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# TECHNICAL DATA SHEET

## EP210 2.1 VOC HB EPOXY PRIMER

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EP210 is a high build Epoxy Primer with multiple VOC capabilities, depending on the catalyst and reducer used. It has been formulated for excellent adhesion and corrosion resistance when used on various types of substrates including properly prepared steel and aluminum. EP210 is compliant with all applicable air regulations including Rule 1151 in the SCAQMD when used with EX21 or EX405



### COMPONENTS

- EP210 Series
  - EX21/EX355/EX405
  - S9860/9870/9885/9895
  - S065/S075/S085
- Epoxy Catalyst  
Fast/Medium/Slow/Very Slow Reducers  
Fast/Medium/Slow Zero VOC Reducers



### MIXING RATIO

Catalyst	Reducer	VOC	Mixing Ratio (base:catalyst:reducer)
EX21/EX405	S065/S075	2.1	1:1: 50%-1
EX355/EX405	S9860/S9870/S9885/S9895	3.5	1:1: 50%-1

\*Stir product while adding reducer to mixture\*  
May be reduced 50%-1 with S9860/S9870/S9885/S9895 reducers for National Rule compliance.  
May be reduced 50%-1 with S065 or S075 for 2.1 Low VOC



### POT LIFE

2 hours @ 77° F/25° C



### CLEAN UP

Use NORTHSTAR Lacquer Thinner or zero VOC solvents. (Check local regulation)



### PHYSICAL DATA

Solids wt. (as mixed) 42-47%  
VOC as mixed 2.1-3.5  
Color Dark Gray, Medium Gray (MG), Light Gray (LG), White (W), Black (B), Red (R), Cat. Yellow (CAT)



### DRY / FLASH TIMES

Air Dry at 77° F/25°C  
Flash between coats 15-45 minutes  
To sand @ 77°F with EX21 & EX355 = 16-24 hours  
with EX405 = 12 hours  
with EX21 & EX355 = 40-45 minutes  
with EX405 = 15-30 minutes

### Force Dry

Flash time before force dry 15 minute flash  
Force dry time 35 minutes @140° F/60°C



### GUN SETUPS

#### Conventional

Gravity Feed 1.5 mm – 1.8 mm  
Siphon Feed 1.5 mm – 1.8 mm

### AIR PRESSURES

#### Conventional at Gun

Gravity Feed 35-45 psi  
Siphon Feed 40-50 psi  
HVLP at cap 8 – 10 psi



### SURFACE PREPARATION

Use NORTHSTAR Clean Wipe (S10) to clean substrate free of grease, dirt, and foreign contaminants.



### APPLICATION AT 77° F/25°C

- Apply medium wet coats over substrate to desired film thickness
- Allow 15-45 minutes between coats, depending on catalyst used
- Sand after 48 hours when using EX21 or EX355; sand after 24 hours when using EX405
- Clean gun after spraying is completed

**DO NOT REDUCE WITH S085 REDUCER**



### SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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