



SHERWIN-WILLIAMS®
Automotive Finishes

DTM Primers
3.5 VOC Epoxy Primers
E2A933 Gray
E2W932 White
E2B931 Black

PRODUCT DESCRIPTION

3.5 VOC DTM Epoxy Primers, E2B931 / E2W932 / E2A933, are low VOC, two-component primers offering excellent direct-to-metal adhesion and corrosion protection over properly cleaned steel and aluminum substrates without the use of lead or chromate. 3.5 VOC Epoxy Primers E2B931 / E2W932 / E2A933 offer flexibility greater than standard epoxy primers. E2B931 / E2W932 / E2A933 require no induction time and are designed for truck manufacturers, fleets and automotive refinishers where extended service is important. These primers may be topcoated as soon as 30 minutes after priming.

TECHNICAL DATA

	E2A933, E2W932, EB931		
Wt/gallon, mixed	10.41 lbs./gal	Flash Point (@ 4:1:1)	38°F Seta
Mixing ratio by volume		Viscosity @ 4:1:1, #2 Zahn cup	14-16 sec.
Primer: VS100: V6V943	4: 1: 1	Performance after one week air dry over Aluminum & Steel using GENESIS® Topcoat	
Volume Solids @ 4:1:1	40.88%	Humidity Resistance - 100 hrs	Pass
Coverage @ 1 mil dry	656 sq.ft./gal	Impact Resistance direct @ 80 in-lbs.	Pass
Pot life @ 70-80°F	4 hrs	Impact Resistance direct @ 80 in-lbs.	Pass
VOC less exempt @ 4:1:1	3.14 lbs./gal	Flexibility 1/8" conical mandrel	Pass
HAPS Status	Compliant, Non-Photochemically Reactive	Salt Spray Resistance - 500 hrs	Pass
		Gloss Holdout @ 15 - 30 mins re-coat	Excellent
		Recommended dry film thickness 2 coats	1.5-2.0 mil

Suitable Substrates : Cold Rolled Steel, Hot Rolled Steel, Hot-dipped Galvaneal, SMC, IMC, ED5050 E-coat, Body Filler.

MIXING

1. Stir or shake E2B931 / E2W932 / E2A933 3.5 Epoxy Primer thoroughly before mixing. Use care when opening after shaking, as slight solvent pressure may build. A 15-minute wait after shaking is recommended.
2. Mix by volume 4 parts E2B931 / E2W932 / E2A933 with 1 part of VS-100 Reducer, and 1 part Epoxy Hardener V6V943.*
3. Stir thoroughly and strain.
4. For a high solids alternate mix ratio to fill blast profiles mix 4 parts E2B931 / E2W932 / E2A933 with 0.5 parts of VS-100 Reducer, and 1 part Epoxy Hardener V6V943.

*Note: VS100 maybe replaced with R7K7210 or ES20 for warm and hot conditions respectively where improved leveling and overspray acceptance are needed.

TINTING

E2A933/W932/B931 can be blended together by volume, or can be tinted by using up to 10% by volume of Genesis Monochromatic toners. **Do not** use Genesis metallic toners or Lead containing Genesis toners(GT1035, GT1036, GT1041) to tint.

APPLICATION

Overall

1. Adjust air pressure at the gun to 55-65 psi for siphon, gravity or pressure feed (adjust pot pressure to 5-10 psi for 8-15 fluid ounces per minute delivery).
2. For Pressure/Siphon feed, apply 2 medium coats at a gun distance of 8-10 inches. Spray to hiding. For HVLP, apply 1 full wet coat with 50% overlap, applying the second coat in a cross-coat method. Recommended dry film thickness is 2.0-2.5 mils.
3. Clean spray gun immediately after use with Gun and Equipment Cleaner.

Repair

1. Repair process must be performed using a two-gun method. Apply topcoat over the repaired area carrying out the wet edge just beyond the repair.
2. Allow topcoat to flash per data sheet recommendations. Apply a second coat to achieve proper hiding and blending of the color into the repaired area and lightly feather the outer edge.
3. Immediately after feathering the final coat, melt the feathered edge with a wet-on-wet application using Ure-Blend™ BS10 1K Urethane Blending Solvent.

Buffing Blend Area

- Allow finish to cure.
- If sanding is needed for dirt or smoothing the blend area, use 2000 to 2500 grit wet paper.
- Buff blend area by machine with a quality micro-finishing compound followed by machine glaze. Hand glaze if needed.

Equipment

<u>Gun Type</u>	<u>Nozzle</u>	<u>Air Pressure</u>
Conventional Siphon Feed	1.3-1.5 mm	50-55 psi
Conventional Gravity Feed	1.3-1.5 mm	50-55 psi
Conventional Pressure Feed	0.8-1.1 mm at 8-12 oz/min	50-55 psi
HVLP Gravity Feed	1.3-1.5 mm	10 psi at cap
HVLP Pressure Feed	0.8-1.1 mm at 8-12 oz/min	10 psi at cap
Reduced Pressure Gravity	1.3-1.5 mm	follow gun manufacturer recommendations
Reduced Pressure Pressure	0.8-1.1 mm	follow gun manufacturer recommendations

DRYING SCHEDULE

Dry times are based on the recommended dry film thickness of 2.0-2.5 mils.

