



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

- CPSVPLV Neutral Epoxy Primer
- CPS 1-5 Colorants
- VPC210 Epoxy Activator
- X01/X02 Fast/Medium Exempt Uni-Solvent
- 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



2. MIXING RATIO

Mix three (3) parts CPSVPLV to one (1) part CPS 1-5.
 Mix four (4) parts CPSVPLV tinted primer to one (1) part VPC210 Activator and reduce with one (1) part X01 or X02 for a 2.1 VOC product or with 171-174 Urethane reducers for 3.3 VOC (4:1:1).



3. POT LIFE @ 77°F (25°C)

6 Hours



4. CLEAN UP

Valspar Refinish 100 Thinner, VL10 Wash Thinner, or X01 Series Uni-Solvent (check local regulations).



5. ADDITIVES

ACCELERATOR: DO NOT USE
 FISHEYE: N/A
 FLEX ADDITIVE: Not Required
NOTE: Do not spray when surface temperature is below 50°F (10°C).



6. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse until water "sheets".
- Sand 320 or red scuff pad.
- Wipe with 170 making sure product is wiped off before flashing dry.



7. 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 88G016 or V880**



8. 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.



9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash Time	10 Minutes
To Sand	4 Hours
To Topcoat	30 Minutes



10. GUN SET UP

CONVENTIONAL GUN

Gravity Feed 1.6 mm - 1.8 mm

Siphon Feed 1.6 mm - 1.8 mm



HVLP

Gravity Feed 1.3 mm - 1.6 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed

Siphon Feed

HVLP @ Cap

PANEL

30-35 psi

35-45 psi

6-8 psi

OVERALL

35-45 psi

45-50 psi

8-10 psi



11. PHYSICAL DATA (4:1:1) Base Color (Reduced with X01)

Density	10.61 lbs./gal. (Average)
VOC	1.67 lbs./gal. (Average)
Weight Solids	49.88% (Average)
Volume Solids	36.01% (Average)
Recommended DFT	0.5 - 2.0 mils.
Zahn #2 Viscosity (RTS)	21 - 23 Seconds
Flash Point	-4°F