

PRODUCT CODE: ELPR250

NAME: Envirothane 250 White 2K Primer

DESCRIPTION: ELPR250 is a specially designed non yellowing two-component primer for all interior wood and most plastic substrates. The 2K isocyanate chemistry imparts industry leading adhesion and water resistance for high performance finishing. Once cured and sanded this primer will be ready to finish with a wide variety of 2K or 1K topcoats. Allow 16 hours of cure time. If dye or tannin bleed is visible, a 2nd coat cured for 16 hours may be necessary for stubborn bleed issues.

USES: This product is designed for interior wood finishing applications such as cabinetry, tables, furniture and millwork.

PRODUCT PREPARATION: **Reduction is required for this product in order to give extended pot-life.** Add 12-15% water to the coating before mixing the CAT100-LV hardener into this primer for use.

MIXING RATIOS AND POT LIFE: Recommended mixing ratios are (minimum) 12% water and 10% CAT100-LV by weight. If you use this product without reduction your pot-life will be only **20-30 minutes**. With 12% water the pot-life is approximately 60 minutes after which the viscosity rises sharply until the product gels. Once it begins to kick it kicks hard fast, don't take chances with the pot-life and flush with water to prevent plugging of pumps, etc. Diaphragm pumps that run continuously or material heaters will shorten the pot life as heat reacts with the hardener.

1 GA ELPR250 : 600g ELCAT100-LV (1/2 Container)

4 GA ELPR250 : 2400g ELCAT100-LV (2 Containers)

When adding CAT100-LV, you should be mixing the coating while adding the hardener, you may find it easier to reduce the ELPR250 with water first to allow for faster mixing. Using less ELCAT100-LV (5% by wt.) will give you a slightly longer pot-life (90 minutes) but sacrifices a little in the way of adhesion, cure time and dye/tannin blocking.

SANDING: Substrate should be sanded with at least 180 grit (preferably 320 for any routed-out MDF) or finer sandpaper prior to applying primer. Sand primer with 320 grit sandpaper and fine or super fine sponges. Two coats can be applied same day back-to-back without sanding between and still achieve good adhesion.

**RECOMMENDED
APPLICATION:**

Spray type: Air Assist Airless
Fluid Pressure: 500-700 PSI
Air Pressure: 25 PSI (triggered)
Tips: 06114 or 09114 (Kremlin)
Tips: 410, 510 or 511 (Graco Wagner
etc..)

Spray type: Airless
Fluid Pressure: 1200-2000 PSI
Tips: 408/508, fine finish or ultra finish

Spray type: HVLP (Turbine)
Air Pressure: Max
Needle: 1.5 - 1.8

Spray type: Cup Gun (gravity)
Air Pressure: 30- 40 PSI
Tips: 1.5 - 1.8

Wet Film Build: 4-6 mils
Grams per 1/10 sq. metre: (250x400mm board) 16g - 24g
Number of Coats: 1-2 depending on desired look
Maximum Dry Film Build: 6 mils

Coating Temperature at Application: 20°C (68°F) or higher
*for colder temperatures, add reducer (ELRX010) or warm material prior to spraying

DRYING TIMES:

**Air dry:
(20°C/68°F)**

Dry to Touch 10-20 Minutes
Dry to Sand 2 hours
Dry to Stack 12 Hours

Note: Good gentle air movement (not a hurricane) with a recirculator or fan while parts are drying will reduce dry to sand times by 20-40% with reasonable humidity levels (<65% r.h.). Lower temperatures or higher humidity will extend dry times.

**Conventional Oven:
(40-45°C/104-113°F)**

Dry to Touch 5-10 Minutes
Dry to Sand 20-30 Minutes
Dry to Stack 1-3 Hours

**Sun-Spot IR Cure:
(Recommended)**

Flash off 1-2 Minutes
Direct Cure 5 Minutes @60-70°C (140-160°F)
Rack Cure (Indirect no probe mode) 10-15 Minutes @20%+ power
Cool Down 10-20 minutes
Product is dry to sand (or stack) after cooling

PHYSICAL PROPERTIES:	Specific Gravity:	1.44 ± 2%
	Viscosity:	1600 cps @25°C
	Solids Content:	60% by weight
	Pot Life:	0.5-1.5 hours, see notes
	Flash Point:	>75°C
	VOC's (material):	62 g/L, 0.51 lb/gal
	VOC's (EPA):	183g/L, 1.53 lb/gal

TYPICAL SYSTEMS: **Note: Two coats of PR250 can be applied same day without sanding between.**

Refinish - Over Old Finishes

Substrate: Oak/maple stained cabinets

Prep: Degrease, rinse and sand 180 grit

1 or 2 coats, ELPR250 White 2K Primer

Sand using 320 grit sandpaper and fine or super fine sponges before top coat

1 or 2 coats ELNYW200XX Envirothane 200 White Topcoat

New Finish - Solid Wood Frame with Veneer core

ELPR250 White 2K Primer

Sand using 320 grit sandpaper and/or fine sponge

ELPR250 Envirothane 250 White 2K Primer

Sand using 320 grit sandpaper and fine or super fine sponges before top coat

1 or 2 coats ELNYW200XX Envirothane 200 White Topcoat

Whites or Light Colours:

Substrate: MDF

ELPR250 Envirothane 250 White 2K Primer

Sand using 320 grit sandpaper and/or fine sponge

ELPR250 Envirothane 250 White 2K Primer

Sand using 320 grit sandpaper and fine or super fine sponges before top coat

1 or 2 coats ELNYW200XX Envirothane 200 White Topcoat

Dark Colours:

Substrate: MDF

ELPR250 Envirothane 250 White Primer + 5% 896-9901 Black (makes dark grey)

Sand using 320 grit sandpaper and/or fine sponge

ELPR250 Envirothane 250 White Primer + 5% 896-9901 Black (makes dark grey)

Sand using 320 grit sandpaper and fine or super fine sponges before top coat

1 or 2 coats EL100XX or ELNYC300XX Envirothane 100 or 300 Series tinted to desired colour

CLEANING:

Flush all equipment with water until it runs clear. Built-up coating and deep cleaning can be performed using ELRX110 EnviroKlean WB Cleaner. For best results cleaning tips, aircaps and unpainted parts use ELRX110 for one hour or 10-20 minutes in an Ultrasonic bath (max. temp. 50°C/120°F). Do not leave painted parts (i.e. spray guns) in ELRX110 for more than 20 minutes.

GENERAL INFORMATION:

Use stainless steel equipment for all water based products. When switching between solvent and water based products in the same spray equipment we suggest the following:

From Solvent to Water: Wash with acetone, then wash with water.

From Water to Solvent: Wash with water, then wash with acetone.

Keep containers closed when not in use and keep from freezing.

These products are designed for industrial use only. Please refer to the Safety Data Sheet prior to use.

SHELF LIFE:

12 months in unopened containers

STORAGE:

Store in a tightly closed container at room temperature (18-25°C/64-75°F) and protect from direct sunlight and foreign material. Do not store at temperatures below 5°C/41°F.

Disclaimer: Every reasonable precaution is taken by the manufacturer in the manufacture of our products to ensure that they comply with our standards. The information given herein is correct to the best of our knowledge. Any suggestions made by us covering the use of our products are based on experience and/or tests believed to be reliable. However, because the use of any product of our manufacture is completely beyond our control, including for example, the method and conditions of application, no guarantee or warranty, expressed or implied, is made. Manufacturer's maximum liability shall be to replace such quantity of product determined by our laboratory to be defective. User shall determine the suitability of the product for his intended use and assumes all risk and liability in connection therewith.