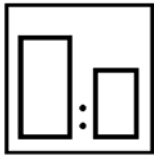


# P80 2K Primer

## FOR PROFESSIONAL USE ONLY

### Description

A two component primer offering a high build film, quick application, easy sanding and good color holdout.



4 P80 2K Primer  
1 U2KA Activator  
10%-30% R200 Reducer (Optional)



Use measuring stick  
# 109

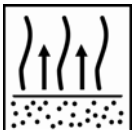


Spray gun set-up:  
1.5-1.8 mm  
HVLP max. 10 psi at air cap

Application pressure:  
40-50 psi ( 3-4 bar )  
o Check gun manufacturer specification



2-3 x 1 coat  
Apply single coats



Between coats  
3-5 minutes at 70°F (20°C)



| Dry Times | 70°F (20°C) | 140°F (60°C) |
|-----------|-------------|--------------|
| Touch     | 20 Minutes  | N/A          |
| Handle    | 1.5 Hours   | 30 Minutes   |



Use suitable respiratory protection  
Akzo Nobel Car Refinishes recommends the use of a fresh air supply respirator

Read complete TDS for detailed product information

# P80 2K Primer

## FOR PROFESSIONAL USE ONLY

### Description

A two component primer consisting of one primer, one universal hardener that can be used in the C320 Clear.

### Product and additives

|                  |                         |
|------------------|-------------------------|
| <b>Product</b>   | P80 2K Primer           |
| <b>Hardener</b>  | U2KA Activator          |
| <b>Reducers</b>  | R200 Reducer (Optional) |
| <b>Additives</b> | None                    |

### Basic raw materials

P80 2K Clear: Acrylic resin, organic and inorganic pigments, solvents  
U2KA Activator: Poly-isocyanate solvents

### Suitable substrates

- Existing finishes, degreased and sanded with #P220 to #P320 grit paper dry.
- Any premium polyester bodyfiller sanded with #P180 to #P220 grit dry.
- Aluminum after it has been properly treated.
- Steel, degreased and sanded with #P80 then #P120 grit dry. (Note: Not for large areas of bare metal use SE58 Self Etching Primer LF prior to application.)
- Fiberglass gelcoat (unbroken) degreased and sanded with #P220 to #P320 grit dry.
- P80 2K Primer 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).

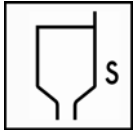
### Mixing Ratio



4 parts by volume of P80 2K Primer  
1 parts by volume U2KA Activator  
10% -30% R200 Reducer (Optional)

For easy and accurate mixing, use measuring stick No. 109

### Viscosity



20-60 seconds – DIN Cup #4 at 70°F (20°C)  
40-50 psi at the spray gun air inlet

### Spray gun set-up / application pressure



#### Spray gun

HVLP gravity  
High Transfer gravity  
High Transfer Pressure Feed  
HVLP Pressure Feed

#### Fluid tip – set-up

1.7-2.0 mm  
1.7-2.0 mm  
1.5-1.7 mm  
N/A

#### Application pressure

HVLP max 10 psi at the air cap  
Check gun manufacturer specification.

# P80 2K Primer

## FOR PROFESSIONAL USE ONLY

### Application process



Apply two-three coats, allowing for a 3-5 minutes flash off time.

### Pot-life

3 hours at 70°F (20°C)

### Film thickness

Per coat: 1.0-2 mils. (25-50 µm)  
The total dry layer thickness: 1.3-1.8 mils. (32-46 µm)

### Drying times



|                 |               |            |
|-----------------|---------------|------------|
| 70°F<br>(20°C)  | Touch         | 20 minutes |
|                 | Dry to handle | 1.5 hours  |
| 140°F<br>(60°C) | Touch         | 1.5 hours  |
|                 | Dry to handle | 30 minutes |

# P80 2K Primer

## FOR PROFESSIONAL USE ONLY

### Sanding



Dry Sand: begin with #P320 and end with #P400 grit paper dry  
Wet Sand: begin with #P400 and end with #P600 grit paper wet

### Material usage

- With recommended application, the theoretical material usage is  $\pm 533$  sq.ft./gl (13 m<sup>2</sup>/liter) per coat.
- *The practical material usage depends on many factors i.e. shape of the object, roughness of the surface, application techniques, pressure, method and application circumstances.*

### Cleaning of equipment

Clean equipment with solvent borne cleaners

### VOC

(4:1 Ready to spray mixture) P80 2K Primer:      2.1 lb/gal    250 g/liter – Need data from lab

### Product storage

- Store products unopened, and used products with closed lids preferably between 60°F-95°F (10°C-35°C)  
Avoid too much temperature fluctuation, optimal storage temperature approximately 70°F (20°C)
- *Product shelf life: 2 years*

## FOR PROFESSIONAL USE ONLY

**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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