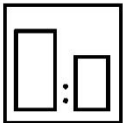


**Description**

A two-component high solids corrosion inhibitive epoxy primer. E350 Epoxy Primer is a low VOC, high solids, HAPs-Free epoxy primer sealer. The ready to spray VOC is 3.5 lbs/gal. E350 Epoxy Primer is a versatile product that can be applied in a couple of different methods:

1. As a wet on wet, non-sanded primer-sealer. Topcoat with U-TECH single stage and basecoat systems
2. As a primer-surfacer that can be sanded for extra smoothness and maximum appearance prior to topcoating.
3. As a transport primer
4. As a sealer coat over aged E350 Epoxy Primer (see Recoatability)
5. As a tintable primer, using (max 10%) of the U-TECH intermix tints



2	E350 Epoxy Primer
1	E350 Epoxy Hardener or E356 Hardener Fast
+10%	E359 Flow Additive (optional - use for improved appearance)

Use AkzoNobel Measuring Stick



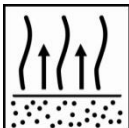
**103**



Spray gun setup:	Check gun manufacture specification		
RP – Pressure Feed	1.4 – 1.7mm	30 – 36psi	12 – 16 oz/min
HVLP – Pressure	1.2 – 2.0mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.5 – 1.9mm	Max 10psi (cap)	



Apply one (1) to two (2) single flowing coats



Between coats  
10 minutes at 70°F (21°C)

Wet on Wet with Topcoat  
30 minutes at 70°F (21°C) – one coat  
45 - 60 minutes at 70°F (21°C) – two coat




Dry to recoat (wet-on-wet)  
Dry to sand

70°F (21°C)	140°F (60°C)
30 – 60 min	N.A.
6 hrs	1 hr



Use suitable respiratory protection  
AkzoNobel recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

	North America	Technical Data Sheet
	<b>E350 Epoxy Primer</b>	
<b>FOR PROFESSIONAL USE ONLY</b>		

### Description

A two-component high solids corrosion inhibitive epoxy primer. E350 Epoxy Primer is a low VOC, high solids, HAPs-Free epoxy primer sealer. The ready to spray VOC is 3.5 lbs/gal. E350 Epoxy Primer is a versatile product that can be applied in a couple of different methods:

1. As a wet on wet, non-sanded primer-sealer. Topcoat with U-TECH single stage and basecoat systems
2. As a primer-surfacer that can be sanded for extra smoothness and maximum appearance prior to topcoating.
3. As a transport primer
4. As a sealer coat over aged E350 Epoxy Primer (see Recoatability)
5. As a tintable primer, using (max 10%) of the U-TECH intermix tints

### Suitable Surfaces

Existing finishes	#P220 to #P320 grit dry
Polyester bodyfiller	#P180 to #P220 grit dry
Aluminum (Alodine)	#P180 to #P220 grit dry followed by Deoxidine 457 and Alodine 5700 pretreatment
Aluminum (Autoprep)	#P180 to #P220 grit dry followed by Autoprep pretreatment wipes
Steel	#P80 then #P120 grit dry or red pad
Blasted Steel	
Galvanized steel	#P180 grit dry or red pad
Fiberglass gelcoat (unbroken)	#P220 to #P320 grit dry

#### Do not apply E350 Epoxy Primer over Thermoplastic Acrylic Lacquers

Properly degrease substrate prior to sanding with AutoPrep Ultra Prep Surface cleaner and R859 wax and grease remover.

### Product and Additives

<b>Product</b>	E350 Epoxy Primer	#391080
<b>Hardener</b>	E350 Epoxy Hardener	#391079
<b>Additives</b>	E359 Flow Additive	#393677

### Basic Raw Material

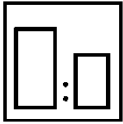
E350 Epoxy Primer	Epoxy resins
E350 Epoxy Hardener	Polyamide resins
E356 Epoxy Hardener Fast	Polyamide resins

### Product Characteristics

WPG (a-component)	13.7 - 14.7 lbs/gal	Gloss	Low
Volume Solids (RTS)	53 - 56%	Color	Black, Grey and White
Theoretical Coverage	857 ft <sup>2</sup> /gal @ 1mil – 100%TE	Pot Life	4 hr @ 70°F (21°C)

**Mixing**

- 2 E350 Epoxy Primer
- 1 E350 Epoxy Hardener or E356 Epoxy Hardener Fast

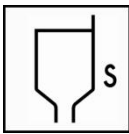


Add up to 10% E359 Flow Additive for improved appearance (optional)

Use AkzoNobel Measuring Stick #103

**Note: E350 Epoxy Primer can be tinted up to 10% using the U-TECH solid intermix tints. Add tints before mixing with the hardener**

