



## TECHNICAL DATA SHEET & PROCESS GUIDE

EGC21TT is a multipurpose, DTM, 2K primer surfacer for use as a primer filler, primer surfacer, or a wet-on-wet sealer.

- High solids content
- Easy to sand with great holdout
- Protective sealant properties eliminate the need for an epoxy sealer.
- Tintable with 10% urethane mixing base
- Excellent adhesion direct to metal and over OEM paint, e-coat, fiberglass, most plastics and polyester filler
- Triple Tight Tin fits on a standard mixing bank

Available Colors • Gray

### TECHNICAL DATA



	Base	Mixed 4:1
Viscosity		50 - 70 s/ ZAHN#2
Solid content	72.60%	67.70%
Specific gravity g/cm <sup>3</sup>	1.68	1.54

### APPLICATION GUIDE

Substrates	<ul style="list-style-type: none"> <li>• Original Paint</li> <li>• Galvanized steel*</li> <li>• Aluminum*</li> </ul>	<ul style="list-style-type: none"> <li>• Bare Steel</li> <li>• Polyester Fillers</li> <li>• Most Plastics*</li> </ul>	<ul style="list-style-type: none"> <li>• E-coat</li> <li>• GRP, SMC, Fiberglass</li> </ul>
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#### Tools Required

- EGC89 Solvent Base Degreaser
- HVLP Gravity Gun
- P180 - P600 Grit Sandpaper



#### Surface Preparation

	Bare Steel	Aluminum*	Galvanized*	Original Paint	Body Filler	GRP / SMC / Fiberglass	Polypropylene / most plastics*
							
	EGC89	EGC89	EGC89	EGC89	EGC89	UP2002	UP2002
	P180	P180	P180	P220	P220	P220	P220

**For best results, good preparation is essential:** Clean and degrease removing dirt, oil, grease and wax with a cleaning solution, like **EGC89 Solvent Based Degreaser** or **System 20 Water Based Degreaser** (UP2002) before and after sanding. Dry thoroughly before applying **EGC21TT 4:1 High Solids Primer**.

*\*Aluminum and galvanized steel components must be primed with 1-2 light coats of ACID#8 Acid Etch Primer and allowed to dry for 20 minutes before applying EGC21TT.*









*\*Plastic components must be prepared with a suitable adhesion promoter such as GRIP #4 1K UNIVERSAL ADHESION PROMOTER AEROSOL. Please refer to the product technical data sheets. For best results over plastic parts, use the Primer Surfacer mix ratio 4:1:1.*

#### Hardener Selection


Temperature °F	Hardener
50 - 80°F	EGC33/40
60 - 90°F	EGC32/42
70 - 100°F	EGC31/43



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	Mixing Ratio	High Build Primer	Primer Surfacer	Wet-on-Wet Sealer
	EGC21TT:Hardener	4:1	4:1	4:1
	EGC83 Reducer	—	20%	40%
<b>Mixing by Weight (grams)</b>				
	EGC21TT	200	200	200
	EGC32/42	29.2	29.2	29.2
	EGC83 Reducer	—	26.8	53.6
	<b>Viscosity ZAHN #2 / sec</b>	50 - 70	20 - 22	16 - 18
	Working Pot-Life @ 70°F	1 - 2 hours	1 - 2 hours	2 - 3 hours
	<b>Compliant HVLP Gravity Gun</b>			
	Gun tip size	1.7 - 2.0 mm	1.4 - 1.7 mm	1.3 - 1.4 mm
	Air Pressure at the gun	26 - 29 PSI	26 - 29 PSI	26 - 29 PSI
	<b>Coats</b>	1 - 2 coats	2 - 3 coats	1 - 2 coats
	Dry Film Build	180 µm (7 MIL)	100 - 120 µm (4 - 5 MIL)	30 - 60 µm (1 - 2 MIL)
	<b>Flash-off @ 70°F</b>			
	Between coats	15 mins	10 mins	10 mins
	<b>Drying Times</b>			
	Sandable @ 70°F	3 - 4 hours	3 - 4 hours	2 - 3 hours
	Sandable @ 140°F	20 - 30 mins	20 - 30 mins	20 - 30 mins
	Sandable IR @ 140°F	15 mins	15 mins	15 mins
	<b>Sanding</b>			
	Dry Sanding / Abrasive	P320 - P400	P500 - P600	P500 - P600 if required
	Wet Sanding / Abrasive	P320 - P400	P500 - P600	P500 - P600 if required
	<b>Over Painting</b>			
	EGC21TT can be directly topcoated with most solvent and water-based basecoats or solid colors.			

