



## TECHNICAL DATASHEET

### 2K HIGH BUILD PRIMER

**ART. NO:** #190.230 (1QT, Light Grey), #190.230.G (1G, Light Grey),  
#190.231.G (1G, Dark Grey), #190.232.G (1G, Black)

2K HIGH BUILD PRIMER is a premium, 2K high build primer and filler designed for car refinishing as well as for use on industrial vehicles. It stands out for its high coverage and its easy sanding capabilities, and is dry sanding ready in 3 to 4 hours. Has good adhesion to cleaned steel, aluminum, galvanized and zinc plate steel, as well as to sanded and degreased GRP and different types of plastic. Recoatable with all base coats & water base coats.

#### FEATURES

- ✓ High build properties
- ✓ Direct to metal, aluminum & e-coat
- ✓ Excellent leveling properties
- ✓ Easy sanding
- ✓ No shrinkage

#### COMPATIBLE SURFACES

- ✓ Steel, aluminum, galvanized and zinc plate
- ✓ Fiber Glass and GRP
- ✓ Plastics such as PP-EPDM, PVC, PA, PC, MA, SMC and NORLYL

#### COMPATIBLE TOPCOAT

- ✓ Water & solvent base coats
- ✓ Sanded 1K & 2K single stage paint

#### CONDITIONS OF USE AND CONFORMITY

The before mentioned technical data and information, especially the recommendations for applying and using our products, are based on our current knowledge and experience when applied under normal conditions. In practice, the materials, surfaces or site conditions are so different that no warranty regarding the working results or liability, arising out of any relationship, can be inferred neither from this information nor from a verbal consultation, except we are charged with intent or gross negligence. In this case the user is obliged to prove that he has informed us about all points required for a proper and promising judgment in writing, in time and completely. Patent rights of any third party are to be observed. Furthermore, our general sales and delivery Terms and Conditions and the latest Technical Data Sheet, which should be demanded, apply.

#### HEALTH & SAFETY

See Safety Data Sheet and labels for additional safety information and handling instructions. Directions for handling and waste disposal are in our Material Safety Data Sheet and the specifications of the Employers Liability Insurance Association for the chemical industry. Wear appropriate PPE such as eye and skin protection. In the event of injury, see first aid procedures on SDS. Always observe all applicable precautions and follow good safety and hygiene practices.

Product (Part A) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	468.23	3.91
Regulatory VOC (less water & exempt solvents)	468.23	3.91
Density	1500	12.52
	WEIGHT %	VOLUME %
Total Solid Content	69%	46%
Total Volatile Content	31%	54%
Water	0%	0%
Exempt Compound Content	0%	0%

Hardener (Part B) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	617.51	5.15
Regulatory VOC (less water & exempt solvents)	617.51	5.15
Density	990	8.26
	WEIGHT %	VOLUME %
Total Solid Content	38%	38%
Total Volatile Content	62%	62%
Water	0%	0%
Exempt Compound Content	0%	0%

RTS VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
Coating Category	Primer	
Mixing Ratio	4 : 1	
	g/L	LBS/GAL
Actual VOC	498.09	4.16
Regulatory VOC (less water & exempt solvents)	498.09	4.16
Density	1398.00	11.67
	WEIGHT %	VOLUME %
Total Solid Content	62.8%	44.4%
Total Volatile Content	37.2%	55.6%
Water	0%	0%
Exempt Compound Content	0%	0%

#### PRODUCT DATA

**Dry Film Thickness / coat (DFT):** 2.0

**Coverage:** 364 Sq. Ft. / gal @ 2 mil\*

**Product Type:** Polyurethane

**Color:** Light Grey, Dark Grey, Black

**Shelf Life:** 24 months

**Package:** 1 Gallon / 1 Quart

**Number per case:** 4 (1G) / 12 (1QT)

Safety Data Sheet (SDS) is available on our website

## TECHNICAL DATASHEET



### HANDLING

#### MIXING

Make sure product is at room temperature 72°F (22.2°C) before mixing

**4 Parts Primer:** # 190.230.QT (1QT) - Light Grey  
 # 190.230.G (1G) - Light Grey  
 # 190.231.G (1G) - Dark Grey  
 # 190.232.G (1G) - Black

**1 Part Reducer:** # 191.230.M (1QT) - Medium  
 # 191.231.M (250ML) - Medium

**Reducer:** Reduce 5 - 10%



#### APPLICATION VISCOSITY

70 - 80 s. with a viscometer Ford #4 at room temperature 72°F (22.2°C)



#### POT LIFE

1 - 2 hours @ 70°F (20°C)



#### GUN SETUP

HVLP 1.8mm - 2.0mm 15 - 25 psi @ gun



#### APPLICATION

Apply a first medium wet coat followed by 1 or 2 full wet coats with 5 - 10 minutes flash between coats



#### FLASH TIME

**Between coats:** 5 - 10 minutes or until primer appears matte

**Before force dry:** 5 - 10 minutes



#### DRY TIMES

**Dust Free:** 5 - 10 minutes depending on temperature

**Air Dry:** 2.5 - 3.5 hours @ 75°F (23.9° C)



#### FORCE DRY

30 minutes @ 140°F (60°C)



#### INFRARED DRYING

20 minutes @ Middle Wave

#### SANDING & BUFFING

**Optimum Times:** **Force Dry:** 1 hour after cool down

**Air Dry:** 8 - 12 hours



#### Sanding:

Use a P320 grit or finer dry sandpaper followed with a final sanding using a P500 on a foam interface pad.