

2K20 PRIMER SURFACER (LOW VOC)

DESCRIPTION: 2K20 Primer Surfacer is a low VOC, two-component high-build primer surfacer. 2K20 Primer Surfacer provides exceptional build and good enamel holdout in combination with all U-Tech topcoats. The VOC is 2.1 lbs/gal ready to spray, making it compliant in even the most highly regulated areas.

PRODUCT & ADDITIVES:

PRODUCT: 2K20 Primer Surfacer

ACTIVATOR: 2K20 Activator



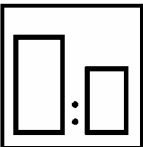
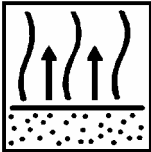
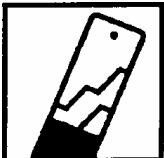
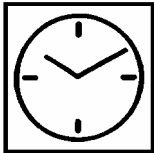
BASIC RAW MATERIALS:

- 2K20 Primer Surfacer: acrylic urethane resins
- 2K20 Activator: polyisocyanate resin and solvent

SUITABLE SUBSTRATES:

- 2K20 Primer Surfacer can be applied over:
- Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry.
 - Any premium polyester bodyfiller sanded with #P180 to #P220 grit dry.
 - Steel, degreased and sanded with #P80 then #P120 grit dry.
 - Fiberglass gelcoat (unbroken), degreased and sanded with #P220 to #P320 grit dry.
 - 2K20 Primer Surfacer can be applied over one coat of SE58 Self Etching Primer LF without sanding after a flash off of 30 minutes at 70°F (20°C).
 - Carbon steel (Note: Not for large areas of bare metal, use SE58 Self Etching Primer LF prior to application.)

APPLICATION:

- | | | | | | |
|----|---|---|----|--|--|
| 1. |  | Contains acrylic resins and other ingredients. When mixed, also contains isocyanates. | 4. |  | 2–3x1
Spray two to three wet coats. |
| 2. |  | 4:1
2K20 Primer Surfacer
2K20 Activator | 5. |  | 5 minutes at 70°F (20°C) |
| 3. |  | Use the U-Tech Measuring Stick. | 6. |  | 3 coats
1 hour at 70°F (20°C)
20 minutes at 140°F (60°C) |



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MIXING RATIO: 4 parts by volume of 2K20 Primer Surfacer
1 part by volume of 2K20 Activator/hardener
For easy and accurate mixing, use the U-Tech Measuring Stick

PLASTIC PARTS: For use over plastic body parts, mix 2K20 Primer Surfacer as follows:
Flexible Parts:
2 parts by volume of 2K20 Primer Surfacer
1 part by volume U-Tech Flex Agent
This will then require further mixing:
4 parts by volume of 2K20 Primer Surfacer with U-Tech Flex Agent
1 part by volume of 2K20 Activator/hardener

**SPRAY GUN
& PRESSURE:**

	Fluid Tip	Spraying Pressure
HVLP Siphon	1.8–2.2 mm	max. 10 psi
HVLP Gravity	1.7–2.0 mm	max. 10 psi

**APPLICATION
METHOD:**

Apply 2 or 3 single coats. Allow a 5 minutes flash-off time between each coat or until completely mat. The number of coats depends on the film thickness desired.

**SPRAYING
VISCOSITY:**

40 seconds ZAHN cup #2 (36 seconds DIN #4) at 70°F (20°C).

POT LIFE:

30 minutes at 70°F (20°C)

DRYING TIMES:

Dry to Sand

	70°F (20°C)	140°F (60°C)
Three coats	1 hour	20 minutes

SANDING:

Dry sand: Pre-sand with #P320 grit paper dry, final sand with #P500 to #P600 grit dry.

Wet sand: Pre-sand with #P500 grit paper wet, final sand with #P600 to #P800 grit wet.

RECOATABILITY:

2K20 Primer Surfacer can be topcoated with U-Tech Basecoats and all Utech Single Stage topcoats. 2K20 Primer Surfacer can be sealed, after sanding, with any compliant U-Tech wet-on-wet product.

**DRY FILM
THICKNESS:**

1.0-1.2 mils per single coat.

**CLEANING OF
EQUIPMENT:**

Use Extra Strong Cleaning Solvent, or lacquer thinner.



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STOCK KEEPING:

COLOR: Grey

SHELF LIFE: 2K20 Primer Surfacer: One year if stored unopened at room temperature.
2K20Activator/hardener: One year if stored unopened at room temperature.

SAFETY ASPECTS:

**READY TO
SPRAY VOC:** 2K20 Primer Surfacer: 2.1 lb/gal 256 g/liter

NOTICE: Do not handle until the Material Safety Data Sheets have been read and understood. Regulations require that all employees be trained on Material Safety Data Sheets for all chemicals with which they come in contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist.