



GENERAL INFORMATION

999VPLV is a neutral-colored epoxy primer base designed to give excellent adhesion and corrosion resistance in a productive 2.1 VOC system.



1. COMPONENTS

- 999VPLV Neutral Epoxy Primer
- CPS 1-5 Colorants
- VPC210 Epoxy Activator
- X01/X02 Fast/Medium Exempt Reducers
- 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 above
- LVBF100 Fast LV Reducer up to 80°F (27°C)
- LVBM100 Medium LV Reducer 80°F-90°F (27°C-32°C)
- LVBS100 Slow LV Reducer 90°F (32°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

Mix three (3) parts CPSVPLV to one (1) part CPS 1-5.

PRIMER- 4:1:1 (by volume)

Mix four (4) parts CPSVPLV to one (1) part VPC210 activator and reduced with one (1) part X01, X02 or LVB100 reducers

SEALER- 4:1:2 (by volume)

Mix four (4) parts CPSVPLV to one (1) part VPC210 activator and reduced with two (2) parts X01, X02 or LVB100 reducers



3. POT LIFE @ 77°F (25°C)

6 Hours



4. CLEAN UP

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



5. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with 170 Aqua Clean (steel/aluminum) and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with P220 (Primer) or P320 (Sealer) grit sandpaper or wet equivalent.
- Clean surface with 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
- **Note: Do Not Apply Over Self Etching Primers**



7. APPLICATION

Apply one to three medium wet coats allowing each coat proper flash before applying another to achieve a dry film thickness of 0.5 - 2 mils/10 - 50 µm



8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash Time	10-15 Minutes
To Sand	4 Hours
To Topcoat	30 Minutes
To Topcoat without Sanding	24 Hours (Max.)



9. GUN SET UP

CONVENTIONAL GUN

Gravity Feed 1.6 mm - 1.8 mm
Siphon Feed 1.6 mm - 2.0 mm



HVLP

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)

HVLP Inlet Air

20-30 psi (1.5-2.0 bar)

See spray gun manufacturer info



10. PHYSICAL DATA

RTS REGULATORY DATA	4:1:1 (170 Reducer Line)		4:1:1 (Exempt Reducer Line)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
	Actual VOC	3.0 Max.	360 Max.	1.4 Max.
Regulatory VOC (less water and exempt solvents)	3.5 Max.	420 Max.	2.1 Max.	250 Max.
Density	9 - 13	1080 - 1560	9 - 13	1080 - 1560
	WT. %	VOL. %	WT. %	VOL. %
Total Volatile Content	40 - 60	55 - 75	40 - 60	55 - 75
Water Content	0	0	0	0
Exempt Compound Content	15 - 35	15 - 35	35 - 55	35 - 55

RTS REGULATORY DATA	4:1:2 (170 Reducer Line)		4:1:2 (Exempt Reducer Line)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
	Actual VOC	3.44 Max.	413 Max.	1.04 Max.
Regulatory VOC (less water and exempt solvents)	4.6 Max.	550 Max.	2.1 Max.	250 Max.
Density	9 - 13	1080 - 1560	9 - 13	1080 - 1560
	WT. %	VOL. %	WT. %	VOL. %
Total Volatile Content	50 - 60	65 - 75	50 - 65	65 - 75
Water Content	0	0	0	0
Exempt Compound Content	20 - 35	25 - 35	40 - 60	50 - 65