North America

Programmed System Technique (PST)

Primer

03/03/2026

E250 DTM Epoxy Primer (as a sealer)

U-TECH E250 DTM Epoxy Primer is a two-component high-solid, low VOC direct to metal (DTM) epoxy primer for the commercial vehicle builder and refinish market. The product is easy to apply with excellent hold out and smooth appearance. E250 DTM Epoxy Primer is a versatile product and good over multiple substrate types making it ideal for commercial vehicle repair shops.

Safety Considerations

- Use suitable personal protection.
- When exposed to paint or solvents AkzoNobel recommends the use of a fresh air supply respirator.

Surface Preparation

- Existing Finishes
  - #P320 to #P400 grit dry
- Steel
  - #P80 to #P180 grit dry
- Zinc Coated Steel
  - Red scuff pad
- Aluminum (5052)
  - #P150 to #P180 grit dry
- Body Filler
  - #P180 to #P220 grit dry

STICK # 9

Mix	By Volume – Wet-on-Wet Sealer Mixture
3	Parts E250 DTM Epoxy Primer
1	Part E250 DTM Epoxy Primer Hardener
1	Part R250 Epoxy 3.5 Reducer or R250 Exempt 2.1 Reducer

- *Other mixing ratios are available. Review the complete TDS for options.*

Spray-Gun Set-Up for Sealer Mix:

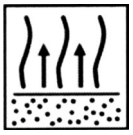
- 1.3 – 1.5mm HVLP Gravity
- 1.3 – 1.5mm Compliant

Application Air Pressure:

- HVLP – 10 psi (<0.7 bar) at cap maximum
- Consult manufacturer specifications

Application

- 1 – 2 x 1 Coats (Apply one or two medium flowing coats)

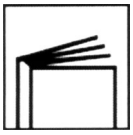


Flash Between Coats at 70°F (21°C)

- 10 minutes

Flash at 70°F (21°C) Before Topcoating

- 30 – 45 minutes
- Maximum of 7 days at ambient temperature and protected from the outside elements.
  - ✓ *Dependent on film weight and air flow.*



Recoatable with:

- 2K20 Surfacer
- 2K100 Surfacer
- 2K HB Surfacer
- 460 Sealer (over sanded E250)
- E250 DTM Epoxy Primer
- Polyester Body Filler
- U-Base Basecoat
- U280 Single Stage
- U350 Single Stage
- U500 Single Stage
- Evercoat Superbuild 4:1
- Evercoat Slicksand

E250 DTM Epoxy Primer

Description

U-TECH E250 DTM Epoxy Primer is a two-component high-solid, low VOC direct to metal (DTM) epoxy primer for the commercial vehicle builder and refinish market. The product is easy to apply with excellent hold out and smooth appearance. E250 DTM Epoxy Primer is a versatile product and good over multiple substrate types making it ideal for commercial vehicle repair shops.

Suitable Substrates

- Cold Rolled steel
- Galvanized steel
- Aluminum (2024 T3, 3003, 5052, 6022, 6111)
- Stainless Steel (304)
- Autoprep Pretreatment Wipe material
- Fiberglass gelcoat (unbroken)
- Polyester body filler
- Existing finishes (except acrylic lacquers)

- E250 DTM Epoxy Primer can be applied directly over the aluminum and steel substrates defined above. For the optimum in performance and protection, use Autoprep Pretreatment Wipes or Bonderite 1455 pretreatment for steel, galvanized, and aluminum. Other grades of aluminum and steel should be tested for adhesion and corrosion prior to use.
- E250 DTM Epoxy Primer can be applied over most polyester body-fillers. Consult AkzoNobel for approved body fillers.
- After sanding, properly degrease substrate with Autoprep Ultraprep Surface Cleaner and R859 wax and grease remover.

Products and Additives

Product

- E250 DTM Epoxy Primer Black (Gallon) – Item #531287
- E250 DTM Epoxy Primer White (Gallon) – Item #531291
- E250 DTM Epoxy Primer Gray (Gallon) – Item #531292

Hardeners

- E250 DTM Epoxy Hardener (Quart) – Item #531295
- E250 DTM Epoxy Hardener (Gallon) – Item #531299

Reducers

- R250 Epoxy 3.5 Reducer (Gallon) – Item #531297
- R250 Epoxy 2.1 Reducer (Gallon) – Item #531298
  - R250 Epoxy 2.1 Reducer is intended for VOC regulated regions.