**Viscosity**



E350 Epoxy Black	33 – 43 sec	EZ ZAHN #2 at 70°F (21°C)
E350 Epoxy White	31 - 41 sec	EZ ZAHN #2 at 70°F (21°C)
E350 Epoxy Grey	33 – 43 sec	EZ ZAHN #2 at 70°F (21°C)

Viscosities are reported as Ready to Spray

**Spray gun set-up / application pressure**



RP – Pressure Feed	1.4 – 1.7mm	30 – 36psi	12 – 16 oz/min
HVLP – Pressure	1.2 – 2.0mm	Max 10psi (cap)	12 – 16 oz/min
HVLP – Gravity Feed	1.5 – 1.9mm	Max 10psi (cap)	
HVLP – Siphon Feed	1.8 – 2.2mm	Max 10psi	
Pressure Feed	1.0 – 1.4mm	50 – 60psi	12 – 16 oz/min
Gravity Feed	1.3 – 1.5mm	50 – 60psi	
Siphon Feed	1.4 – 1.7mm	50 – 60psi	
Electrostatic	1.2 – 1.7mm	60 – 70psi	12 – 14 oz/min
Airless Spray	0.011 – 0.015in	1500 – 3000psi	
Air Assisted Airless	0.011 – 0.015in	700 – 900psi	

**Application**

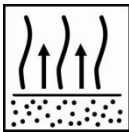


**Wet on Wet Primer Sealer** - Apply one (1) to two (2) medium flowing coats. For repairs down to bare metal, apply an initial thin coat over area, allow proper flash time and then follow with one medium flowing coat.

**Primer Surfacer (Sanded)** – Apply two (2) single flowing coats with proper flash time between coats.

**Transport Primer** – Apply two (2) single flowing coats followed with proper flash time between coats. See recoatability section.


**Flash off**



10 minutes at 70°F (21°C) between coats

30 minutes at 70°F (21°C) final flash before topcoating (1.2 – 1.4 mil)

45 – 60 minutes at 70°F (21°C) final flash topcoating (High Film Thickness)

	North America	Technical Data Sheet	
	<b>E350 Epoxy Primer</b>		Primer
			12/13/16
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**Dry times**



E350 Epoxy Hardener

Object Temperature	Before Topcoat @ (1.2 – 1.4mils)	Dry to Sand
50°F (10°C)	1 hour	24 hours
70°F (21°C)	30 min	6 hours
100°F (38°C)	15 min	2 hours
140°F (60°C)	10 min	1 hour



E356 Epoxy Hardener Fast

Object Temperature	Before Topcoat @ (1.2 – 1.4mils)	Dry to Sand
50°F (10°C)	1 hour	16 hours
70°F (21°C)	15 min	4 hours
100°F (38°C)	15 min	1 hours
140°F (60°C)	10 min	30 min

**Dry Film Thickness**

Primer Sealer – 1.2 – 1.4 mils  
 Primer Surfacer (Sanded) or Transport Primer – Minimum 2.0 mils

Apply 1.2 - 1.4 mils per coat

**Sanding**



Final dry sanding step use #P400 – 500 before application of topcoats

*Initial sanding steps may be executed with a coarser sanding grit: #P320*

**Recoatability**

E350 Epoxy Primer at a 1.2 -1.4 mil DFT can be topcoated after a final flash of 30 minutes at 70°F (21°C). For higher film thicknesses, allow a 45 – 60 minute final flash for optimum topcoat appearance.


Non-sanded E350 Epoxy Primer must be topcoated within 7 days of parts being stored indoors at 70°F (21°C). After 7 days of indoor exposure, E350 Epoxy Primer must be sanded prior to topcoating.

Non-sanded E350 Epoxy Primer must be topcoated within 24 hours of parts being stored outside. Outside exposure greater than 24 hours and up to 6 months require a power wash and re-application of one (1) coat of E350 Epoxy Primer prior to topcoating. **Do not allow E350 Epoxy Primer to be outside greater than 6 months without topcoating.**

**Do not apply polyester bodyfillers over E350 Epoxy Primer**

**Cleaning of equipment**

Clean equipment with extra strong cleaning solvents

	North America	Technical Data Sheet
	<b>E350 Epoxy Primer</b>	Primer
		12/13/16
<b>FOR PROFESSIONAL USE ONLY</b>		

**VOC**

E350 Epoxy Primer < 3.5 lb/gal < 420 g/l

VOC is ready to spray at a mix ratio of 2:1. Adding up to 10% E359 Flow Additive will not increase the ready to spray VOC

**Product Storage and Shelf Life**

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

E350 Epoxy Primer	2 years
E350 Epoxy Hardener	1 year
E356 Epoxy Hardener Fast	1 year

**FOR PROFESSIONAL USE ONLY**

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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