (PPE), may result in hazardous conditions or injury.
- Follow spray equipment manufacturer's instructions to prevent personal injury or fire.



- Provide adequate ventilation for health and fire hazard control.



- Follow company policy, product MSDS and respirator manufacturer's recommendations for selection and proper use of respiratory protection. Be sure employees are adequately trained on the safe use of respirators per company and regulatory requirements.
- Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on MSDS.
- Always observe all applicable precautions and follow good safety and hygiene practices.

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**Emergency Medical or Spill Control Information (412) 434-4515; In Canada (514) 645-1320**

Materials described are designed for application by professional, trained personnel using proper equipment and are not intended for sale to the general public. Products mentioned may be hazardous and should only be used according to directions, while observing precautions and warning statements listed on label. Statements and methods described are based upon the best information and practices known to PPG Industries. Procedures for applications mentioned are suggestions only and are not to be construed as representations or warranties as to performance, results, or fitness for any intended use, nor does PPG Industries warrant freedom from patent infringement in the use of any formula or process set forth herein.

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