

SPECTRACRON® 591 Wet-on-Wet Epoxy Primers are two-component, high hiding, low VOC, corrosion resistant epoxy primers designed for properly prepared metal surfaces. The *Spectracron* 591 Series can be topcoated with any of the *Spectracron* Polyurethanes with as little as a 15 minute flash.

Substrates

- Cold rolled steel
- Hot rolled steel
- Aluminum
- Plastics¹

Suggested Topcoats

- *Spectracron* branded epoxy and urethane topcoats

End Use Markets

- Agricultural equipment
- Heavy duty equipment
- Industrial equipment
- Transportation

Product Codes

- QAP591 – Gray

Product Highlights

- More surface tolerant than traditional epoxies
- Wet-on-Wet application
- High-hiding formulation
- Excellent corrosion resistance
- Can be used over zinc rich primers
- Excellent flexibility
- VOC 3.5 lbs./gal. (420 g/L)
- HAPS 0.2 lbs./gal. (24 g/L)

Physical Properties

Property	Blended Value
Solids % by weight	59.5 ± 2.0
Solids % by volume	38.4 ± 2.0
Weight / Gallon	10.9 – 11.3 lbs./gal. (1308 – 1356 g/L)
Coverage @ 1 mil, 100% TE	600 – 630 ft. ² /gal. (56 – 59 m ² /3.785L)
60° Gloss	30 – 75
VOC (less exempts)	3.5 lbs./gal. (420 g/L)
VOC (actual)	2.5 lbs./gal. (300 g/L)
Shelf life	2 years (each component)

Performance Properties

Test	Result*
Pencil hardness	F – 3H
Conical mandrel (1/8")	Pass
Adhesion	4B
Salt Spray	750 hours
Humidity	1000 hours

*results obtained over iron phosphate CRS panels



SPECTRACRON® 591 Series

Wet-on-Wet Epoxy Primer

Substrate Protection

The surface must be clean and free of all surface contamination. A chemical pretreatment such as PPG Chemfos® KA Cleaner/Coater or a similar conversion coating will improve the performance properties of the coating system. See your PPG Representative for recommendations.

Cure Schedule

Paint film is not fully cured for 7 days. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.

Physical Properties

Air Dry Times²

To Touch	30 – 40 min.
To Handle	1 – 2 hours
To Topcoat	15 min. to 14 days, must be abraded after 14 days

Force Dry Times

Flash Time	10 – 15 min. (ambient)
Temperature	Up to 180°F (82°C)
Time at Temperature	15 – 20 min.

Mix Directions

Blend Ratio ³	4.5:1 with QAP592
Pot Life	1.5 – 2 hours
Reduction ⁴	Not recommended, but can use Q30, Q50, Q160, Q80 or TFS Blends
Application Viscosity	As blended
Line/Flush Clean Up	Q60 or TFS909

Application

Equipment	Conventional, HVLP, airless, air-assisted airless
Recommended Wet Film Build	3.9 – 5.2 mils 99 – 132 microns
Recommended Dry Film Build	1.5 – 2.0 mils 38 – 51 microns

Additional Information

In-Service Temperature: 200°F (93°C)
Do not apply at temperatures below 50°F (10°C)
Protect from freezing

Footnotes

1. Due to the variability in plastic substrates, it's highly recommended to test adhesion on a small sample before application.
2. Excess film thickness will retard dry times and affect the recoat window.
3. No-mixing or improper mixing can result in performance issues and curing issues.
4. Use of a reducer other than Q30 or TFS321-50 will increase VOC above 3.5 lbs./gal.

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PPG TRUEFINISH® Industrial Coatings, One PPG Place Pittsburgh, PA 15272, 1.866.PPG.TRUE

