

**PITTSBURGH® PAINTS**A new generation of paint company
for a new generation.**PITTSBURGH® Paints****94-109 Series****HPC/Industrial Maintenance****PITTSBURGH® Paints Epoxy Fast Dry Primer****Generic Type**

Polyamide-Epoxy Two Component

Tinting and Base Information

Do not tint

94-109

Gram Primer

94-112

Buff Primer

94-128

Component B Catalyst

General Description

Pittsburgh® Paints Epoxy Fast Dry Primer is a fast drying primer for use over properly prepared metal surfaces. This product can also be used as a high build intermediate over zincs and other primers

Recommended Uses

Metal

Features / Benefits

Fully 3.5 VOC compliant
Fast drying primer- recoat in two hours

Limitations of Use

Apply only when air and substrate temperatures are above 40°F (4.4°C) and the surface is at least 5°F (3°C) above the dew point. Avoid painting late in the day when dew or condensation can form or rain is threatening.
Not intended for residential use.

Product Data**Gloss:** Flat**VOC*:** 2.80 lbs/gal 340.00 g/L**Coverage:** 163 to 245 sq ft/gal (15 to 22 sq. m/3.78L)*Note: Does not include loss due to varying application method, surface porosity, or mixing.***DFT:** 4.0 minimum to 6.0 maximum**Weight/Gallon*:** 12.6 lbs. (5.7 kg) +/- 0.5 lbs. (227 g)**Volume Solids*:** 61.0% +/- 2%**Weight Solids*:** 77.7% +/- 2%**Mix Ratio:** One part Comp. A to one part Comp. B**Clean-up:** PPG 97-725 Epoxy Thinner

Results will vary by color, thinning and other additives.

*Product data calculated on mixed 94-109

Drying Time:

To Touch: 30 minutes

To Handle: 2 hours

To Recoat: 2 hours

Dry Time @77°F (°C);

Pot Life: 8 hours**Induction Time:** 30 minutes**In Service Temperature:**

Dry Heat (F): 250° Dry Heat (C): 121°

Flash Point: 94-109 55°F, (12.8°C)

94-128 62°F, (16.7°C)

94-112 59°F, (15.0°C)

HPC/Industrial Maintenance

PITTSBURGH® Paints Epoxy Fast Dry Primer

General Surface Preparation

In VOC regulated areas, all primers and finishes must comply with regional VOC regulations. Surface to be primed must be free of dirt, rust, oil, water, grease, mill scale, stabilizers, loose paint and other contaminants. Recommended minimal surface preparation for metal substrates is Commercial Blast (SSPC-SP6).

HPC Systems in Detail Brochure (H10788) Coating Systems 69-HD, 70-HD, 71-HD

Recommended Primers

none See Surface Preparation

Directions for Use

Agitate both components thoroughly before blending. Add equal volumes of Epoxy Fast Dry Inhibitive Primer Component A to 94-128 Component B Catalyst and blend well. Allow to digest for 30 minutes at paint temperature of 60°F (15°C) or more before using.

Permissible temperatures during application:

Material:	70 to 85°F	21 to 29°C
Ambient:	40 to 100°F	16 to 38°C
Substrate:	40 to 100°F	16 to 38°C

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Application Information

Recommended Spread Rates:

Wet Mils :	6.5	minimum to	10.0	maximum
Wet Microns:	63.5	minimum to	83.8	maximum
Dry Mils :	4.0	minimum to	6.0	maximum
Dry Microns:	38.1	minimum to	50.8	maximum

Application Equipment: Changes in application equipment, pressures and/or tip sizes may be required depending on ambient temperatures and application conditions.

Conventional Spray: JGA or PMBC 510 gun with E tip and needle, 777 air cap. A 64 air cap may be used to reduce dry spray on larger parts.

Airless Spray: Equipment capable of 2000 psi without surge when

Brush: Not Recommended

Roller: Not Recommended.

Thinning:

Not required.

Packaging: 1-Gallon (3.78L) 5-Gallon (18.9L)

Not all products are available in all sizes.



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Additional copies of this bulletin can be obtained from our web site or by calling 1-800-428-7806.

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