SHERWIN WILLIAMS®

General Industrial Coatings

Vectrogard™ 3000 Cathodic Epoxy Black Electrocoat Primer

WEAC208/WECC033

DESCRIPTION

Vectrogard™ 3000 is a cathodic epoxy electrocoat primer that provides excellent edge coverage and corrosion protection to metal substrates.

Advantages:

- Proven performance
- High edge performance
- Excellent corrosion resistance
- Efficient and robust operations
- Excellent chemical resistance
- Low VOC
- HAPs compliant
- Formulated to not contain lead, nickel, zinc, and chrome

APPLICATION

Application:	Cathodic Electrocoat
Operating Voltage:	Up to 400 volts
Standard Dwell Time:	120 seconds
Paint Operating Temperature:	85-95°F (29-35°C)

Equipment/application guidelines are only guidelines and individual application & process parameters will dictate exact requirements.

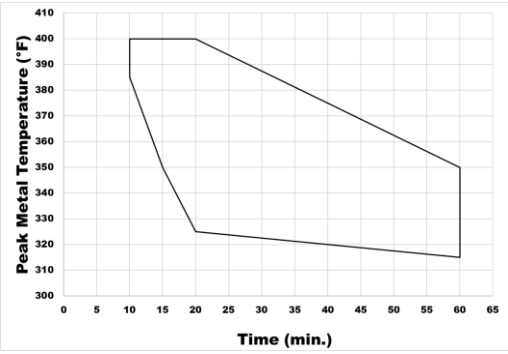
PERFORMANCE TESTS

Substrate:	Cold rolled steel, Zinc Phosphate Non-chrome seal
Cure:	350°F (175°C) at 20 minutes (Peak Metal Temperature)
Salt Spray Test: (ASTM B117)	1000 hours 0-2mm average creep from scribe
Impact Resistance, Direct	120+ in-lbs. 100+ cm-kg
Impact Resistance, Indirect	120+ in-lbs. 100+ cm-kg
Pencil Hardness	2H minimum
Conical Mandrel, 1/8" (3.2mm)	No Cracking
Water Immersion	240 hours minimum
Adhesion	5B

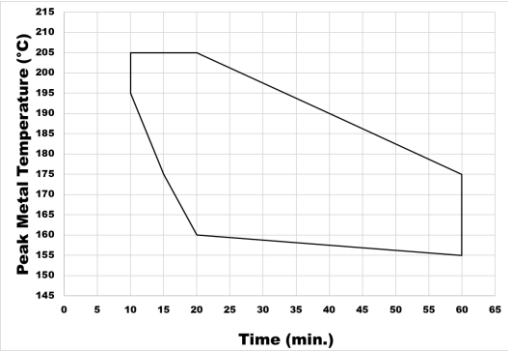
CURE WINDOW

(Time at Peak Metal Temperature)

Fahrenheit



Celsius



Disclaimer: Data generated from salt fog and double rub testing. Specific line conditions should be tested. Curing outside of these parameters may affect coating performance.

SPECIFICATIONS

General: All substrates should be free of mold release, oil, grease, dirt, fingerprints, drawing compounds, surface passivation treatments and any other contaminants to ensure optimum adhesion and coating performance.

Remove rust, mill scale, and oxidation products. For best results, treat the surface with a commercially available surface chemical treatment of zinc phosphate, iron phosphate, or nano pretreatment to improve corrosion protection. Consult with pretreat supplier for recommend process and products for your individual application.

Testing: The information, data, and recommendations set forth in this Product Data Sheet are based upon test results believed to be reliable. However, due to the wide variety of substrates, substrate properties, surface preparation methods, equipment and tools, application methods, and environments, the customer should test the complete system for adhesion, compatibility, and performance prior to full scale application.

ADDITIONAL INFORMATION

1. **DO NOT VARY MIX RATIO.** This ratio has been established for optimum performance.
2. Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system for adhesion and compatibility prior to full scale application.
3. Ensure coated parts are not exposed to sunlight.
4. On sandblasted surfaces, apply sufficient film thickness to fully protect the blast profile.

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CHARACTERISTICS

Component A:	**WEAC208**
Component B:	**WECC033**

Mixing Ratio (by volume):

WEAC208	1 Part
WECC033	7 Parts

Mixing Ratio (by weight):

WEAC208	1 Part
WECC033	6 Parts

Density (lbs/gal)**:**

WEAC208	10.1-10.5
WECC033	8.7-8.9
Admixed	8.9-9.1

Density (kg/L)**:**

WEAC208	1.21–1.26
WECC033	1.04-1.07
Admixed	1.07-1.09

Weight Solids (%):

WEAC208	52-55
WECC033	34-36
Admixed	36-38

Volume Solids (%):

WEAC208	41-44
WECC033	30-32
Admixed	31-33

Viscosity (at 77°F / 25°C)**:**

WEAC208	300-1200 centipoises
WECC033	<100 centipoises

Theoretical Coverage:

520 ft^2/gal at 25 µm DFT admixed
12.8 m^2/L at 25 µm DFT admixed

VOC by Weight (%):

WEAC208	1.3-2.3
WECC033	0.8-1.8
Admixed	0.9-1.9

Water by Weight (%):

WEAC208	43.5-46.5
WECC033	62.5-65.5
Admixed	59.8-61.8

VOC/Gallon (US EPA Method 24-calculated) (lbs./gal)

WEAC208	0.42
WECC033	0.35
Admixed	0.36

VOC per gallon as Supplied (lbs.VOC/gal):

WEAC208	0.19
WECC033	0.11
Admixed	0.12

VOC per liter as Supplied (g VOC/L):

WEAC208	22.7
WECC033	13.2
Admixed	14.4

CHARACTERISTICS Continued

Flash Point (Seta Flash Point Tester)**:**

WEAC208	>212° F / >100° C
WECC033	>212° F / >100° C

Recommended DFT (Dry Film Thickness):

Mils	0.8-1.2
Microns	20-30

60° Gloss: 40-70

Package Life: A minimum shelf life of 12 months from date of manufacture can be expected if stored in sealed containers at temperatures between 50-95°F (10-35°C). Store under roof; keep out of rain and snow. Protect from freezing. Store out of direct sunlight.

CAUTIONS

FOR INDUSTRIAL APPLICATION ONLY

Thoroughly review the product label and Safety Data Sheet (SDS) for safety information and cautions prior to using this product.

To obtain the most current version of the Environmental Data Sheet (EDS), Product Data Sheet (PDS), or Safety Data Sheet (SDS) please contact your sales or technical service representative.

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