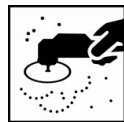


VEP-100 EPOXY PRIMER GREY

Valorem VEP-100 Epoxy Primer Grey provides the adhesion and anti-corrosion characteristics that are important to a long-lasting repair. Valorem VEP-100 can be used as a primer sealer, primer surfacer, or as a foundation to other materials such as polyester body filler.

**SAFETY CONSIDERATIONS**

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.

**SURFACE PREPARATION**

- Existing finishes – #P320 to #P400 sandpaper dry
- Polyester body filler – #P150 to #P220 sandpaper dry
- Bare Steel – Final sanded with #P120 sandpaper dry
- Zinc coated steel – Red scuff pad
- Aluminum (5052) – #P150 to #P220 sandpaper dry

**SURFACE CLEANING**

- Use suitable surface cleaners and technique to ensure a clean surface.



BY VOLUME

MIXING – AS A WET-ON-WET SEALER**Mix**

- | | |
|----------|---|
| 3 | Parts Valorem VEP-100 Epoxy Primer Grey |
| 1 | Part Valorem VH-101 Epoxy Hardener |
| 1 | Part Valorem Epoxy Reducer (VR-102 or VR-103) |

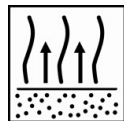
✓ Other mixing ratios are available, see the complete TDS for detailed information.

**EQUIPMENT****Spray-Gun Set-Up for Sealer Mix: Application Air Pressure:**

- 1.3 – 1.5 mm HVLP Gravity – HVLP – 10 psi (<0.7 bar) at cap maximum
- 1.3 – 1.5 mm Compliant Gravity – Consult manufacturer specifications.

**APPLICATION**

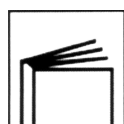
- Apply one to two single flowing coats.

**FLASH OFF****Flash Between Coats at 70°F (21°C)**

- 10 minutes

**FLASH AT 70°F (21°C) BEFORE TOPCOATING**

- 30 – 45 minutes
- Maximum 7 days at ambient temperature and protected from outside elements.
- *Dependent on film weight and air flow*

**RECOATING**

- Valorem VEP-100 Epoxy Primer Grey as a sealer may have polyester body filler or Valorem basecoats or topcoats applied.

Read the complete TDS and the product Safety Data Sheet (SDS) for detailed product information

VEP-100 EPOXY PRIMER GREY**DESCRIPTION**

Valorem VEP-100 Epoxy Primer Grey provides the adhesion and anti-corrosion characteristics that are important to a long-lasting repair. Valorem VEP-100 can be used as a primer sealer, primer surfacer, or as a foundation to other materials such as polyester body filler.

**PRODUCT ASSORTMENT**

- Valorem VEP-100 Epoxy Primer Grey – Item #594464 (Quart)
- Valorem VH-101 Epoxy Hardener – Item #594467 (Quart)
- Valorem VR-102 Epoxy Reducer – Item #595969 (Quart)
- Valorem VR-103 Epoxy Reducer 2.1 – Item #596344 (Quart)
- Stock unopened or used products in approved closed containers with proper labeling. Store in temperatures between 40°F - 95°F (5°C – 35°C). Avoid too much temperature fluctuation. Optimum storage temperature is approximately 70°F (21°C).
- Shelf-life: VEP-100 (2 years), VH-101 (1 year), VR-102, VR-103 (2 years).
 - Refer to the price list for the most up-to-date shelf-life information.

**SURFACE PREPARATION****Substrate**

- Blasted steel
- Sanded steel
- Galvanized steel
- Aluminum (5052)
- Polyester body filler
- Fiberglass gelcoat (unbroken)
- Existing finishes (except acrylic lacquers)

Preparation

- Blow off to remove dust and debris
- Final sand with #P120 sandpaper dry
- Scuffed with a red scuff pad
- #P150 to #P180 sandpaper dry
- #P150 to #P220 sandpaper dry
- #P220 to #P320 sandpaper dry
- #P320 to #P400 sandpaper dry



- ✓ The minimum film thickness required over a blasted profile is >1.5 mils (>38 µm) for suitable protection.
- ✓ Adhesion and anti-corrosion performance can be enhanced by pre-coating metal surfaces with Valorem VPT-24 Pretreatment Wipe material before priming.
- ✓ Aluminum grades other than 5052 should be tested prior to refinishing.

**Surface Cleaning**

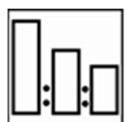
- Use suitable surface cleaners and technique to ensure a clean surface.

