Revised: 11/05

Hi Prime

Hi Prime is a high solids acrylic lacquer primer surfacer formulated for quick filling , easy sanding, and excellent adhesion properties. Its quick filling properties easily fills up to 80 grit sand scratches . An economical and production shop oriented primer that provides an excellent base and promotes topcoat adhesion. VOC complaint when used with color grade lacquer thinner.

Part #	Description	Size
8400	*Hi Prime - Gray*	*Gallon*
8401	*Hi Prime - Gray*	*Quart*
8402	*Hi Prime - Red Oxide*	*Gallon*
8403	*Hi Prime - Red Oxide*	*Quart*
8404	*Hi Prime - Hot Rod Black*	*Gallon*

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 5910 wax & grease remover

Mixing

2 Parts Hi Prime Primer Surfacer
3 Parts VOC Compliant Thinner

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
Viscosity (#2 Zahn)	18 - 20 seconds
Film Build	0.6-0.8 mils DFT per full wet coat
Coverage	208 sq. ft. @ 1 mil

Application

Apply 2-3 full wet coats to provide filling and leveling of sand scratches and minor imperfections on refinish surface. Allow 10 to 15 minutes between full wet coats. Time may vary due to heat and humidity conditions. Adjust accordingly with the appropriate temperature color grade lacquer thinner.

Drying

Sand Time	20 - 30 minutes with appropriate Lacquer Thinner
Recoat	30 minutes dry time, sand with 400 grit before recoating with primer or sealer.
Topcoat	30 minutes dry time, sand with 400 grit before topcoating with lacquer or enamel.

Physical Data

Volume Solids RTS	13%
Pot Life	Indefinite
VOC (sprayable)	4.8lbs/gal.
Humidity Resistance	Good
Salt Spray Test	Good
Lead & Chromate	Lead & Chromate Free

Master Tips

It is important to choose the proper temperature range lacquer thinner. Accelerated evaporation can actually condense water vapor within primer surfacer and severely reduce primers adhesion and sanding properties. Sealing is recommended if topcoating with a urethane or synthetic enamel topcoat. Allow an extended flash off time after the use of wax & grease removers due to primers porous nature.