

# 2K High Build Primer

2.1 VOC

## **Product Numbers:**

8000-1 Gray (gallon)

7001-4 Activator (quart)

## **Mixing: 4:1**

Mix 4 parts Build Primer to 1 part Activator. This primer can be reduced with SPI Urethane Reducers 870, 885, and 895 or equivalent Low VOC reducers if less millage is desired. Do not reduce more than 25%.

**Caution! Due to the thickness of this primer it is very important that you completely mix the activator in with the primer. MIX ONE FULL MINUTE!**

## **Pot Life:**

60 minutes at 70 degrees. Do not leave mixed product in the paint gun for more than 30 minutes.

**Spraying:** Gun tip recommendation 2.0 – 2.5

**Always coat bare metal with epoxy first! Remove any cup strainers or filters before spraying.** Mix only what you immediately need and clean the gun when you are finished. Spray one wet coat and let it flash 5 minutes then apply a second coat. You can apply as many coats as you like but it's very important that each coat flashes before applying additional coats.

## **Sanding:**

Depending on how High Build Primer is applied you should be able to sand this product in 45-60 minutes. Keep in mind this time changes with temperature. This primer sands good but to make it easier shoot your coats to be blocked non-reduced and reduce your final coat 10-15% for less build and less final blocking. If sanded primer has set more than 24 hours you must scuff first with a gray scuff pad or equivalent before applying another product.

## **Winter:**

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

## **Summer:**

Add 2-6oz of SPI 925-4 Urethane Retarder per sprayable quart if the primer is drying too fast.