

## 501 Series

## 1K HS Epoxy-Ester Primer

SPECTRACRON® 501 Series 1K HS Epoxy Ester Primers are low VOC single component primers recommended for industrial use on properly prepared metal surfaces. Without moving to a two-component system, Spectracron 501 Series primers can provide good filling properties and strong corrosion resistance.

### Substrates

- Blasted steel
- Cold rolled steel
- Hot rolled steel
- Aluminum
- Plastics<sup>1</sup>
- Fiberglass<sup>1</sup>

### Suggested Topcoats

- Spectracron branded alkyd topcoats

### End Use Markets

- Metal fabrication
- Structural steel
- Building materials
- Heavy duty equipment
- Agricultural equipment
- Transportation and trailer

### Product Codes

- QAP501 – Gray

### Product Highlights

- One-component epoxy
- Good filling properties
- Non chrome pigments
- Very good corrosion protection
- VOC <3.5 lbs. /gal. (420 g/L)
- Strong adhesion

### Physical Properties

Property	Value
Solids % by weight	72.2 ± 2.0
Solids % by volume	51.9 ± 2.0
Weight / Gallon	10.0 – 10.2 lbs. /gal. (1200 – 1248 g/L)
Coverage @ 1 mil, 100% TE	800 – 865 ft. <sup>2</sup> /gal. (74 – 80 m <sup>2</sup> /3.785L)
60° Gloss	25
VOC (less exempts)	3.5 lbs./gal. (420 g/L)
VOC (actual)	3.5 lbs./gal. (420 g/L)
HAPS	<0.4 lbs. /gal. (48 g/L)
Shelf life	2 years

### Performance Properties

Test	Result*
Pencil hardness	F
Conical mandrel (1/8")	Pass
Adhesion	4B – 5B
Salt Spray	250 hours
Humidity	100 hours

\*results obtained over iron phosphate CRS panels



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### 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 Times<sup>2</sup>

To Touch	30 – 45 min.
To Handle	1 – 2 hours
To Topcoat	After 1 hour to 7 days

#### Force Dry Times

Flash Time	10 min. (ambient)
Temperature	Up to 160°F (71°C)
Time at Temperature	10 – 20 min.

### Mix Directions

Reduction	Not recommended, but can use Q70 if needed
Application Viscosity	As blended
Line/Flush Clean Up	Q80 or Q60

### Application

Equipment	Conventional, HVLP, air-assisted airless, airless
Recommended Wet Film Build	2.0 – 3.0 mils 51 – 76 microns
Recommended Dry Film Build	1.0 – 1.5 mils 25 – 38 microns

### Additional Information

In-Service Temperature: 220°F (104°C)
Do not apply at temperatures below 50°F (10°C)
Protect from freezing
Not recommended for use on galvanized, galvaneal or zinc rich surfaces

#### Footnotes

1. Due to the variability in plastic and fiberglass 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.

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