

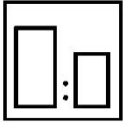


# 2K (HB) Primer Surfacer

**FOR PROFESSIONAL USE ONLY**

## Description

2K HB Primer Surfacer is a two-component fast curing high-build urethane primer surfacer. 2K Primer Surfacer provides exceptional build and good holdout in combination with all U-TECH topcoats. The ready-to-spray VOC is 4.2 lbs/gal



4      2K HB Primer Surfacer  
1      2K HB Activator

Use AkzoNobel Measuring Stick



**109**



Spray gun setup:

Check gun manufacture specification

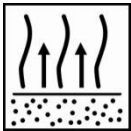
RP – Gravity Feed  
HVLP – Gravity Feed

1.5 – 2.0mm  
1.7 – 2.2mm

30 – 35psi  
Max 10psi (cap)



Apply two (2) to three (3) single flowing coats



Between coats  
5 minutes at 70°F (21°C)



Dry to sand

70°F (21°C)

140°F (60°C)

1 hr

20 min



Use suitable respiratory protection  
AkzoNobel recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information





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### Suitable Surfaces

Existing finishes	#P220 to #P320 grit dry
Polyester bodyfiller	#P180 to #P220 grit dry
Aluminum (Alodine)	#P180 to #P220 grit dry followed by Deoxidine 457 and Alodine 5700 pretreatment
Aluminum (Autoprep)	#P180 to #P220 grit dry followed by Autoprep pretreatment wipes
Steel (spot repair)	#P80 then #P120 grit dry or red pad. Not for large areas of bare metal, use U-TECH epoxy primer or an approved metal pretreatment
Galvanized steel	#P180 grit dry or red pad
Fiberglass gelcoat (unbroken)	#P220 to #P320 grit dry
Flexible Plastic Body Parts (pre-painted)	#P220 to #P320 grit dry. Use LV Flex Additive, see mixing section

### Raw flexible plastic body parts require PAP 722 Clear adhesion promoter

Properly degrease substrate prior to sanding with Autoclean surface cleaner and R859 wax and grease remover.

### Product and Additives

<b>Product</b>	2K HB Primer Surfacer
<b>Hardener</b>	2K HB Activator
<b>Additives</b>	LV Flex Additive

### Basic Raw Material

2K HB Primer Surfacer	Acrylic urethane resins
2K HB Activator	Polyisocyanate resin and solvent
LV Flex Additive	Special polyester resins

### Product Characteristics

WPG (a-component)	11.5 +/- 0.4 lbs/gal	Gloss	Low
Volume Solids (RTS)	43 +/- 2%	Color	Grey and Buff
Theoretical Coverage	690 ft <sup>2</sup> /gal @ 1mil – 100%TE	Pot Life	15 min @ 70°F (21°C)





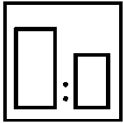
## 2K (HB) Primer Surfacer

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### Mixing

Standard mix ratio (by volume)  
4 2K HB Primer Surfacer  
1 2K HB Activator

Flexible Pre-painted Plastic Parts mix ratio (by volume)  
100 2K HB Primer Surfacer  
15 LV Flex Additive

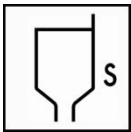


Then mix (by volume)  
4 2K HB Primer Surfacer (Flexed)  
1 2K HB Activator

Use AkzoNobel Measuring Stick #109

**Note: Raw flexible plastic body parts require PAP 722 Clear adhesion promoter**

### Viscosity



2K HB Primer Surfacer

16 – 22 sec  
25 - 45 sec

EZ ZAHN #3 at 70°F (21°C)  
DIN #4 at 70°F (21°C)

Viscosities are reported as Ready to Spray

### Spray gun set-up / application pressure



RP – Gravity Feed  
HVLP – Gravity Feed

1.5 – 2.0mm  
1.7 – 2.2mm

30 – 35psi  
Max 10psi (cap)

### Application



Apply two (2) or three (3) single coats



## 2K (HB) Primer Surfacer

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### Flash off



5 minutes at 70°F (21°C) between coats

### Dry times



	70°F (21°C)	140°F (60°C)
Dry to sand	1 hour	20 minutes

**Note: Using LV Flex will extend curing times and effect the sandability of 2K HB Primer Surfacer**

### Dry Film Thickness

1.7 – 5.0 mils

Apply 1.7 – 2.0 mils per coat

### Sanding



Final dry sanding step use #P400 – 500 before application of topcoats

*Initial sanding steps may be executed with a coarser sanding grit: #P320*

### Recoatability

2K HB Primer Surfacer can be sealed or topcoated, after sanding, with any U-TECH sealer, single stage or basecoat systems.

### Cleaning of equipment

Clean equipment with extra strong cleaning solvents



## 2K (HB) Primer Surfacer

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### VOC

2K100 Primer Surfacer

4.2 lb/gal

504 g/l

VOC is ready to spray at a mix ratio of 4:1

### Product Storage and Shelf Life

Store products unopened and used products with closed lids. Store products between 70°F-95°F (21°C-35°C). Optimal storage temperature is 77°F (25°C). Avoid extreme temperature fluctuation when storing.

2K HB Primer Surfacer

2 years

2K HBActivator

1 year

LV Flex Additive

1 year

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**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

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