

VP50 Series Low VOC Epoxy Primer/Sealer



DESCRIPTION

VP50 Series are epoxy primers formulated for excellent adhesion, durability, water and corrosion resistance in a versatile, productive system. VP50 meets national air quality regulations and may be mixed in either a 2.8 or 3.5 VOC.



COMPONENTS

- VP50. . . . Buff Epoxy Primer
- VP51. . . . Black Epoxy Primer
- VP54. . . . White Epoxy Primer
- VP55. . . . Gray Epoxy Primer
- VP57. . . . Yellow Epoxy Primer
- VPC50 . . Epoxy Activator
- VPC5X. Fast Epoxy Activator
- 171. Fast Reducer up to 75°F (24°C)
- 172. Medium Reducer 75-85°F(24-29°C)
- 173. Slow Reducer 85-95°F(29-35°C)
- 174. Very Slow Reducer 95°F(35°C) plus
- X01/X02. Fast/ Medium Exempt Reducer

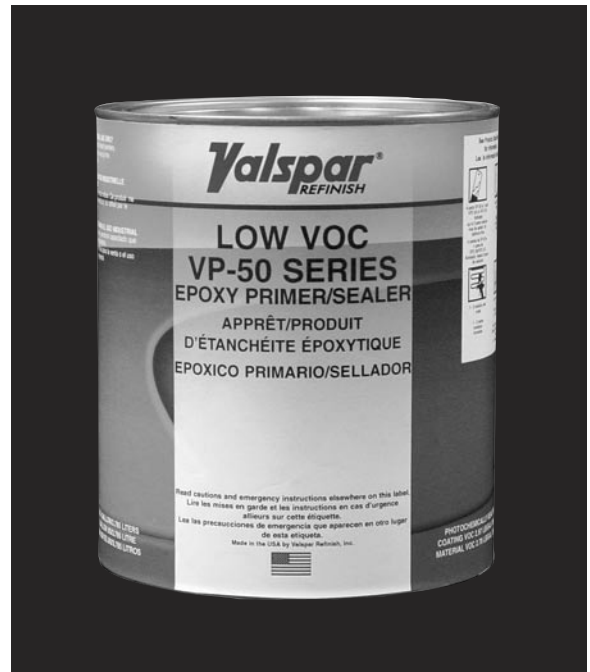


MIXING RATIO

National Rule: For use as a primer mix 4 parts VP50 Series color with 1 part VPC50 or VPC5X and reduce with 1 part urethane reducer (170 Series) (4:1:1). When used as a sealer add an additional part of urethane reducer (4:1:2).

3.5 VOC: For use as a primer mix 4 parts VP50 Series color with 1 part VPC50 or VPC5X and reduce with 1 part urethane reducer (170 Series) (4:1:1). When used as a sealer add an additional part X01 or X02 Reducer (4:1:1:1).

2.8 VOC: For use as a primer mix 4 parts VP50 Series color with 1 part VPC50 or VPC5X and reduce with 1 part X01 or X02 Reducer (4:1:1). When used as a sealer add an additional part X01 or X02 Reducer (4:1:2).



POT LIFE @ 77°F (25°C)

6 hours



ADDITIVES

ACCELERATOR: DO NOT USE

FISHEYE: N/A

FLEX ADDITIVE: Not Required

Note: Do not spray when surface temperature is below 50°F (10°C).



SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.



- Wipe surface with 155 Surface Cleaner or 170 AquaClean and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with 240 grit sandpaper or equivalent.
- Clean surface with 155 Surface Cleaner (not recommended as final wipe for aluminum substrates) or 170 AquaClean and wipe dry with clean cloth before product flashes.



CLEAN UP

Valspar Refinish 100 Thinner
(Check local regulations)

VP50 Series Low VOC Epoxy Primer/Sealer



SUBSTRATES

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel
- Properly cleaned and sanded fiberglass and SMC
- Properly cleaned and sanded OEM finishes
- **Do Not Apply Over 88 Sunlock or V880**



APPLICATION

- Spray one to two medium wet coats allowing 15-20 minutes between coats.



FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash Time	15-20 Minutes
To Sand	3-4 Hours
To Topcoat w/VPC50 activator	2 Hours
To Topcoat w/VPC5X activator	30 Minutes



FORCE DRY @ 140°F (60°C)

To Topcoat with VPC50	30 Minutes
To Sand after cool down	60 Minutes
To Topcoat without sanding	24 Hrs. (max)



INFRARED CURE

See Infrared Curing Information on pages 78



GUN SETUPS

CONVENTIONAL

Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.6 mm - 2.0 mm

HVLP

Gravity Feed	1.3 mm - 1.8 mm
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AIR PRESSURES

Conventional @ Gun

	PANEL	OVERALL
Gravity Feed	30-40 psi	35-45 psi
Siphon Feed	35-45 psi	40-50 psi
HVLP @ Cap	6-8 psi	8-10 psi

PHYSICAL DATA

VOC	2.8 VOC - 4.3 VOC depending on mix ratio
Volume Solids	As primer 47.5%
.....	As sealer 40.7%
Theoretical Coverage	As primer 763 sq. ft. per mil per gallon
.....	As sealer 654 sq. ft. per mil per gallon
Recommended DFT	As primer 1.0 - 6.0 mils
.....	As sealer 0.5 - 2.0 mils
Zahn #2 Viscosity (RTS)	As primer 24 - 26 seconds
.....	As sealer 22 - 24 seconds