



## GENERAL INFORMATION

VP50 is an Epoxy Primer formulated for excellent adhesion, durability, water and corrosion resistance in a versatile, productive system.



## 1. COMPONENTS

- VP50 Epoxy Primer Buff
- VPC50 Epoxy Activator
- VPC5X Fast Epoxy Activator
- X01/X02 Fast/Medium Uni-Solvent LV
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- 173 Slow Uni-Solvent 85°-95°F (29°-35°C)
- 174 Very Slow Uni-Solvent 95°F (35°C) and over
- 171HP High Performance Reducer Fast
- 172HP High Performance Reducer Medium
- 173HP High Performance Reducer Slow
- 174HP High Performance Reducer Very Slow



## 2. MIXING RATIO

### PRIMER- 4:1:1 (by volume)

Mix four (4) parts VP50 to one (1) part VPC50 or VPC5X activator and reduced with one (1) part solvents or reducers listed above.

### USA VOC compliant rules:

For VOC 2.8 compliant use Uni-Solvent LV X01 or X02.  
For VOC national rule use solvents or reducers listed above

### SEALER- 4:1:2 (by volume)

Mix four (4) parts VP50 to one (1) part VPC50 or VPC5X activator and reduced with two (2) parts solvents or reducers listed above.

### USA VOC compliant rules:

For VOC 2.8 compliant use Uni-Solvent LV X01 or X02.  
For VOC national rule use solvents or reducers listed above



## 3. POT LIFE @ 77°F (25°C)

6 Hours



## 4. CLEAN UP

Uni-Solvent 171-174 or Uni-Solvent LV X01, X02 (check local regulations).



## 5. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with 155 Surface Cleaner (steel) or 170 AquaClean (steel/aluminum) and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with P320 grit sandpaper or equivalent.
- Clean surface with 155 Surface Cleaner or 170 AquaClean and wipe dry with clean cloth before product flashes.



## 6. 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 Self Etching Primers**



## 7. APPLICATION

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

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



## 8. 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 Hours (max.)

### Note - when applied as a sealer:

After 24 hours, Surface must be scuffed before applying basecoat or topcoat.



## 9. INFRARED CURE

See Infrared Curing Information.



## 10. GUN SET UP

<b>CONVENTIONAL GUN</b>	
Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.6 mm - 2.0 mm
<b>HVLP</b>	
Gravity Feed	1.3 mm - 1.8 mm

### AIR PRESSURES

#### Conventional @ Gun

Gravity Feed	30-40 psi (2.0-2.8 bar)
Siphon Feed	35-45 psi (2.5-3.1 bar)
<b>HVLP Inlet Air</b>	20-30 psi (1.5-2.0 bar)

See spray gun manufacturer info



## 11. PHYSICAL DATA

VOC	2.8 - 4.3 lbs./gal. depending on mix ratio	
	<b>As Primer</b>	<b>As Sealer</b>
Volume Solids	47.5%	40.7%
Theoretical Coverage	763 sq. ft. per mil per gallon	654 sq. ft. per mil per gallon
Recommended DFT	1.0 - 6.0 mils (25-150 µm)	0.5 - 2.0 mils (12-50 µm)
Zahn #2 Viscosity (Din cup 4) (RTS)	24 - 26 Seconds (20 - 22 Seconds)	22 - 24 Seconds (18 - 20 Seconds)