



GENERAL INFORMATION:

Epoxy Primer is a high solids Epoxy based primer with excellent adhesion characteristics and corrosion resistance on bare metals. The 1-780 Epoxy primer meets OEM approval requirements. For application on passenger cars and commercial vehicles.



COMPONENTS:

1-700 Epoxy Primer Hardener
1-151 Uni Thinner Standard



AUTOMOTIVE SUBSTRATES:

On properly cleaned and prepared steel, zinc, aluminum, E-coat, polyester putties and OEM finishes.
Note: Do not apply Epoxy Primer over Wash Primer.



SURFACE PREPARATION:

Cleaning: Clean with Silicon Remover 1-951 by using wipe on/wipe off method.



Sanding: Sand surface thoroughly with P180 dry discs. Sand with P240 dry discs or scuffing pad for preparation of E-coat and OEM finishes.



Cleaning: Repeat cleaning procedure after preparation of substrate



MIXING RATIO:

5 : 1 : 1 by volume
(Primer 1-780 : Hardener 1-700 : Thinner 1-151)



VISCOSITY: DIN cup 4 mm / 68°F / Sec

Airspray 14-16



GUN SET UP:

	Nozzle (mm)	Air pressure bar/psi
HE	1.3 - 1.6	2.0 / 29
HVLP	1.3 - 1.6	2.0 / 29



APPLICATION:

Spray coats 2-3 Medium wet coats
Dry layer thickness (µm) 60-90



POT LIFE at 68°F (min.)

60-90 *
* Waiting longer for application might affect the application properties



FLASH OFF at 68°F (min.)

10-20 between coats, until matt
Do not use wet-on-wet application



DRY TIMES: (min.)

68°F N/A
140°F Obj. 60



CLEAN UP:

1-051 Gun Cleaner

NEXT LAYER:

Recoat with 900* series WaterBase basecoat after sanding

PHYSICAL PROPERTIES

FOR USA (4.6 LB/GAL Compliance):

RTS REGULATORY DATA:	5:1:1 (Uni Thinner Series)	
	LB/GAL	g/L
	Actual VOC	4.1 Max.
Regulatory VOC (less water and exempt solvents)	4.6 Max.	550 Max.
Density	11 – 12	1320 – 1440
	WT%	VOL%
Total Solids Content	59 – 63	38 – 42
Total Volatile Content	37 – 41	58 – 62
Water Content	0	0
Exempt Compound Content	5 - 10	5 - 10
Coating Category	Primer Sealer	

Note: US Regulations allow for the use of exempt compounds for VOC calculations.

STORAGE / SHELF LIFE (years)

min. 2
Under normal storage conditions and for unopened tins



Use suitable respiratory protection (we recommend the use of a fresh air supply respirator).

If used as directed, this product is designed to comply with the US National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use. The data on this sheet represents typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR PROVIDES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES. Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, determined at our discretion.