- SDS and TDS for products available online at – https://my.anaac.net/

Characteristics

- E250 DTM Epoxy Primer – Epoxy resins
- E250 DTM Epoxy Hardener – Polyamide resins
- R250 Reducers – Special solvent blends

E250 DTM Epoxy Primer

- E250 DTM Epoxy Primer weight per gallon – 13.1-13.7 (5.94-6.21kg)
- Volume Solids mixed 3:1 – 50% +/-1%
- Volume Solids mixed 3:1:0.5 – 44% +/-1%
- Volume Solids mixed 3:1:1 – 39% +/-1%
- Gloss – Low

Substrate Preparation

Pre-Cleaning

- If needed pre-wash the repair with warm soap and water. Rinse completely with clean water.
- Clean with U-TECH R879 Surface Cleaner, Autoprep Ultraprep (VOC compliant) or Sikkens Anti-Static surface cleaners.

Sanding Preparation	Sanding	Additional Information
Existing Finishes	#P320 to #P400, dry	
Gelcoat (unbroken)	#P220 to #P320, dry	
Premium Polyester Bodyfiller	#P180 to #P220, dry	
Steel, Cold Rolled	#P80 then #P120, dry	
Steel, Blasted	Blasted to a white appearance	The minimum total thickness required over a blasted profile is >1.5 mils (>38 µm) for adequate protection
Galvanized Steel	Abraded with a Red Scuff Pad	
Stainless Steel (304)	#P180, dry	
Aluminum (2024 T3, 3003, 6022, 6111	#P180, dry	
Aluminum (5052)	#P150 to #P180 grit, dry	

NOTE: E250 DTM Epoxy Primer may be applied directly over the metal substrates listed above. For the optimum in performance: after abrading, properly clean and follow with Autoprep Pretreatment Wipes or Bonderite 1455.

Surface Cleaning – Prior to Paint Application

- Clean with U-TECH R879 Surface Cleaner, Autoprep Ultraprep (VOC compliant) or Sikkens Antistatic Surface Cleaner.

E250 DTM Epoxy Primer

Product Agitation

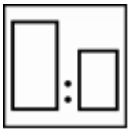
Stirring

- Because E250 DTM Epoxy Primer is a high-solids paint, it needs to be agitated before use.
- Stir or shake vigorously before each use.

Mixing Color Formulas and Products

- For easy mixing of materials, final mixing, including hardening, reduction, and the addition of additives, can be done utilizing MIXIT.

Mixing



BY VOLUME
STICK # 9

- **High Build Ratio**

Mix — **High build primer for rough surfaces such as blasted steel (2.1lb/gal VOC)**

3	Parts E250 DTM Epoxy Primer
1	Parts E250 DTM Epoxy Hardener

BY WEIGHT

High build primer for rough surfaces such as blasted steel (2.1lb/gal VOC)
1 Quart Ready to Spray Mixing 3:1 – By Weight

	E250 DTM Epoxy	E250 Hardener
Black	1125 grams	274 grams
Gray	1120 grams	274 grams
White	1163 grams	274 grams

BY VOLUME

- **Medium Build Wet-on-Wet Ratio**

Mix — **Medium build wet-on-wet sealer (3.5 or 2.1 lb/gal VOC)**

3	Parts E250 DTM Epoxy Primer
1	Parts E250 DTM Epoxy Hardener
0.5	Parts R250 DTM Epoxy 3.5 Reducer or R250 Exempt 2.1 Reducer

✓ *Recommended ratio for pressure feed sealer application*

BY WEIGHT

Medium build wet-on-wet sealer with R250 Epoxy 3.5 Reducer (2.8 lb/gal VOC)
1 Quart Ready to Spray Mixing 3:1:0.5 – By Weight

	E250 DTM Epoxy	E250 Hardener	R250 3.5 Reducer
Black	1000 grams	244 grams	100 grams

E250 DTM Epoxy Primer

Mixing - continued

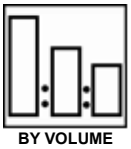

BY WEIGHT

Gray	996 grams	244 grams	100 grams
White	1034 grams	244 grams	100 grams


BY WEIGHT

Medium build wet-on-wet sealer with R250 Exempt 2.1 Reducer (2.1lb/gal VOC)
1 Quart Ready to Spray Mixing 3:1:0.5 – By Weight

