

COIL COATING PRODUCT DATASHEET



INDUSTRIAL FINISHES

AkzoNobel
Tomorrow's Answers Today

Customer: Metal Coaters of California
Location: Rancho Cucamonga, California

Product Description: **Product Code:** EA9R13644
Description: Epoxy Weldable Primer
End Customer:

Wet Properties: **Density:** 15.3 ± 0.2 lbs./gal.
Weight Solids: 71 ± 2 %
Volume Solids: 40 ± 2 %
VOC (theoretical): 4.50 lbs./gal.
Coverage/Gallon: 3206 ft²/gallon at 0.2 mils
VHAPS (theoretical): 2.24%
VHAP Wt./Vol. Solids: 0.86 lbs./solid gal.
Shelf Life: 6 weeks (Material over 6 weeks old must be re-checked for settling and for conformance to this PDS, and should be used only with the permission of AkzoNobel.)
Storage: Recommend inside storage of 35°F to 90°F.
Clean-Up Solvents: MEK
Package Viscosity: 50 - 60 sec., #4 Zahn, 77°F

Application Details: **Application Viscosity:** As required
Suggested Reducers: Butyl Cellosolve or MEK
Substrate: HDG or CRS
Pretreatment: E-CLPS 2950SI*
Primer: N/A
Suggested PMT: 465 - 490°F
Application Method: Reverse roll coater
Dry Film Thickness:
Primer: 0.15 - 0.25 (0.60 mils wet, at 10% reduction)
Topcoat:
Total: 0.15 - 0.25 mils

Applied Properties: **Color Standard:** N/A
Color Tolerance: N/A
Gloss @ 60°: 0 - 5%
Pencil Hardness: N/A
Solvent Resistance: 10 double rubs, MEK
Impact: 80 inch-pounds, reverse, NTO
Flexibility: 2T, NTO

Additional Remarks: *This pretreatment is granted provisional acceptance, pending satisfactory completion of the provisional period for the pretreatment under current line conditions. Use of this primer with dried-in-place pretreatment is not recommended. This cautionary remark can be disregarded when this product is used on the back side.

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This Product Data Sheet ("PDS") does not contain any data warranted by AkzoNobel. However, it does contain information needed to protect any AkzoNobel limited warranty which might apply to the product. This PDS describes certain mandatory guidelines for application of the product to the metal. Failure to comply with those guidelines voids any AkzoNobel limited warranty. This PDS also describes the characteristics that the product should exhibit immediately before and after coating. If the product does not exhibit these characteristics, use of the product should immediately cease, and AkzoNobel's sales or technical service representative should be contacted.

