



SPECTRACRON® 531/532 HIGH BUILD 2K EPOXY PRIMER

DESCRIPTION:

SPECTRACRON® 531/532 High Build 2K Epoxy Primer is a two-component primer recommended for use on properly prepared steel or aluminum where high build and smooth finishes are required. Properties include excellent adhesion, toughness and corrosion resistance when blended with the appropriate crosslinker.

HIGHLIGHTS:

- ❖ High build, smooth finish
- ❖ Long pot life, with no induction time
- ❖ Ideal for manual mix and plural component equipment
- ❖ Fast topcoat and handle times

TECHNICAL PROPERTIES:

PROPERTY	METHOD	RESULT*
Colors		Gray (QAP531 & QAP532) Black (QAP531 & QAP532-BLK)
Gloss Range @ 60° Angle	ASTM D523	Low sheen
Pencil Hardness	ASTM D3363	2H
Adhesion	ASTM 3359	5B
Humidity Resistance – 500 Hrs.	ASTM D2247	Pass
Salt Spray Resistance – 700 Hrs.	ASTM B117	Excellent
Chemical Resistance		Excellent
Abrasion Resistance		Excellent
Substrates		Blasted CRS, HRS & Aluminum
Recommended Topcoat(s)		SPECTRACRON: 100, 110, 300, 310, 320, 360, 370, 380, 390, 550, 611**

*These results were obtained over iron phosphated CRS panels.

**QAP531 can be used as a sealer/intermediate coat for QAP611 – Organic Zinc Rich primer.

PHYSICAL PROPERTIES:

PROPERTY	VALUE
Weight per gallon – blended*	10.5 ± 0.5 lbs./gal.
Weight Solids (%) – blended*	57.8 ± 2.0
Volume Solids (%) – blended*	38.9 ± 2.0
VOC – blended* (less exemptions)	4.5 lbs./gal.
VOE – blended* (actual)	4.5 lbs./gal.
Coverage (@ 1 mil, no loss)	589 – 649 sq. ft./gal.
Flash Point:	
SPECTRACRON 531	80°F (27°C)
SPECTRACRON 532	83°F (28°C)
SPECTRACRON 532-BLK	78°F (26°C)
Shelf Life - unopened containers	2 years (each component)

*Blended values listed are for gray (QAP531:QAP532)

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SURFACE PREPARATION:

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.

APPLICATION DATA:

Mixing Instructions:

Gray: 1 part SPECTRACRON 531 (QAP531) : 1 part SPECTRACRON 532 (QAP532)

Black: 1 part SPECTRACRON 531 (QAP531) : 1 part SPECTRACRON 532-BLK (QAP532-BLK)

Mix by volume. Agitate prior to application. No induction time required.

Wet Film Thickness: 5.0 – 12.0 mils

Dry Film Thickness: 2.0 – 5.0 mils

Reducer: Use Q80 (xylene) or TFS999-90 (SPECTRATHIN® Slow Reducer), if needed

Pot Life: 8 hrs. (@77°F & 50% R.H.)

Clean up: Q80 (xylene), Q70 (MAK) or TFS999-90

SPRAY APPLICATION	SPRAY EQUIPMENT*	FLUID PRESSURE (psi)	ATOMIZATION PRESSURE (psi)	FLUID NOZZLE	AIR NOZZLE
Conventional	Binks 2001	20 - 25	45 - 50	66SS (0.070", 1.8mm)	67PB
Conventional	DeVilbiss MBC-510	20 - 25	45 - 50	E (0.070", 1.8mm)	92
Airless	Graco Silver Gun	1500 - 2400	n/a	0.013 - 0.017"	n/a
Air Assisted Airless	Graco G-15	900 - 1300	20 - 40	0.011 - 0.015"	249596
HVLP	DeVilbiss JGHV	20 - 25	50 - 55**	E (0.070", 1.8mm)	83MP

*or equivalent

**atomization pressure should read <10 psi @ the cap

CURE SCHEDULES:

Air-dry (assumes 77°F & 50% Relative Humidity)

To Touch: 45 min.

To Handle: 3 hrs.

To Recoat: 1 hr., 21 day maximum

To Topcoat: 30 – 45 min., 21 day maximum

ADDITIONAL INFORMATION:

- ❖ Do not apply at temperatures below 50°F
- ❖ Excess film thickness will retard dry times and affect recoat and topcoat windows
- ❖ Paint film is not fully cured for 7 days.
- ❖ In-Service Temperature Limit: 200 - 300°F

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CONTACT 1-866-PPG TRUE

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