

## TECHNICAL DATA

E-4402 GREY  
E-4403 WHITE  
E-4409 BLACK  
EPOXY PRIMER

### **PRODUCT DESCRIPTION**

General purpose 2 component high-build epoxy.  
Ideal for trucks, heavy equipment, machinery,  
fiberglass, steel structures, tank exteriors,  
concrete and wood.

### **PRODUCT FEATURES**

- > Fast drying
- > Good adhesion
- > Good chemical resistance
- > Good sanding properties
- > Can achieve 8-10 mils wet (200-250 microns) in one coat.

### **PRODUCT LIMITATIONS**

- > Shelf life: 12 months

> Keep in a cool and dry area.

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<b>Gloss:</b>	60°-80°
<b>Type of cure:</b>	Two component epoxy
<b>Binder:</b>	Epoxy/Polyamide
<b>Solids by volume:</b>	52+/-2%
<b>Solids by weight:</b>	74+/-2%
<b>Theoretical coverage</b>	1 mil: 830ft <sup>2</sup> /US gal.
<b>D.F.T.:</b>	25 microns: 77m <sup>2</sup> /3.78 lts.
<b>Recommended</b>	mils: 1.0-3.0
<b>dry film thickness/coat:</b>	microns: 25-75
<b>Viscosity:</b>	80 ku +/-5
<b>Specific gravity:</b>	1.47-1.57 kg.lt
<b>Flash Point:</b>	-6°C (21.2°F.)
<b>V.O.C.:</b>	409grs./lt. 3.39 lbs./gal.
<b>Drying time:</b>	
<b>Dust free:</b>	15 minutes
<b>To recoat:</b>	30 minutes
<b>Hard:</b>	24 hours
<b>Pot life:</b>	24 hours
<b>Reduction:</b>	6211 Regular 10% per volume
<b>Induction time:</b>	30 minutes
<b>Catalyst:</b>	E-4400C 4:1
<b>Ratio:</b>	3.78 lts. (1 US gal.)
<b>Packaging:</b>	15.14 Lts. (4 US gal.)

## APPLICATION GUIDE

### SURFACE PREPARATION

Prepare surface in accordance with SSPC-SP-1 (solvent cleaning).

Removal of all detrimental foreign matter such as oil, grease, dirt, soil, salts, drawing and cutting compounds, and other contaminants from steel surfaces by the use of solvents, emulsions, cleaning compounds, steam or other similar materials and methods which involve a solvent or cleaning action.

### MIXING AND THINNING

To obtain a smooth homogeneous product, both part A and part B should be mechanically mixed together.

Use with catalyst: E-4400C Mixing ratio: 4:1

Dilute with 6211 epoxy thinner.

Air spray: 15-25% reduction

Airless spray: If required

### APPLICATION

			RECOATING TIME	
Substrate temperature	Dust free	Hard	Minimum	Maximum
25 deg C (72 deg F)	15 minutes	24 hours	30 minutes	20 days

**Note: Should always be free of all contaminants between minimum and maximum recoating time.**

#### Air spray:

Spray gun: DeVilbiss JGA or MBC (or equivalent)

Fluid tip: "E" or "EX" (tip and needle)

Air cap: 704 or 765 and #80 with EX

Air pressure: 50-55 psi

#### Airless spray:

Pump: Heavy Duty 30:1

Tip: 0.015-0.021 inch (0.38-0.53mm) @ 1500-3000 psi

### PRECAUTION

See the material safety data sheet and product label for complete safety and precaution requirements.

#### DISCLAIMER:

"The following is made in lieu of all warranties, expressed or implied: Manufacturer's obligation shall be to replace such quantity of the product proven to be defective. The manufacturer shall not be liable for any injury, loss or damage, direct or incidental or consequential, arising out of the use of or the inability to use the product. Before using, the user shall determine the suitability of the product for the intended use and the user assumes all risk and liability whatsoever in connection therewith. All values shown are approximations. Values indicated are for guide purposes only, as actual values can change due to application conditions, application methods, environmental conditions etc. The information contained herein is subject to change without notice. Consult your representative for a current data sheet. The foregoing may not be altered except by an agreement signed by the officers of the manufacturer."

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