



TECHNICAL DATA SHEET

PRODUCT NAME: 2K HIGH BUILD PRIMER

Version: 27/01/2014

DESCRIPTION:

Specialist Paints 2K High Build Primers are a high quality two-component extra build / easy sand acrylic urethane primer with excellent build, colour holdout and durability that can be used as a high build primer filler or a primer surfacer. Available in 3 colours: grey, white and black which can be blended to make different shades of grey. Suitable for: Car, Motor bike, Caravan, Commercial Vehicle and industrial industry.

TYPICAL SUBSTRATES:

- OEM primer
- GRP / fibreglass
- Epoxy primer surfacer
- Polyester putties
- Existing finishes in good condition
- Etch primer



SURFACE PREPARATION:

Clean and dry the surface. Sand surface with P220—P380 grit abrasive.



MIXING:

Primer	4 Parts (White, Grey or Black)
Activator	1 Part
Thinner	5%-15% (Optional, amount will depend on spray gun setup)

POT LIFE 1 Hour @ 70°F (20°C)



GUN SET UP:

Conventional (Siphon & Gravity): 1.6-2.2mm (.070"-.086"), 50-55 psi at the gun
 HVLP: 1.1mm – 2.2mm, 6-10 psi max @ the cap
 (Depending on the size of object being painted)



APPLICATION:

2-4 medium wet coats
5-10 minutes between coats

Allow 20 minute flash-off before force drying or Infra-Red.



FLASH TIME/DRY TIMES @ 72°F / 22.2°C:

Allow 5 - 10 minutes flash time between coats.
Air Dry 1½—3 hours
Baking 20—30 minutes @ metal temperature of 140°F / 60°C
INFRA RED 15-20 minutes

Times can vary depending on the air temperature and air movement. .

RECOAT:

Topcoat within 24 hours of sanding. If time exceeds 24 hours, the primed surface must be sanded and cleaned again prior to application of primer or topcoat.

SANDING:

Dry & D.A.: P400—P600
Wet Sanding: P500—P600

PHYSICAL DATA:

The EU limit value for this product (product category IIB c) in ready for use form is max 540g/litre of VOC. The VOC content of this product in ready to use form is max 540 g/l

Film thickness of approx 100-200 microns depending on the amounts coats applied

HEALTH & SAFETY:

Read all warnings, first aid and safety for all components before using. Keep out of reach of children and animals. Wear a properly fitting NIOSH/MSHA approved respirator. Select positive pressure supplied respirator (TC-19C or equivalent) for isocyanates. Follow the respirator manufacturer's directions for use. Protect hands with impervious rubber gloves. Wear face, skin and eye protection. Specialist Paints finishes are for industrial use by professional, trained painters.

Note: Custom painting can be difficult. All products should be fully tested prior to commencing any job to determine suitability, final finish and overall appearance. All information and data provided by CUSTOM PAINTS LTD is given in good faith and intended to be a general guide only. CUSTOM PAINTS LTD shall not accept liability as a result of any failure or lack of expertise on the part of the applicator, condition of substrates, lack of, or incorrect preparation, use of incompatible materials, equipment failure or use of incorrect equipment or any other reason beyond the control of CUSTOM PAINTS LTD and further offers no warranties of whatever nature express or implied as to merchantability or fitness for a particular use or purpose and shall not accept liability for any specific or consequential damage as a result of using these products unless otherwise agreed to in writing. Should a product be defective, CUSTOM PAINTS LTD shall replace the defective product, or, at its sole discretion refund the purchase price.