



SPECTRACRON® 501 1K HS EPOXY PRIMER

DESCRIPTION:

SPECTRACRON 501 1K HS Epoxy Primer is recommended for industrial use on properly prepared surfaces. Applications include metal fabrication, castings, cabinets, machinery and heavy equipment.

HIGHLIGHTS:

- ❖ Easy to use one component epoxy
- ❖ Very good corrosion protection
- ❖ Non chrome pigments
- ❖ Low VOC

TECHNICAL PROPERTIES*:

PROPERTY	METHOD	RESULT
Color		Gray QAP501
Gloss @ 60° Angle	ASTM D523	25
Pencil Hardness	ASTM D3363	H- 2H
Conical Mandrel	ASTM D522	Excellent
Impact Resistance	ASTM D2794	30 in/lb
Adhesion	ASTM D3359	Excellent
Humidity Resistance 100Hrs	ASTM D2247	Excellent
Salt Spray Resistance 500 hours	ASTM B117	Excellent
Chemical Resistance		Good
Abrasion Resistance		Very Good
Substrates		CRS, HRS, Alum
Top Coat		SPECTRACRON 100, 150, 300, 360, 380, 390

*Results obtained over iron phosphated CRS panel

PHYSICAL PROPERTIES:

PROPERTY	VALUE
Weight per gallon	12.0 ± 0.2 lbs / gallon
Solid % (Weight)	72.2 ± 2.0%
Solid % (Volume)	51.9 ± 2.0%
Flash Point	84° F (29° C)
VOC	3.5 lbs / gallon maximum
Coverage	800-865 sq ft / gallon @ 1 mil (no loss)
Shelf Life	12 months



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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: Stir thoroughly before and during use

Wet Film Thickness: 2.0 - 3.0 mils

Dry Film Thickness: 1.0 - 1.5 mils

Clean up: MEK or Xylene

SPRAY APPLICATION	SPRAY EQUIPMENT	PRESSURE POT	PRESSURE (PSI)	ATOMIZING AIR (PSI)	TIP
Conventional	Binks 2001 *	NA	45	NA	66 SD
Conventional	Graco Delta Air *	¼" Fluid	10	60	.042
Air Assisted Airless	Graco Alpha A.A.*	NA	1000-1500	20-30	.011 or .013
HVLP	Binks 2001 HVLP *	NA	50	NA	NA

*Or Equivalent

CURE SCHEDULE:

Air-Dry @ 77°F:

Dry to touch: 30 - 45 minutes

Dry to handle: 90 minutes

To Recoat: Before 1 hour or after 6 hours to 7 days

To Topcoat: After 1 hour to 7 days

Force Dry: Flash 10 min @ ambient: 20 minutes @ 120°F

Flash 10 min @ ambient: 10 minutes @ 140°F

ADDITIONAL INFORMATION:

- ❖ For application below 50°F, please contact your technical sales/service representative
- ❖ Excess film thickness will retard dry times and affect the recoat window
- ❖ 200°F Maximum In-Service temperature

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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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