

### PRIMER/PRIMER SURFACER

80-0094 [ Primer 2K 4:1:3 Grey ]

#### 1. GENERAL INFORMATION

2K Polyurethane Primer, A Two-component Polyurethane Primer that contains polyurethane resin as the first part and isocyanate as the second part. It provides excellent adhesion to all metals and protects against harsh conditions that can cause rust on steel surfaces. In addition, it can be used as heavy build filler without affecting the gloss of top/base coat.

Packing Size : -

#### 2. MIXING

##### COMPONENTS

80-0094 ( Primer 2K 4:1:3 Grey )

21-20 ( Hardener for 2K Primer 4:1 )

86-104 ( Acrylic BBP Thinner )

MIX RATIO	Volume	By weight	Remark
80-0094	4	6.40	
21-20	1	1.01	
86-104	1.2	1.08	
APPLY VISCOSITY	13 - 16 second NK#2		
POT LIFE	3 - 4 Hour		

#### 3. APPLICATION

##### SURFACE PREPARATION

All surfaces must be thoroughly sanded and cleaned with Concept Wax & Grease Remover prior to application.

-With soap and water. Rinse and wipe dry with clean cloth. Finally, clean surface using Wiping Solvent #85-4 (slow) or #85-7 (fast) with clean cloth.

-Sand steel, aluminum, or galvanized metal with 150 – 240 grit sandpaper. Primer can be applied direct to metal; however, for improved adhesion to metal, we recommend priming with Epoxy Primer #258-xxxx or Etch Primer/Wash Primer #282-xxxx.

-OEM or Original Paint must be cured and sanded with 150 – 240 grit sandpaper. Clear or lacquer must be sanded with 150 – 240 grit sandpaper before to avoid lifting. Body filler or fiberglass must be sanded with 150 – 240 grit sandpaper.

##### APPLICATION

Number of coats	2 – 3 coats Medium wet coats. Remark : Mixing ratio, Mixing component and environmental are effect to flash off time.		
Dry film thickness	Contact our Technician		
Theoretical Coverages	Contact our Technician		

##### APPLICATION EQUIPMENT

GUN SET UP*	Compliant	Gravity Feed	1.6 – 2.0 mm
		Siphon Feed	1.6 – 2.0 mm

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	HVLP	Gravity Feed	1.8 – 2.0 mm
		Siphon Feed	1.8 – 2.0 mm
AIR PRESSURE*	Compliant	Gravity Feed	20 – 30 psi at the gun
		Siphon Feed	20 – 30 psi at the gun
	HVLP	Gravity Feed	6-8 psi at the cap
		Siphon Feed	6-8 psi at the cap

Remark : Flash time and Dry times will depends on temperature, humidity and wet film thickness.

### 4.DRY TIME

AIR DRY @25-30 °C

Touch Dry : 3 - 5 minutes

Dry for wet sanding : 30 - 45 minutes

Dry for Dry sanding : Contact our Technician

FORCE DRY at 60-80 °C

Flash off before forcing dry : 5 - 10 minutes

Cycle Time : 30 - 40 minutes

Cool Down : 40 - 60 minutes

INFRARED DRY

Refer to the Infrared Guide for setup recommendations.

Remark : Flash time and Dry times will depends on temperature, humidity and wet film thickness.

### 5.SANDING

Use 1500 grit wet or finer.

Note: Use caution when sanding or polishing. Cutting too deep into the film may cause a color ring effect.

This can be repaired only by applying the Clear Topcoat over the sanding areas.

### 6. PHYSICAL PROPERTIES

Specific Gravity : 1.4 - 1.6 g/cm<sup>3</sup>

Total Non-Volatile Solid : 66 - 72 %

### 7. VOC REGULATION AREAS

These directions refer to the use of products which may be restrictor require special mixing instruction in VOC REGULATION AREAS. Follow mixing usage and recommendations in the VOC compliant products Chart for your area.

### 8. SAFETY AND HANDLING

For professional or trained applicator use only. Not for sale or use by the public. Before use, read and follow all TDS, label, and SDS precautions. Flammable product. Keep outreach of children. Always wear approved organic vapor goggles and a safety mask when using a product. Apply paint in good ventilating area.