**MIXING****Mix****3****1****High Build Surfacer Ratio**

Parts Valorem VEP-100 Epoxy Primer Grey

Part Valorem VH-101 Epoxy Hardener

BY VOLUME

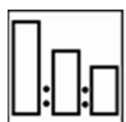
**Mix****3****1****0.5****Medium Build Wet-on-Wet Ratio**

Parts Valorem VEP-100 Epoxy Primer Grey

Part Valorem VH-101 Epoxy Hardener

Part Valorem Epoxy Reducer (VR-102 or VR-103)

BY VOLUME

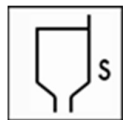
**Mix****3****1****1****Wet-on-Wet Sealer Ratio**

Parts Valorem VEP-100 Epoxy Primer Grey

Part Valorem VH-101 Epoxy Hardener

Part Valorem Epoxy Reducer (VR-102 or VR-103)

BY VOLUME

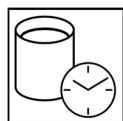
VEP-100 EPOXY PRIMER GREY

EZ ZAHN #3

VISCOSITY – READY TO SPRAY AT 70°F (21°C)

11.5 – 13.5 Seconds
9 – 11 Seconds
7.5 – 9.5 Seconds

3:1 High Build Surfacer
 3:1:0.5 Medium Build Wet-on-Wet
 3:1:1 Wet-on-Wet Sealer

**POT-LIFE WHEN MIXED****Product Mix**

- Valorem VEP-100 Epoxy Primer Grey
- ✓ A shorter pot-life can be expected in higher temperatures.

At 70°F (21°C)
 4 hours

**SPRAY-GUN SET-UP****Spray-Gun Set-Up (3:1 Ratio)**

- 1.7 – 1.9 mm HVLP Gravity
- 1.5 – 1.7 mm Compliant Gravity

Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap, maximum.
- Consult manufacturer specifications.

Spray-Gun Set-Up (3:1:0.5 Ratio)

- 1.5 – 1.7 mm HVLP Gravity
- 1.5 – 1.7 mm Compliant Gravity

Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap, maximum.
- Consult manufacturer specifications.

Spray-Gun Set-Up (3:1:1 Ratio)

- 1.3 – 1.5 mm HVLP Gravity
- 1.3 – 1.5 mm Compliant Gravity

Application Air Pressure:

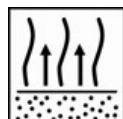
- HVLP – 10 psi (<0.7 bar) at cap, maximum.
- Consult manufacturer specifications.

**APPLICATION****3:1 High Build Surfacer Mix**

- Apply two single flowing coats.
- Allow a 10-minute flash between coats.

3:1:0.5 or 3:1:1 Wet-on-Wet Mix

- Apply one or two single flowing coats.
- Allow a 10-minute flash between coats.

**FLASH DRYING****Flash Between Coats at 70°F (21°C)**

- 10 minutes

Flash at 70°F (21°C) Before Topcoating

- 30-45 minutes (7 days maximum)

- ✓ Flash time is dependent on temperature and application.
- ✓ Polyester body filler products: Flash dry for a minimum of 1 hour (maximum 7 days) before applying.
- ✓ Maximum times are based on the object maintaining an ambient temperature status and preventing extended exposure to the outside elements.

**DRYING / CURING – 3:1 HIGH BUILD SURFACER MIX****Drying / Curing at 70°F (21°C)**

- 24 Hours dry to sand.

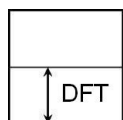
Drying / Curing at 140°F (60°C)

- 1 – 1½ hours dry to sand.

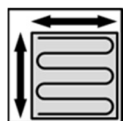
- ✓ Drying times are stated at recommended application method, film thickness, and object temperature.

VEP-100 EPOXY PRIMER GREY**RECOATING**

- After observing proper flash time, Valorem VEP-100 Epoxy Primer Grey may be recoated with Valorem surfacers, sealers, basecoats, and topcoats. It may also be recoated with most polyester body filler products.

**FILM THICKNESS – USING SUITABLE APPLICATION**

- 1 coat of VEP-100 Epoxy mixed 3:1 as a surfacer – 1.5-1.8 mils (38-45 μ m) dry.
- 1 coat of VEP-100 Epoxy mixed 3:1:0.5 or 3:1:1 as a wet-on-wet sealer – 1.2-1.5 mils (30-38 μ m) dry.
- The minimum total thickness required over sanded metals or a blasted metal profile is >1.5 mils (>38 μ m) for adequate protection and appearance.

**THEORETICAL COVERAGE**

- With the recommended application, the theoretical material usage at a 1 mil thickness (25.4 μ m).
 - VEP-100 High Build Mixed 3:1 \approx 780 ft²/gallon (19.2m²/liter)
 - VEP-100 Wet-on-Wet 3:1:0.5 \approx 694 ft²/gallon (17.0m²/liter)
 - VEP-100 Wet-on-Wet 3:1:1 \approx 624 ft²/gallon (15.3m²/liter)
- Actual coverage is dependent on many factors. These may include the shape of the object, surface smoothness, application technique, and other application variables.

**VOC / REGULATORY INFORMATION**

- Notice: Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

Valorem VEP-100 Epoxy Primer Grey Ready to spray VOC:

Product Mix	lb/gal	g/l
Epoxy Primer Grey High Build (3:1)	\leq 2.1	\leq 250
Epoxy Primer Grey with VR-102 Epoxy Reducer (3:1:0.5)	\leq 2.8	\leq 326
Epoxy Primer Grey with VR-102 Epoxy Reducer (3:1:1)	\leq 3.2	\leq 384
Epoxy Primer Grey with VR-103 Epoxy Reducer (3:1:0.5)	\leq 2.1	\leq 250
Epoxy Primer Grey with VR-103 Epoxy Reducer (3:1:1)	\leq 2.1	\leq 250

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FOR PROFESSIONAL USE WITH SUITABLE HSE EQUIPMENT

IMPORTANT NOTE The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Safety Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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