



TECHNICAL DATASHEET

PRIMEWORX (2.1 VOC)

ART. NO: #190.240.21 (1G Light Grey), #190.241.21 (1G Dark Grey), #190.242.21 (1G Black)

PRIMEWORX 2.1 VOC is a fast 2K high build primer designed for car refinishing as well as for use on industrial vehicles. With easy sandability and excellent adhesion to steel, aluminum and galvanized metals, PRIMEWORX not only offers excellent coverage and hiding power, but is extremely versatile across various applications.

FEATURES

- ✓ Fast high build or surface primer
- ✓ Grinds finer for easier sanding
- ✓ Excellent coverage and hiding power
- ✓ Recoatable with all basecoats
- ✓ Adheres directly to all metals & e-coats
- ✓ Excellent levelling properties
- ✓ No shrinkage
- ✓ VOC compliant
- ✓ Available in 3 colors

COMPATIBLE SURFACES

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

COMPATIBLE TOPCOAT

- ✓ Water & Solvent basecoats
- ✓ Sanded 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	85	0.7
Regulatory VOC (less water & exempt solvents)	161	1.3
Density	1.52	12.7
	WEIGHT %	VOLUME %
Total Solid Content	64.5%	43.5%
Total Volatile Content	35.5%	56.5%
Water	0%	0%
Exempt Compound Content	29.9%	47.2%

Hardener (Part B) VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
	g/L	LBS/GAL
Actual VOC	257	2.1
Regulatory VOC (less water & exempt solvents)	409	3.4
Density	1.03	8.6
	WEIGHT %	VOLUME %
Total Solid Content	37.5%	33.4%
Total Volatile Content	62.5%	66.6%
Water	0%	0%
Exempt Compound Content	37.5%	37.2%

RTS VOC Regulatory Data For USA (National Rule & Low VOC) / Canada		
Coating Category	Primer	
Mixing Ratio	4:1:0.5	
	g/L	LBS/GAL
Actual VOC	118	1.0
Regulatory VOC (less water & exempt solvents)	215	1.8
Density	1.42	11.9
	WEIGHT %	VOLUME %
Total Solid Content	61%	41.7%
Total Volatile Content	39%	58.3%
Water	0%	0%
Exempt Compound Content	35.7%	52.6%

PRODUCT DATA

Dry Film Thickness / coat (DFT): 2.0

Coverage: 326 Sq. Ft. / gal @ 2 mil*

Product Type: Polyurethane

Color: Light Grey, Dark Grey, Black

Shelf Life: 24 months

Package: 1 Gallon

Number per case: 4

Safety Data Sheet (SDS) is available on our website



HANDLING AS A SURFACER PRIMER

MIXING

Make sure product is at room temperature 70°F (20°C) before mixing

- 4 Parts Primer:** # 190.240.21 (1G) - Light Grey
- # 190.241.21 (1G) - Dark Grey
- # 190.242.21 (1G) - Black

1 Part Activator: # 191.240M - Medium (1QT)

½ Part Reducer: # 192.001 (1G) - Slow



APPLICATION VISCOSITY

20 - 40 s. with a viscometer Ford #4 at room temperature 70°F (20°C)



POT LIFE

1 hour @ 70°F (20°C)



GUN SETUP

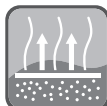
HVLP 1.8mm - 2.0mm 15 - 25 psi @ gun



APPLICATION

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

Recommended Thickness: 2.5 - 3.5 mil (65 - 90 µm)



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

Air Dry: 1 - 2 hours @ 70°F (20° C)



FORCE DRY

30 minutes @ 140°F (60°C)



INFRARED DRYING

Medium Activator: 12 - 15 minutes @ Middle Wave



SANDING & BUFFING

Optimum Times: **Force Dry:** 30 minutes after cool down

Air Dry: 1.5 - 2.5 hours

Sanding:

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

TECHNICAL DATASHEET



HANDLING AS A HIGH BUILD PRIMER

MIXING

Make sure product is at room temperature 70°F (20°C) before mixing

4 Parts Primer: # 190.240.21 (1G) - Light Grey
 # 190.241.21 (1G) - Dark Grey
 # 190.242.21 (1G) - Black

1 Part Activator: # 191.240M - Medium (1QT)

½ Part Reducer: # 192.001 (1G) - Slow



APPLICATION VISCOSITY

50 - 70 s. with a viscometer Ford #4 at room temperature 70°F (20°C)



POT LIFE

1 hour @ 70°F (20°C)



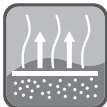
GUN SETUP

HVLP 2.0mm - 2.2mm 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
Recommended Thickness: 3.5 - 4.5 mil (90 - 115 µm)



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
Air Dry: 1 - 2 hours @ 70°F (20° C)



FORCE DRY

30 minutes @ 140°F (60°C)



INFRARED DRYING

Medium Activator: 12 - 15 minutes @ Middle Wave



SANDING & BUFFING

Optimum Times: **Force Dry:** 30 minutes after cool down
Air Dry: 1.5 - 2.5 hours

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