

Technical Data Sheet

S2KP1 SUPER 2K PRIMER / S2KA4 SUPER 2K ACTIVATOR

PRODUCT DESCRIPTION:

S2KP1 / S2KA4 is a new generation Low V.O.C. direct to metal, super high build urethane primer-surfacer/sealer. Designed for use under all single stage or basecoat/clearcoat systems. Excellent adhesion to cut through bare metal areas (no bigger than a basketball size area) and direct to unsanded E-coat, on undersides of hoods, fenders and jambs.

SUBSTRATES:

1. Properly prepared steel
2. All properly prepared rigid and semi-rigid auto body parts
3. Properly cleaned inside surfaces of new e-coat parts (apply without sanding). NOTE: It is recommended that outer surfaces be scuffed/sanded before applying.
4. Clean, properly sanded O.E.M. or refinish coatings
5. Apply over all types and brands of polyester fillers and glazing putties

FEATURES:

1. Very fast dry time; dries in 1 hour or less depending on reducer speed
2. Excellent adhesion
3. Built in corrosion resistance
4. Superior color holdout due to excellent solvent resistance
5. Superior chip resistance
6. Versatile applications ranging from high build to medium build primer-surfacer or as a sealer
7. Excellent filling properties
8. Easy sanding in as little as 50 minutes.
9. Cost saver

SURFACE PREPARATION:

1. Wash prime area with mild detergent and water.
2. Clean area with PC1 Wax-n-Grease Remover.
3. Sand as needed to remove rust or corrosion.
4. Re-clean with PC1 Wax-n-Grease Remover.

5. For large bare metal areas, apply one to two coats of PCSEP1 / PCSEA1. Can be applied directly to clean and dry bare metal cut through areas.
6. Apply S2KP1 as needed, selecting the reduction ratio suitable for the job. Allow 15 minutes flash between coats.
7. Allow 50 minutes or more, depending on the amount of primer applied. Heavy primer coats will lengthen dry time.
8. High build can be accelerated with UA8 Universal Accelerator for quick sanding in cold weather conditions. Using UA8 will reduce pot life.

PRE-PAINTED SURFACES:

1. Wash areas thoroughly with soap and water.
2. Clean thoroughly with PC1 Wax-n-Grease Remover.
3. Sand and featheredge area as needed.

MIXING INSTRUCTIONS:

| | Products | HIGH BUILD | MEDIUM BUILD | SEALER |
|-----------------|--------------------------|-------------------|---------------------|---------------|
| | S2KP1 Super 2K Primer | 4 Parts | 4 Parts | 4 Parts |
| | S2KA4 Super 2K Activator | 1 Part | 1 Part | 1 Part |
| REDUCERS | URF1 | 5 – 10 % | 15 – 20 % | 1 Part |
| | URM1 | 5 – 10 % | 15 – 20 % | 1 Part |
| | URS1 | 5 – 10 % | 15 – 20 % | 1 Part |
| | URXS1 | 5 – 10 % | 15 – 20 % | 1 Part |

APPLICATION INSTRUCTIONS:

1. Use 30 to 45 P.S.I. air pressure at gun.
2. Apply even wet coats allowing 15 minutes flash between coats.
3. Finish sand with 320 grit or finer wet or dry sand paper following paint manufacturers recommendations. Initial sanding can be done with 180-220 grit paper.

CLEANING:

Use good quality lacquer thinner or urethane reducer (URF1/URM1/URS1/URXS1) to thoroughly clean all equipment.

RECOMMENDED TOPCOATS:

1. Acrylic and polyurethane topcoat
2. Acrylic basecoat/clearcoat finishes
3. Acrylic or synthetic enamel finishes
4. S2KP1 as a Sealer or EP1, EP4 Epoxy Primer/Sealer

TECHNICAL DATA:

| | |
|----------------------|----------------------|
| Color: | Beige |
| Pot Life: | 90 minutes |
| Mix Ratio: | 4:1 before reducer |
| Weight Solids: | 66.1% |
| Volume Solids: | 47.1% |
| Film Build: | 3 Mils wet (approx.) |
| Flash Point: | 23 F |
| Packaged V.O.C.: | 4.1 lbs/gal |
| Weight per Gallon: | 12.01 |
| High build V.O.C.: | 4.4 lbs/gal |
| Medium build V.O.C.: | 4.4 lbs/gal |
| Sealer V.O.C.: | 4.7 lbs/gal |