



GENERAL INFORMATION

VP50 is an Epoxy Primer formulated for excellent adhesion, durability, water and corrosion resistance in a versatile, productive system. VP50 meets national air quality regulations and may be mixed in either a 2.8 or 3.5 VOC.



1. COMPONENTS

- VP50 Epoxy Primer Buff
- VPC50 Epoxy Activator
- VPC5X Fast 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 over



2. MIXING RATIO

National Rule: For use as a primer mix four (4) parts VP50 with one (1) part VPC50 or VPC5X and reduce with 1 part Urethane Uni-Solvent (170 Series) (4:1:1). When used as a sealer add an additional part of Urethane Uni-Solvent (4:1:2).

3.5 VOC: For use as a primer mix four (4) parts VP50 with one (1) part VPC50 or VPC5X and reduce with 1 part Urethane Uni-Solvent (170 Series) (4:1:1). When used as a sealer add an additional part X01 or X02 Uni-Solvent (4:1:1:1).

2.8 VOC: For use as a primer mix four (4) parts VP50 with one (1) part VPC50 or VPC5X and reduce with 1 part X01 or X02 Uni-Solvent (4:1:1). When used as a sealer add an additional part X01 or X02 Uni-Solvent (4:1:2).



3. POT LIFE @ 77°F (25°C)

6 Hours



4. CLEAN UP

Valspar Refinish 100 Thinner (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 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 360 grit sandpaper or equivalent.
- Clean surface with 155 Surface Cleaner or 170 AquaClean and wipe dry with clean cloth before product flashes.



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

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



9. 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.

10. INFRARED CURE

See Infrared Curing Information.



11. 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

Siphon Feed

HVLP @ Cap

PANEL

30-40 psi

35-45 psi

6-8 psi

OVERALL

35-45 psi

40-50 psi

8-10 psi



12. PHYSICAL DATA

VOC	2.8 - 4.3 lbs./gal. depending on mix ratio	
	As Primer	As Sealer
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	0.5 - 2.0 mils
Zahn #2 Viscosity (RTS)	24 - 26 Seconds	22 - 24 Seconds