



CRE with CRE-91XR

CPC 176

CRE-904 Corrosion Resistant Epoxy Primer – Gray

PRODUCT DESCRIPTION			
Component A CRE-904FF Corrosion Resistant Epoxy Primer – Gray (Full Fill)		Component B CRE-91XR	
TYPE Epoxy/Amine			
RECOMMENDED USE CRE/CRE-91XR is a chrome-free, high build epoxy primer, designed for maximum filling and corrosion resistance when applied over properly prepared steel and aluminum. CRE/CRE-91XR primer is particularly suited for application over sandblasted metals, or anywhere superior film build and corrosion resistance are required. Examples include castings, fabrications for off shore or marine exposure, or as a heavy machinery original or reconditioning primer. CRE primer provides excellent build and leveling, and offers rapid dry to recoat times. The CRE-91XR catalyst allows for easier pourability while maintaining 3.5 VOC compliance.			
PHYSICAL CONSTANTS			
Voc (Mixed) CRE-904FF	3.1 Lbs./Gallon	Flash Points (Pensky-Martens) CRE-904FF 65°F (18C°) CRE-91XR 84°F (29C°)	
Percent Solids By Weight (Mixed) CRE-904FF	70 – 72%	Ready To Spray Viscosity #3 Zahn = 10 – 20 Seconds #2 Zahn = N/A	
Percent Solids By Volume (Mixed) CRE-904F	55.5 – 56.5%	Weight Per U.S. Gallon (Mixed) CRE-904FF 10.1 – 11.1 Lbs./G	
PERFORMANCE FEATURES			
96 Hour Humidity Resistance Excellent		In Service Temperature Limitations 300° F	
Water Resistance Although Resistant To Intermittent Exposure, <i>Not Recommended For Immersion.</i>		Adhesion Excellent	
CHEMICAL/SOLVENT RESISTANCE			
10% Sulfuric Acid	Excellent	10% Hydrochloric Acid	Excellent
10% Ammonia	Excellent	10% Sodium Hydroxide	Excellent
Xylene	Excellent	Isopropyl Alcohol	Excellent
Oil	Excellent	Gasoline	Excellent
500 Hours Salt Spray	Excellent		

SURFACE PREPARATION			APPLICATION DATA (cont.)
The surface to be coated must be sanded, free of all contamination, including dust, dirt, oil, grease and oxidation.			Recommended Spreading Rate 900 sq. ft. at 1.0 mil dry film per U.S. gallon (varies by color). Spreading rate figures do not include losses due to mixing, transfer or application of coating, or losses due to surface irregularities or porosity.
Metal	Recommended Topcoat	Direct To Properly Treated Substrate	Clean Up PPG Urethane Reducer or Lacquer Thinner
Cold Rolled Steel	ALK-200, ALK-200/201, ALK-300, ALK-300LG, AUE-100, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-360, AUE-400LG	Excellent	Application Precautions and Limitations Apply only when air, product or surface temperature is above 50°F (10°C) and when surface temperature is at least 5°F (3°C) above the dew point. All Commercial Coatings Performance data is based on spray application, at the recommended film build. If alternative application methods are employed, substrate preparation and film builds listed for spray application must be followed.
Hot Rolled Steel	ALK-200, ALK-200/201, ALK-300, ALK-300LG, AUE-100, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-360, AUE-400LG	Excellent	
Aluminum	ALK-200, ALK-200/201, ALK-300, ALK-300LG, AUE-100, AUE-280, AUE-280LG, AUE-300, AUE-350, AUE-360, AUE-400LG	Excellent	
Plastic/ Fiberglass	Surface should be free of all contamination. Because of the variability of plastic/fiberglass substrates, coating performance should be confirmed on the actual plastic/fiberglass substrate being used.		
APPLICATION DATA			
Mixing Directions Stir thoroughly before and occasionally during use. To each pigmented gallon, 128 oz. net of CRE-904FF, add 64 oz of CRE-91XR catalyst.			
CRE Primer : CRE-91XR 2 : 1			
<i>Note: Moisture contamination in components can result in poor properties of applied films or gelling of the material. Do not open until ready to use.</i>			
Pot Life 2 hours at 75°F. Mix only enough material that can be used in two hours. <i>Note: Higher temperatures will shorten pot life.</i>			
Thinning Not recommended where 2.8 lbs./gallon VOC compliance is required. In unregulated areas, Up to 10% by volume of Xylene, Toluene, MEK, Aromatic 100 or 150 may be used to maintain 3.5 VOC compliance.			
Application Equipment Conventional Spray: 55 - 65 psi at the gun.			
Drying Time (77°F / 25°C and 50% relative humidity)			
To Touch:		45 minutes	
To Handle:		2 hours*	
To Dry:		6 hours	
To Topcoat:		1 hour to 4 days	
* This condition does not mean that the paint film has reached full cure. It is a stage where handling can be achieved without loosening, wrinkling or otherwise marring the film under minimal pressure from fingers or hands. Drying time listed may vary, depending upon film build, color selection, temperature, humidity and degree of air movement.			
Application of film thickness in excess of that recommended for this product will substantially extend dry time and lengthen the recoat window.			
Recommended Wet Film Build (Mixed):		2.6 To 10.4 Mils	
Recommended Dry Film Build:		2 To 8 Mils	
Film in excess or below these recommended film builds may result in poor adhesion, solvent popping, runs, sags, or extended dry times.			
SAFETY			
These materials are designed for application only by professional, trained personnel, using proper equipment under controlled conditions and are not intended for sale to the general public. Safe application of paints and coatings requires knowledge of equipment materials and individual training. Directions and precautionary information on both equipment and products should be carefully read and strictly observed for personal safety and property protection. Consideration must be given to eliminate conditions, which may generate hazardous atmospheres during spray application or subject operators or bystanders to injury or illness. Special precautions must be taken when utilizing spray equipment, particularly airless equipment. High-pressure injection of coatings into the skin by airless equipment may cause serious injury requiring immediate medical attention at a hospital. Treatment advice may also be obtained from Poison Centers. Air quality should be maintained with adequate ventilation; applicators can achieve additional protection by wearing respirators and other protective garments such as gloves and overalls. In all cases, wear protective eye equipment. During the application of all coatings materials, all flames, welding and smoking must be prohibited. Explosion proof equipment must be used when coating these materials in confined areas.			
PRECAUTIONARY INFORMATION			
Before using the products listed herein, carefully read each product label and follow directions for its use. Please read and observe all warnings and precautionary information on all product labels. Prevent all contact with skin and eyes and breathing of vapors and spray mist. Repeated inhalation of high vapor concentrations may cause a series of progressive effects including irritation of the respiratory system, permanent brain and nervous system damage and possible unconsciousness and death in poorly ventilated areas. Eye watering, headaches, nausea, dizziness and loss of coordination are indications that solvent levels are too high. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. KEEP OUT OF THE REACH OF CHILDREN			
MEDICAL RESPONSE			
Emergency Medical or Spill Control Information (412) 434-4515; CANADA (514) 645 - 1320 Have label information available.			
MATERIAL SAFETY DATA SHEET			
Material Safety Data Sheets for the PPG products mentioned in this publication are available through your PPG Distributor. FOR ADDITIONAL INFORMATION REGARDING THIS PRODUCT, SEE THE MSDS AND LABEL INFORMATION.			
To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries, Inc. is constantly improving its coatings and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your PPG Distributor for the most up-to-date information.			

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