

2K Regular Build Primer

4:1

06/2013

Product Numbers:

6500-1B Buff / Yellow - Gallon

6520-1G Gray - Gallon

6530-1 Black - Gallon

6501-4 Activator - Quart

Gun Tip: 1.7 – 2.5

Mix:

4:1

4 parts primer to 1 part activator. Mix / stir activator in very well for at least one minute. This primer can be reduced with SPI urethane reducers 870, 885 and 895. Do not reduce more than 25%.

Pot Life:

45-60 minutes at 75°

Spraying:

Always coat bare metal with epoxy first!

Mix only what you immediately need and clean the gun when you are finished. Spray a full wet coat and let it flash. Spray a total of two or three coats being sure to let each coat flash before spraying the next coat. Flash times will vary from 3-5 minutes depending on temperature.

Filling:

This primer is the same as our High Build Primer except it will spray a little thinner at about 1.8 to 2.0 mills per coat depending on the primer / paint gun used. This is an excellent primer for the high quality shop that does not need a very high filling primer. This primer is made to fill like the major paint manufacturers best 2K primers. A sealer is not required for this primer prior to painting.

Sanding:

Depending on how you applied it and current temperature this primer should be ready to sand in 30 minutes. If sanded primer has set more than 24 hrs, you must scuff first with a red scuff pad or equivalent before applying another product.

Winter:

Add 2oz of SPI 900-4 Polar Accelerator in shops with inadequate heat.

Summer Heat:

Add 2oz of SPI 925 Retarder per sprayable quart if pinholes are a problem.