



SHERWIN-WILLIAMS.
Automotive Finishes

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

PRODUCT OVERVIEW

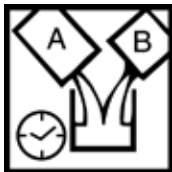
3.5 VOC DTM Epoxy Primers, E2B931, E2W932, E2A933 are low VOC, two-component primers offering excellent direct-to-metal adhesion and corrosion protection over properly cleaned steel and aluminum substrates. 3.5 VOC Epoxy Primers E2B931, E2W932, E2A933 offer flexibility greater than standard epoxy primers. 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.

SUITABLE SUBSTRATES

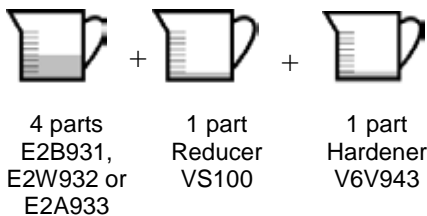


- Cold rolled steel
- Hot rolled steel
- Hot-dipped Galvaneal
- Aluminum
- SMC
- IMC
- E-Coated Steel
- Body Filler
- ED5050

NOTE: Not for use on immersed surfaces. Not for use on surfaces with extended surface temperatures of 250°F or more.



MIXING

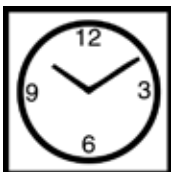


APPLICATION



For Pressure/Siphon feed, apply 2 medium coats at a gun distance of 8-10 inches. For HVLP, apply 1 full wet coat with 50% overlap, then apply a second coat in a cross-coat method. Recommended dry film thickness is 2.0-2.5 mils.

1. HVLP: Adjust air pressure at cap to 5-10 psi.
2. Adjust air pressure at the gun to 55-65 psi for pressure feed applications with a fluid delivery of 8-15 ounces per minute.
3. Conventional: Adjust air pressure at the gun to 60 psi for pressure feed applications with a fluid delivery of 8-12 ounces per minute.



DRYING SCHEDULE

Air Dry Times at 75°F and 25% relative humidity

- Hand Slick: 5 minutes
- Dust Free: 15-20 minutes
- Tack Free: 1 hour
- Nib Sandable: 1 hour
- Sandable: 1.5 hours (slightly longer for E2B931)
- Tape Free: 1.5 hours (slightly longer for E2B931)



PERSONAL PROTECTION

- Read all label directions before use.
- Refer to MSDS for specific information.
- Wear positive-air respirator when mixing and applying.
- For Professional Use Only.
- Wear a NIOSH approved dust particulate mask when sanding.
- Wear safety goggles, coveralls and latex gloves when using product.



PRODUCT DATA SHEET



SURFACE PREPARATION

- **Solvent clean** with the appropriate solvent cleaner and wipe dry with a clean cloth.
- **Abrade** all bare metal surfaces with 220 or 320 grit sandpaper, or Red Scotch Brite® pad.
- **Apply** body filler to clean bare metal as needed.
- **Solvent clean** again with appropriate solvent cleaner to remove sand residue.



SUITABLE SUBSTRATES

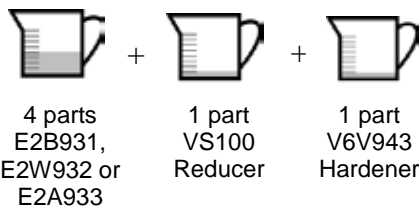
- Cold rolled steel
- Hot rolled steel
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- IMC
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NOTE: Not for use on immersed surfaces. Not for use on surfaces with extended surface temperatures of 250°F or more.



MIXING

- Stir or shake E2B931, E2W932, E2A933 3.5 Epoxy Primer thoroughly before mixing. Use care when opening and after shaking, as slight solvent pressure may build.
- Mix by volume 4 parts E2B931, E2W932, E2A933 with 1 part VS100 Reducer, and 1 part V6V943 Epoxy Hardener.
- Stir thoroughly and strain.
- Pot life 4 hours at 70-80°F for E2W932 and E2A933. Pot life 3 hours at 70-80°F for E2B931.



REDUCER	TEMPERATURE RANGE
VS100	50-75°F
R7K7210 or ES20	75-90°F

NOTE: VS100 Reducer may be replaced with R7K7210 or ES20 for warm and hot conditions respectively where improved leveling and overspray acceptance are needed.



APPLICATION

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. 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.

EQUIPMENT

<u>Gun Type</u>	<u>Nozzle</u>	<u>Air Pressure</u>
Conventional Gravity Feed	1.3-1.5 mm	55-65 psi
Conventional Pressure Feed	0.8-1.1 mm at 8-12 oz/min	55-65 psi
HVLP Gravity Feed	1.3-1.5 mm	5-10 psi at cap
HVLP Pressure Feed	0.8-1.1 mm at 8-12 oz/min	5-10 psi at cap



PRODUCT DATA SHEET

RECOAT

- E2B931, E2W932, E2A933 3.5 VOC Epoxy Primers may be recoated up to 7 days after spraying without scuffing for most topcoats (see exceptions below).
- Ultra 7000® Basecoat may be recoated up to 2 days without scuffing. After 2 days, scuff sand with 320 grit or finer sandpaper to ensure proper adhesion.

Recommended topcoats:

- DIMENSION® 2.8-3.5 Urethane Enamel (7 Days)
- Ultra 7000® Basecoat (2 Days)
- GENESIS® Basecoat (3 Days)
- GENESIS® 2.8/3.5 Acrylic Urethane (7 Days)
- GENESIS® M Acrylic Urethane (7 Days)

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



DRYING SCHEDULE

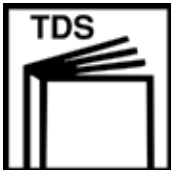
Dry times are based on the recommended dry film thickness of 2.0-2.5 mils. Thicker films, low temperatures, and high humidity will extend dry time.

Air Dry Times at 75°F and 25% relative humidity

Hand slick	5 minutes
Dust Free:	15-20 minutes
Nib Sandable:	1 hour
Tack Free:	1 hour
Sandable:	1.5 hours (slightly longer for E2B931)
Tape Free:	1.5 hours (slightly longer for E2B931)

Force Dry Times

Temperature	Time to Sand
160°F	45 minutes
180°F	30 minutes



TECHNICAL DATA

Mixing Ratio by Volume	4:1:1	Physical Properties	
Max VOC @ 4:1:1	3.11 lbs/gal	Salt Spray 500 hours	Pass
Ready to Spray Volume Solids (White)	40-41 %	Impact Resistance direct @ 80 in-lbs	Pass
Coverage @ 1 mil dry (white)	656-657 FT ² /gal	Humidity 100 hours	Pass
Pot Life	4 hours at 75°F 3 hours at 75°F for E2B931P	Flexibility (1/8" conical mandrel)	Pass
Viscosity (sprayable) Gardener #2 Zahn Cup (ISO calibrated)	14-16 sec	Recommended Dry Film Thickness	2.0 -2.5 mils

E2B931 / W932 / A933	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	12.02	1440	10.57	1266
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	28.4	48.8	40.3	59.0
Solids	71.6	51.2	59.7	41
Water	0	0	0	0
Exempt Compounds	9.6	17.6	19.1	28.3
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	2.25	269	2.23	267
VOC Less Exempt	2.73	327	3.11	373
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.00	0.000	0.47	0.057

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