## STORAGE & VOC INFORMATION

	<b>Shelf Life</b>	2 years from date of manufacture in sealed original containers.		
	<b>Recommended Storage Temperature</b>	40°F - 75°F		
	<b>Recommended Application Temperature</b>	As per the Hardener Selection table above		
	<b>Equipment Cleaning</b>	Clean gun Immediately after use with EGC reducer or gunwash.		
<b>Important Remarks</b>		Do not use activated product beyond pot life. Activated material should not be returned to the original can of non-activated material. After 10 minutes standing, the coating may need mild agitation to reliquify before 2nd and 3rd coat applications.		



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	EGC21TT - GRAY As Packaged		As Applied 4:1 with EGC32 Standard Hardener	
 <b>VOC Regulatory</b>	400 g/l	3.34 lbs/gal	445 g/l	3.7 lbs/gal
<b>VOC Actual</b>	400 g/l	3.34 lbs/gal	445 g/l	3.7 lbs/gal
<b>Percent Solids</b>	72.6% by weight	50.3% by volume	67.7% by weight	46.9% by volume
<b>Volatiles</b>	23.8% by weight		28.8% by weight	
<b>Water</b>	0% by weight	0% by volume	0% by weight	0% by volume
<b>Exempt compounds</b>	0% by weight	0% by volume	0% by weight	0% by volume
<b>HAPS %</b>	11.1% by weight		12.6% by weight	
<b>Density</b>	1684 g/l	14.0 lbs/gal	1544 g/l	12.9 lbs/gal
	As Applied 4:1:1 with EGC32 Standard Hardener and EGC83 Standard Reducer		As Applied 4:1:2 with EGC32 Standard Hardener and EGC83 Standard Reducer	
<b>VOC Regulatory</b>	519 g/l	4.3 lbs/gal	571 g/l	4.8 lbs/gal
<b>VOC Actual</b>	519 g/l	4.3 lbs/gal	571 g/l	4.8 lbs/gal
<b>Percent Solids</b>	63.8% by weight	42.0% by volume	57.9% by weight	36.0% by volume
<b>Volatiles</b>	36.2% by weight		42.1% by weight	
<b>Water</b>	0% by weight	0% by volume	0% by weight	0% by volume
<b>Exempt compounds</b>	0% by weight	0% by volume	0% by weight	0% by volume
<b>HAPS %</b>	15.5% by weight		17.9% by weight	
<b>Density</b>	1434 g/l	12.0 lbs/gal	1356 g/l	11.3 lbs/gal

### REORDER CODE

Order Code	Size	Product
EGC21TT	1 US Gallon Tin	Gray Primer
EGC31	1 QT Tin	Slow Hardener
EGC32	1 QT Tin	Standard Hardener
EGC33	1 QT Tin	Fast Hardener
EGC40	2.5 L Tin	Fast Hardener
EGC42	2.5 L Tin	Standard Hardener
EGC43	2.5 L Tin	Slow Hardener
EGC83	1 US Gallon Tin	Standard Reducer

### IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.

This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. U-POL disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the U-POL website at [WWW.U-POL.COM](http://WWW.U-POL.COM). U-POL is not responsible for the results obtained by others over whose methods we have no control and thereof U-POL is not liable for consequential or incidental damages including loss of profits.

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