



## SPECTRACRON® 521/522 EPOXY PRIMER

**DESCRIPTION:**

**SPECTRACRON 521/522 Epoxy Primer** is an all-purpose primer that is corrosion resistant when used on properly prepared metal surfaces. It exhibits excellent adhesion when applied over properly prepared steel, galvanized aluminum and fiberglass.

**HIGHLIGHTS:**

- ❖ Excellent corrosion resistance
- ❖ Lead and chrome free
- ❖ Fast dry

**TECHNICAL PROPERTIES\*:**

PROPERTY	METHOD	RESULT
Color		Beige
Gloss @ 60° Angle	ASTM D523	25
Pencil Hardness	ASTM D3363	H - 2H
Adhesion	ASTM D3359	Excellent
Humidity Resistance 100Hrs	ASTM D2247	Excellent
Salt Spray Resistance 500 hours	ASTM B117	Excellent
Chemical Resistance		Excellent
Abrasion Resistance		Excellent
In Service Temperature		200 - 300° F
Substrates		CRS, HRS, Alum, Galv
Top Coat		SPECTRACRON 100,110,150,300,360

\*Results obtained over iron phosphated CRS panel

**PHYSICAL PROPERTIES:**

PROPERTY	VALUE
Weight per gallon	8.6 ± 0.2 lbs / gallon
Solid % (Weight)	35.0 ± 2.0%
Solid % (Volume)	23.0 ± 2.0%
Flash Point	
SPECTRACRON 521	30° F (-1° C)
SPECTRACRON 522	40° F (4° C)
VOC	5.4 lbs / gallon
Coverage	349 - 389 sq ft / gallon @ 1 mil (no loss)
Shelf Life	12 months each component



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## SURFACE PREPARATION:

The surface must be clean and free of all contamination. Chemical treatment or the use of a conversion coating will improve the adhesion and performance properties of the finished coat.

## APPLICATION DATA:

Mixing Instructions: Mix 1 part SPECTRACRON 521 to 1 part of SPECTRACRON 522 by volume. Stir thoroughly before and during use. Digest 15 minutes before using.

Wet Film Thickness: 3.0 - 5.0 mils

Dry Film Thickness: 1.0 - 1.5 mils

Thinner: Not Recommended

Clean up: Lacquer Thinner

Pot Life: 72 hours @ 77°F (**NOTE**: Heat shortens pot life of this material)

SPRAY APPLICATION	SPRAY EQUIPMENT	PRESSURE POT	PRESSURE (PSI)	ATOMIZING AIR (PSI)	TIP
Conventional	Binks 2001 *	NA	50	NA	66 SD
Conventional	Graco Delta Air *	¼" Fluid	10	60	.042
Air Assisted Airless	Graco Alpha A.A.*	NA	1000-1500	20-30	.009 or .011
HVLP	Binks 2001 HVLP *	NA	50	NA	NA

\*Or Equivalent

## CURE SCHEDULE:

Air-Dry @ 77°F:

Dry to touch: 15 minutes

Dry to handle: 45 minutes

To Topcoat: 1 hour to 4 days

To Recoat: After 1 hour or before 4 days

Force Dry: Flash 10 min @ ambient: 30 minutes @ 140°F

## ADDITIONAL INFORMATION:

- ❖ For application below 50°F, please contact your technical sales/service representative
- ❖ After 4 days, mechanically abrade surface before recoating or topcoating
- ❖ Excess film thickness will retard dry times and affect the recoat window
- ❖ Paint film is not fully cured for 7 days
- ❖ 300°F Maximum In-Service temperature

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**CONTACT 1-866-PPG TRUE**

It is recommended that the customer should trial the product for adhesion and compatibility using all substrates, surface preparation techniques and application processes in the environment the product will be intended to be used in prior to actual product application.

The technical data presented in this bulletin is based upon information believed by PPG to be currently accurate. However, no guarantees of accuracy, comprehensiveness or performance are given or implied. Continuous improvements in coatings technology may cause future technical data to vary from what is in this bulletin.

Do not attempt to use this product without the current Material Safety Data Sheet.  
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