



**ZINC RICH EPOXY PRIMER**  
**CORROSION INHIBITING PRIMER: AIR DRY**  
**SERIES E315**

**SANDSTROM**  
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**DESCRIPTION**

E315 Zinc Rich Epoxy Primer is a thermoplastic, air dry coating containing corrosion inhibiting pigments. This air drying material prevents corrosion. It can be applied by spray or dip.

**OUTSTANDING FEATURES/BENEFITS**

- Excellent corrosion protection without the use of toxic heavy metals.

**TYPICAL USES**

- As a corrosion preventative primer over various metals.

**NOTICE**

Before using this product, read all warnings, limitations and safety information printed on the product label, Safety Data Sheet (MSDS) and Technical Data Sheet.

**LIMITATIONS**

- STORE AT TEMPERATURES BELOW 100°F.

COMPOSITION AND PHYSICAL PROPERTIES			
Net Weight per gallon	15.0 – 17.0 lbs./gallon (Theoretical)	Vehicle	Epoxy
Weight Solids	68.0 – 72.0% (Theoretical)	Color	Gray
Volume Solids	28.0 – 32.0% (Theoretical)	Color Stability	Must have top coat for exterior use
VOC	4.85 lbs./gallon	Finish	Flat
Odor	Solvent	Coverage Rate*	477 sq. ft./gallon @ 1.0 mil DFT
Viscosity	75 – 90 K.U. @ 77°F	Recommended Coats	1 – 2
Storage Conditions	40°F to 100°F	Dry Film Thickness	.3 – 1.0 mils
Freeze/Thaw Stability	Stable	Flash Point	52°F
Shelf Life	12 Months from Date of Shipment		
*Actual figures do not include spray loss. Also allow for surface irregularities and porosity, as well as material loss when mixing.			

PERFORMANCE AND FUNCTIONAL PROPERTIES		
Corrosion Protection:	ASTM B117	140+ hours on bare steel

IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY  
 We warrant our products to be free of manufacturing defects and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and are accurate to the best of our knowledge. They are based on technical data we believe to be reliable and are intended for use by persons having skill and "know-how" at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION, THE DATA ON WHICH IT IS BASED OR THE RESULTS OBTAINED FROM ITS USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT. Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders of other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. SANDSTROM PRODUCTS COMPANY

**GENERAL**

Sandstrom E315 is a paint-like material consisting of zinc dust pigments dispersed in a thermoplastic resin system thinned with appropriate solvents. For maximum service, the APPLICATION INSTRUCTIONS MUST BE FOLLOWED CLOSELY.

**FILM THICKNESS & ENGINEERING TOLERANCE**

As supplied, Sandstrom E315 Zinc Rich Epoxy Primer will yield a film thickness of about 0.0075 inches without interference. If excess buildup does occur and a force fit is necessary, burnishing lightly will assist in mating the parts. The remaining excess will be worn away in the first few cycles of operation. Whenever possible, the proper tolerances should be designed into the part.

**COVERAGE**

One gallon of this material will theoretically cover 477 sq. ft. with a dry film thickness of 0.001 inches. Coverage depends upon method of application and other variables such as overspray and type of surface to be coated. Above coverage rates are based on 100% efficiency.

**SURFACE PREPARATION**

Please contact Sandstrom Products Company for substitute surface preparations if recommended steps cannot be followed.

**Application on steel.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Phosphate IAW MIL-DTL-16232 (weight should be 11-22 g/m<sup>2</sup>), type M, class 3 (optimal performance) or type Z, class 3.

**Application on stainless steels.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Passivate surface with ASTM A967, types nitric 1, nitric 2 or nitric 3, as applicable.

**Application on aluminum and aluminum alloys.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Sulfuric acid anodize IAW MIL-A-8625 and seal surface.

**Application on titanium and titanium alloys.** Degrease surface to be coated with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum) and alkaline anodize.