	E250 DTM Epoxy	E250 Hardener	R250 2.1 Reducer
Black	1000 grams	244 grams	141 grams
Gray	996 grams	244 grams	141 grams
White	1034 grams	244 grams	141 grams


BY VOLUME
STICK # 9

- **Wet-on-Wet Ratio Over Existing Finishes**

Mix **Wet-on-wet sealer over existing finishes (3.5 or 2.1 lb/gal VOC)**

3 Parts E250 DTM Epoxy Primer
1 Part E250 DTM Epoxy Hardener
1 Part R250 DTM 3.5 Reducer or R250 Exempt 2.1 Reducer


BY WEIGHT

Wet-on-wet sealer over existing finishes using R250 Epoxy 3.5 Reducer (3.2 lb/gal VOC)
1 Quart Ready to Spray Mixing 3:1:1 – By Weight

	E250 DTM Epoxy	E250 Hardener	R250 3.5 Reducer
Black	900 grams	219 grams	180 grams
Gray	896 grams	219 grams	180 grams
White	931 grams	219 grams	180 grams

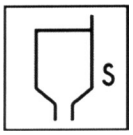

BY WEIGHT

Wet-on-wet sealer over existing finishes using R250 Exempt 2.1 Reducer (2.1lb/gal VOC)
1 Quart Ready to Spray Mixing 3:1:1 – By Weight

	E250 DTM Epoxy	E250 Hardener	R250 2.1 Reducer
Black	900 grams	219 grams	254 grams
Gray	896 grams	219 grams	254 grams
White	930 grams	219 grams	254 grams

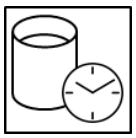
E250 DTM Epoxy Primer

Viscosity Ready to Spray at 70°F (21°C) EZ Zahn #3



Seconds	
11.5 – 13.5	• 3:1 High Build Primer Surfacer
9 – 11	• 3:1:0.5 Medium Build Wet-on-Wet Sealer
7.5 – 9.5	• 3:1:1 Wet-on-Wet Sealer

Pot-Life When Mixed



Product Mix	70°F (21°C)
• E250 DTM Epoxy Primer	– 4 Hours

Spray Gun Set-Up

Consult spray gun manufacturer's instructions for recommended application specifications.

Spray Gun	Fluid Tip	Application Pressure
HVLP Gravity Feed (Mixed 3:1)	1.7 – 1.9mm	<10 psi (<0.7 bar) at cap.
Compliant Gravity Feed (Mixed 3:1)	1.5 – 1.7mm	psi per spray gun manufacturer.
HVLP Gravity Feed (Mixed 3:1:1)	1.3 – 1.5mm	<10 psi (<0.7 bar) at cap.
Compliant Gravity Feed (Mixed 3:1:1)	1.3 – 1.5mm	psi per spray gun manufacturer.
HVLP Pressure Feed (Mixed 3:1)	1.3 – 1.5mm	12-16 per minute. <10 psi (<0.7 bar) at cap.
Compliant Pressure Feed (Mixed 3:1)	1.3 – 1.5mm	12-16 per minute - psi per spray gun manufacturer.
HVLP Pressure Feed (Mixed 3:1:0.5)	1.0 – 1.3mm	12-16 per minute. <10 psi (<0.7 bar) at cap.
Compliant Pressure Feed (Mixed 3:1:0.5)	1.0 – 1.3mm	12-16 per minute - psi per spray gun manufacturer.

Application

3:1 High Build Application

- Apply two single flowing coats.
- Allow a flash off time between coats of 10 minutes.
  - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available airflow.

E250 DTM Epoxy Primer

3:1:0.5 or 3:1:1 Wet-on-Wet Application

- Apply one or two medium flowing coats.
- Allow a flash off time between coats of 10 minutes.
  - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available airflow.

Flash Drying

Flash Between Coats at 70°F (21°C)

- 10 minutes

Flash Before Top Coating at 70°F (21°C)

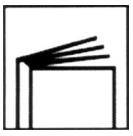
- 30-45 minutes (7 days maximum)

  - Flash time will be dependent on ambient temperature, applied paint wetness/thickness and available air-flow.
  - The maximum time E250 Epoxy may be left before being coated with more U-TECH urethane products is 7 days. After 7 days, the surface must be sanded.
  - Polyester body fillers (including sprayable polyesters): Flash dry for a minimum of 1 hour (maximum 7 days) before applying.
    - ✓ Maximum times are based on the object maintaining an ambient temperature status and preventing extended exposure to the outside elements.

