

### Substrates

- Blasted steel
- Cold rolled steel
- Hot rolled steel
- Aluminum
- Galvanneal

### Suggested Topcoats

- *Spectracron* branded epoxy and urethane topcoats

### End Use Markets

- Custom coaters
- Material handling
- Fabricated metal
- Agricultural equipment
- Transportation

### Product Codes

- QAP531 - Gray
- QAP531-WHT - White

SPECTRACRON® 531 Series High Build 2K Epoxy Primers are two-component primers recommended for use on properly prepared metal substrates where high build and smooth finishes are required. Properties include excellent adhesion, toughness and corrosion resistance when blended with the appropriate cross-linker.

### Product Highlights

- Ideal for manual mix and plural component equipment
- High build, smooth finish
- Excellent chemical and corrosion resistance
- Long 8 hour pot life with no induction time
- 1:1 Mix ratio
- Fast topcoat and handle times

### Physical Properties

Property	Blended Value
Solids % by weight	57.8 ± 2.0
Solids % by volume	38.9 ± 2.0
Weight / Gallon	10.0 – 11.0 lbs. /gal. (1200 – 1320 g/L)
Coverage @ 1 mil, 100% TE	589 – 649 ft. <sup>2</sup> /gal. (55 – 60 m <sup>2</sup> /3.785L)
60° Gloss	<10
VOC (less exempts)	4.5 lbs. /gal. (540 g/L)
VOC (actual)	4.5 lbs. /gal. (540 g/L)
HAPs	3.2 lbs. /gal. (384 g/L)
Shelf life	2 years (each component)

### Performance Properties

Test	Result*
Pencil hardness	2H
Conical mandrel (1/8")	Pass
Adhesion	5B
Salt Spray	700 hours
Humidity	500 hours

\*results obtained over iron phosphate CRS panels



# SPECTRACRON® 531 Series

## High Build 2K 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 Times<sup>1</sup>

To Touch	45 min.
To Handle	3 hours
To Topcoat	30 – 45 min., 21 day max

#### Force Dry Times

Flash Time	10 min. (ambient)
Temperature	Up to 160°F (71°C)
Time at Temperature	20 – 30 min.

### Mix Directions

Blend Ratio <sup>2</sup>	1:1 with QAP532
Pot Life	8 hours
Reduction	Q30, Q50, Q160, Q80 or TFS Blends as required for acceptable application and desired film build
Line/Flush Clean Up	Q80 or Q70

### Application

Equipment	Conventional, HVLP, airless, air-assisted airless
Recommended Wet Film Build	5.0 – 12.0 mils 127 – 305 microns
Recommended Dry Film Build	2.0 – 5.0 mils 51 – 127 microns

### Additional Information

In-Service Temperature: 300°F (149°C)
Do not apply at temperatures below 50°F (10°C)
Protect from freezing

#### Footnotes

1. Excess film thickness will retard dry times and affect the recoat window.
2. No-mixing or improper mixing can result in performance issues and curing issues.

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