**Application on copper and copper alloys.** Pre-clean surface with aliphatic naphtha or any other EPA compliant cleaner that sufficiently cleans surface to pass ASTM F22. Abrasive blast surface with 180-220 grit aluminum oxide (25-50 RMS optimum). Form a black oxide finish on surface.

**STIRRING**

**IMPORTANT!** THIS PRODUCT CONTAINS HEAVY PIGMENTS WHICH SETTLE RAPIDLY. THEREFORE, IT SHOULD BE STIRRED THOROUGHLY BEFORE USE AND CONTINUOUSLY DURING APPLICATION.

**THINNING**

**For conventional spray** – Thin for spray by reducing 2 parts coating with 1 part xylene.

**For dipping** - Thin for dip by reducing 1 parts coating with 1 part xylene.

**APPLICATION**

Sandstrom E315 Zinc Rich Epoxy Primer should be sprayed or dipped to the desired film thickness (usually 0.0003 to 0.001 inches). Allow the surface to dry **at least** 30 minutes to 1 hour before doing light assembly work.

It is important to keep container closed when not in use to keep loss of solvents at a minimum and avoid a change in volume solids.

Note: All instructions are based on product and part temperatures of 77°F ± 5°F and <70% relative humidity. Should product need temperature adjustments, use a hot or cold water bath.

**DRYING**

Sandstrom E315 Zinc Rich Epoxy Primer may be air dried or force dried. If parts are to be air dried, allow at least 8 hours @ 77°F ± 5°F and ≤70% relative humidity before putting into service.

After a flash time of 30 minutes, E315 Zinc Rich Epoxy Primer can be force dried according to the following schedule:

90 minutes @ 150°F or  
45 minutes @ 175°F or  
25 minutes @ 200°F.

**IMPORTANT!** The time begins when the part has reached temperature, NOT when it is placed in the Class A oven.

**CLEANUP**

Use the same solvents for cleaning tools as are recommended for thinning or use MEK.

**REMOVAL**

Soak the coated part for 10 – 20 minutes in a 1:1 by volume blend of Acetone to PM Solvent. Then use a soft bristle brush to remove coating from the surface. If necessary, perform a second rinse with a clean solvent blend to remove any remaining coating.

**WARNINGS:** Constant stirring is imperative for best results.

**DANGER! USE WITH ADEQUATE VENTILATION.**

\*\*\*Strict compliance to the instructions given in Surface Preparation, Application and Stirring is very essential for obtaining optimum results.\*\*\*

**IMPORTANT! DO NOT TOUCH CLEAN SURFACE WITH FINGERS - OIL FROM THE HANDS WILL INTERFERE WITH PROPER COATING ADHESION.**

**IMPORTANT NOTICE TO BUYER / WARRANTY AND LIMITATIONS ON OUR LIABILITY**

We warrant our products to be free of manufacturing defects and that they meet our current published physical properties and specifications. All information and suggestions presented are rendered gratis and are accurate to the best of our knowledge. They are based on technical data we believe to be reliable and are intended for use by persons having skill and "know-how" at their own discretion and risk. Prior to use, customers are cautioned to determine the suitability of our products for any given application through their own testing. NO WARRANTY IS MADE, EXPRESS OR IMPLIED, REGARDING SUCH INFORMATION, THE DATA ON WHICH IT IS BASED OR THE RESULTS OBTAINED FROM ITS USE OR THAT OUR PRODUCT SHALL BE MERCHANTABLE OR FIT FOR ANY PARTICULAR PURPOSE. SUCH STATEMENTS ARE NOT INTENDED TO SUGGEST INFRINGEMENT OF ANY PATENT. Since conditions of use of our products are beyond our control, all suggestions and statements are made without guarantee, warranty or other responsibility, express or implied, on our part. We assume no responsibility for results obtained, or damages incurred, from their use beyond replacing material proved to be defective or refunding the purchase price of such material at our option. Acceptance of delivery of our product means you have accepted the terms of this warranty, whether or not purchase orders of other documents state terms that vary from this warning. No seller is authorized to make any representations or warranty or assume any other liability on our behalf with any sales of our products. SANDSTROM PRODUCTS COMPANY

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