Drying / Curing Time

- Allow E250 Epoxy mixed 3:1 as a high build primer to dry 24 hours at 70°F (20°C) to sand.
  - E250 may be force dried 1 to 1½ hours at 140°F (60°C) to cure for sanding.
  - Drying times are stated at recommended application method, film thickness and object temperature.

Recoating



After the stated flash time E250 Epoxy may be recoated with the following materials.

- Fiberglass Evercoat Superbuild 4:1
- Fiberglass Evercoat Slicksand
- Polyester Body Filler
- 460 Tintable Sealer (over sanded E250)
- U-TECH E250 DTM Epoxy Primer
- U-TECH 2K20
- U-TECH 2K100
- U-TECH 2KHB
- U-TECH U280
- U-TECH U350
- U-TECH U500
- U-TECH U-Base

  - E250 DTM Epoxy Primer can be recoated with polyester body filler products without sanding after a minimum of 1 hour drying and a maximum 7 days at ambient temperature. After the polyester body filler and the E250 DTM Epoxy Primer have dried, sand the body filler material until satisfied with the repair.
  - The maximum time E250 Epoxy may be left before being coated with more U-TECH urethane products is 7 days. After 7 days, the surface must be sanded.
  - E250 DTM Epoxy Primer may be recoated with itself for up to 30 days without sanding.
  - For easier sanding, E250 Epoxy Primer may be recoated with the U-TECH primer surfacers listed above after observing the proper flash time.
    - ✓ All recoat times are based on protecting the applied E250 DTM Epoxy Primer from extended exposure to the outside elements.

E250 DTM Epoxy Primer

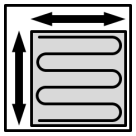
Cleaning of Equipment

- Clean equipment and dispose of waste following local and federal regulations. In compliant localities, use a VOC compliant high quality solvent borne gun cleaner. For national rule regions, a use high quality lacquer thinner.
- For efficient cleaning and less evaporated cleaning solvents, an enclosed automatic gun cleaning machine is suggested.

Film Thickness – Using Suitable Application

- 1 Coat of E250 Epoxy mixed 3:1 as a surfacer – 1.5-1.75 mils (38-45µm) dry.
- 1 Coat of E250 Epoxy mixed 3:1:0.5 or 3:1:1 as a wet-on-wet sealer – 1.2-1.5 mils (30-38µm) dry.
- The minimum total thickness required over sanded metals or a blasted metal profile is >1.5 mils (>38µm) for adequate protection and appearance.

Theoretical Coverage



- With the recommended application, the theoretical material usage at a 1 mil thickness (25.4 µm).
  - E250 High Build Mixed 3:1 ≈ 780 ft^2/gallon (19.2m^2/liter)
  - E250 Wet-on-Wet 3:1:0.5 ≈ 694 ft^2/gallon (17.0m^2/liter)
  - E250 Wet-on-Wet 3:1:1 ≈ 624 ft^2/gallon (15.3m^2/liter)
- Actual coverage is dependent on many factors. These may include; the shape of the object, surface smoothness, application technique, and other application variables.

VOC / Regulatory Information

Product	VOC lb/gal	VOC g/l
• E250 High Build Mixed 3:1	– <2.1	– 250
• E250 Wet-on-Wet with R250 2.1 Reducer Mixed 3:1:0.5	– <2.1	– 250
• E250 Wet-on-Wet with R250 2.1 Reducer Mixed 3:1:1	– <2.1	– 250
• E250 Wet-on-Wet with R250 3.5 Reducer Mixed 3:1:0.5	– <2.8	– 326
• E250 Wet-on-Wet with R250 3.5 Reducer Mixed 3:1:1	– ≤3.2	– 384

- Do not handle until the Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.

E250 DTM Epoxy Primer

Product Storage

- Stock unopened or used products in approved closed containers with proper labeling. Store in moderate temperatures. Optimum storage temperature is approximately 70°F (21°C). Avoid too much temperature fluctuation. The maximum temperature range for storage is 40°F – 95°F (5°C to 35°C).
- Refer to the product shelf-life TDS or the current price sheet for the most up-to-date shelf-life information.

• E250 DTM Epoxy Primer	– 2 Years
• E250 DTM Epoxy Hardener	– 1 Year
• R250 Exempt 2.1 Reducer	– 2 Years
• R250 Epoxy 3.5 Reducer	– 2 Years

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