

## 2K Hi-Build Urethane Primer Surfacer

A premium acrylic urethane primer surfacer designed to be an ultimate performing, high build, easy sanding primer surfacer that resists sand scratch swelling and shrinkage. 2K Hi-Build Urethane Primer has excellent build, dry times, adhesion and flex properties. The resins utilized in this formula offer excellent color holdout and are ideal for urethane top coats and base coat clear coat systems. Color: Gray



Part #	Description	Size
8455	2K Hi-Build Urethane Primer- Gray	Gallon
8456	2K Hi-Build Urethane Primer- Gray	Quart
8155	2K Hi-Build Primer Catalyst	Quart
8156	2K Hi-Build Primer Catalyst	1/2 Pint



### Substrates

- Fully cured finishes - Sand with 240 - 320 grit paper
- Steel, Galvanized & Aluminum - Sand with 80 - 180 grit paper
- Fiberglass & SMC - Sand with 150 - 240 grit paper
- Always clean surface prior to application with 5900 or 5911 wax & grease remover.



### Mixing

- 4 parts 2K Hi-Build Urethane Primer
- 1 part 2K Hi-Build Catalyst
- 1 part Urethane Reducer



### Set up Tech Info

- Tip/Needle: 1.5mm to 1.8mm
- Spot Air Pressure: 35 - 45 psi / HVLP 5 to 10 psi at cap
- Overall Air Pressure: 45 - 55 psi / HVLP 5 to 10 psi at cap

Film Build: 1.3-1.5 mills/wet coat  
 Coverage: 696 @ 1 mil



### Application

Apply 2 to 3 medium wet coats to fill sand scratches, imperfections, and build low areas. Allow 10-15 minutes between coats.



### Drying

- Sand Air: 1-3 hours @ 77°F Force: purge 15 min. @ 77°F then 20 min @ 140°F
- Recoat 1-3 hours or after cool down. Sand before recoating with additional primers, sealers or color topcoat.
- Pot Life 1-2 hours



### Physical Data

- Volume Solids RTS 61-63%
- VOC RTS: 4.1 lb./g
- Humidity Resistance: Excellent
- Salt Spray Test: Excellent
- Lead & Chromate Levels Lead & Chromate Free



### Master Tips

If shop or substrate temperature is below 60°F, urethane accelerator recommended. Curing process of isocyanate products are severely inhibited below 60°F. Primer should be recoated or topcoated within 12 hours. If not topcoated within 12 hours, sand with 500 grit paper before recoating with primer, sealer, or color topcoat. Retarders - Recommended only in severe heat and humidity. Flex Agent - Recommended when repairing flexible substrates OFF the vehicle, approximately 10%.