• Air dry times @ 75°F and 25% R.H.

Hand-slick	5 minutes
To Recoat	30 minutes (see below)
Tack-Free	1 hour
Nib Sandable	1 hour
Sandable	1.5 hours (Slightly longer for Black)
Tape Free	1.5 hours (Slightly longer for Black)

• Force dry times (to tape free)

45 minutes at 160°F
30 minutes at 180°F

RECOATING

1. E2B931/ E2W932 / E2A933 3.5 VOC epoxy primers may be recoated up to 7 days after spraying without scuffing for all topcoats (see exceptions below) except Ultra 7000, which may be recoated up to 2 days without scuffing. After 2 days, scuff sand with 320 grit or finer sandpaper to insure proper adhesion.
2. Recommended topcoats

DIMENSION 3.5-2.8 Urethane Enamel	SUNFIRE Acrylic Urethane
Ultra 7000 Basecoat/clearcoat	SUNFIRE Low VOC Acrylic Urethane
ACRYLD 5.0*	GENESIS 2.8/3.5 Acrylic Urethane
GENESIS Basecoat/clearcoat	GENESIS M Acrylic Urethane

* Topcoat within 8 hours when using ACRYLD over E2A933 series primers.

* When sealing with any urethane sealer, allow primer to dry a minimum of 3 hours.

PRODUCT -AT-A - GLANCE

DTM Primer
3.5 VOC Epoxy Primer
E2A933 Gray, E2W932 White, E2B931 Black

PRODUCT USE

- Direct to properly cleaned metal surfaces
- Ideal for harsh environments where corrosion protection is important
- Fast dry

SUITABLE SUBSTRATES*

- Steel/Stainless Steel
- Aluminum
- SLI269 (SMC)
- Body Filler
- *Hot-dipped Galvaneal*
- E67AR1908 (IMC)
- ED5050 (E-coated Steel)
- E2G973 CORROSION SHIELD

SURFACE PREPARATION

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean cloth.
- Solvent clean with the appropriate solvent cleaner and wipe dry with a clean cloth.
- Grind repair area to remove paint and all rust as needed.
- Apply body filler to clean bare metal as needed.
- Sand all areas to be refinished and featheredge all broken film areas.

Bare Substrates: Steel, Galvanized Steel, Aluminum*

**Note: With the inconsistencies of substrates, consult your local Sherwin Williams Representative for system recommendations and substrate testing.*

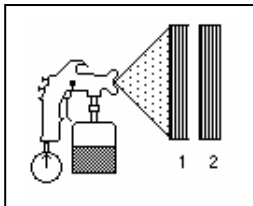
MIXING

1. Stir or shake 3.5 VOC Epoxy Primer E2B931/E2W932/E2A933 thoroughly before mixing. Use care when opening after shaking, as slight solvent pressure may build. A 15-minute wait is recommended after shaking.
2. Mix by volume 4 parts 3.5 Epoxy Primer E2B931/E2W932/E2A933 to 1 parts VS100 Reducer to 1 part 3.5 Epoxy Activator V6V943. *Note: VS100 maybe replaced with R7K72 10 or ES20 for warm and hot conditions respectively where improved leveling and overspray acceptance are needed.*
3. Stir thoroughly and strain.

Note: See E2B931P/W932P/A933P PDS for zinc enriched mixing option for severe service environments.

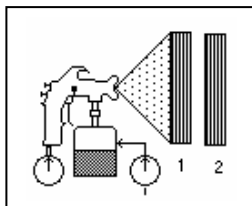
APPLICATION

Gravity Feed
Apply 2 coats.
Allow each coat to become hand slick.



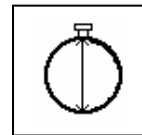
50 - 55 psi HVLP: 10 psi

Pressure Feed
Apply 2 coats.
Allow each coat to become hand slick.



50-55 psi pot pressure: 10 psi

Time to
Recoat
30 minutes



RECOAT

SUNFIRE® Acrylic Urethane
SUNFIRE® Low VOC Acrylic Urethane
SUNFIRE® Basecoat/Clearcoat
ACRYLYD® 5.0
Westhane® 5.0/3.5

DIMENSION™ 3.5 Urethane
ULTRA 7000® Basecoat/Clearcoat
GENESIS® 2.8/3.5 Acrylic Urethane
GENESIS® Basecoat/Clearcoat
ULTRA ONE™ HPU 5.0/3.5

NOTES

- Scuff sand with 320 or finer sandpaper after recommended recoat time. See previous page for recommendations.
- For optimum corrosion resistance, 2.0-2.5 mils of primer (dry) is recommended.

PERSONAL PROTECTION

- For use by trained professionals only.
- Read label, directions, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.

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