



Technical Data:

Low VOC Undercoat System

**Base Epoxy Primer WP230
Primer-Sealer Activator WP232
Primer-Surfacer Activator WP234**

PRODUCT DESCRIPTION

The Western Low VOC Undercoat System is composed of Base Epoxy Primer WP230 that can be activated with Primer-Sealer Activator WP232 to form Low VOC Primer-Sealer, or Primer-Surfacer Activator WP234 to form Low VOC Primer-Surfacer. It is a two-component, water reducible, epoxy based undercoat system designed to provide excellent adhesion and corrosion protection without flash rusting, and with a VOC as applied of 2.0 lbs/gallon (maximum).

TECHNICAL DATA

• Color	Light Gray	Base Epoxy Primer WP230	Low VOC	Low VOC
	Med. Gray	Sealer Activator WP232	Primer-Surfacer	Primer-Sealer
	Dark Gray	Surfacer Activator WP234	<u>WP230/234</u>	<u>WP230/232</u>
		Low VOC	2.0-2.5 mils	1.3-1.7 mils
		Primer-Surfacer		
		<u>WP230/234</u>		
		Low VOC		
		<u>WP230/232</u>		
• Flash points		>230°F	• Recommended dry film thickness	
• Volume solids as applied		37%	• Topcoat holdout	Excellent
• VOC as applied	2.0 lbs/gal.	45%	• Humidity resistance* (96 hrs)	Excellent
• Viscosity #2 Zahn	32-40 sec.	2.0 lbs/gal.	• Corrosion resistance* (250 hrs.)	Excellent
• Lead/chromate free	Yes	32-40 sec.	• Impact resistance* - direct	160 in. lbs.
• Coverage @ 1 mil dry per sprayable gallon	600 sq. ft.	Yes	• Flexibility* (1/4" conical mandrel)	Pass
		724 sq. ft.	* After one week air dry	Pass

SURFACE PREPARATION

Bare Substrates: Steel, Galvanized Steel, Aluminum, or Fiberglass

Note: *With the inconsistencies of galvanized steel, consult your local Western Representative for system recommendations and substrate testing.*

- Solvent clean with WS1018 Grease & Wax Remover or WS1019 Low VOC Surface Cleaner and wipe dry with a clean, dry cloth.
- Apply one double coat of Etch Wash Primer WP213 for steel substrates. For aluminum, remove oxidation by sanding with 280 grit on a random orbital sander. (Fiberglass does not require pre-treatment primer.)
Note: Avoid using directly over shot/sand blasted steel without a pre-treatment primer.

Prepainted Substrates:

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
- Solvent clean with WS1018 Grease & Wax Remover or WS1019 Low VOC Surface Cleaner. Wipe dry with a clean, dry cloth.
- Grind repair area to remove paint and all rust as needed. Fill as needed using an appropriate body filler. Allow body filler to tack up and shape as needed.
- Sand repair area and featheredge using 80, 180, 280, and finish with 320 grit treated sandpaper on a random orbital sander.
- Apply Metal Prep W709 to bare metal by brush, nylon scuff pad, spray, or dip.

(For the above products refer to the appropriate product label or data page for complete information.)

MIXING (No induction time required)

1. Stir WP230 thoroughly before using.
2. **Western Low VOC Primer-Surfacer** (pot life is 24 hours at 70°F)



Western Low VOC Primer-Sealer (pot life is 6 hours at 70°F)



* Add up to 10% **deionized** water to achieve 32-40 seconds in #2 Zahn.

APPLICATION

Low VOC Primer-Surfacer WP230/234

1. Adjust air pressure at the gun to **45-55** psi for siphon feed or 8-9 lbs. for HVLP with a fluid delivery of 11 oz./minute. For pressure pot, use Devilbiss JGA (or equivalent) with .070" orifice, EX tip, and 264 air cap with a fluid delivery rate of 10-12 oz./minute.
2. Apply 2-3 medium coats at a gun distance of 8-10 inches allowing each coat to become hand slick before next coat.

Low VOC Primer-Sealer WP230/232

1. Adjust air pressure to 50-55 lbs. for siphon feed or 9-10 lbs. for HVLP with a fluid delivery rate of 12 oz./minute. For pressure pot, use Devilbiss JGA (or equivalent) with .070" orifice, EX tip, and 264 air cap with a fluid delivery rate of 10-12 oz./minute.
2. Apply 1 medium coat at a gun distance of 8-10 inches.

Notes:

- **Flush spray equipment with deionized water prior to spraying Low VOC Undercoat System.**
- **Do not use gun air to blow dry or cracking may occur. Clean up immediately with water followed by a 1:1 alcohol (isopropanol) and water solution and finish with lacquer thinner.**
- **Do not use below 65°F as film will not cure properly.**

RECOATING

Western Low VOC Primer-Surfacer WP230/234

1. Allow to dry for 30 minutes at 70°F or force dry for 15 minutes at 120°F. (Product may be force dried at temperatures up to 200°F.)
2. Finish sand with 320 grit or finer, depending on topcoat, treated sandpaper. Solvent clean with WS1018 Grease & Wax Remover or WS1019 Low VOC Surface Cleaner to ensure surface is free of sanding residue.
3. Recoat with Low VOC Primer-Sealer WP230/232, E BASE™ Basecoat, EXPRESS® Acrylic Enamel with hardener, or HI-GLO™ Synthetic Enamel with hardener.

Western Low VOC Primer-Sealer WP230/232

1. Allow to dry 8 hours at 70°F or force dry for a minimum of 30 minutes at 140°F, a minimum of 20 minutes at 160°F, or a minimum of 10 minutes at 180°F.
2. Recoat with E BASE Basecoat, EXPRESS Acrylic Enamel with hardener, or HI-GLO Synthetic Enamel with hardener.

Note: Refer to manufacturer's maximum force dry temperature recommendations before force drying.