GENERAL INFORMATION
RP2100 is a 2.1 VOC High Solids Primer Filler designed to offer superior fill, productive dry, ease of sanding, and excellent adhesion.

1. COMPONENTS
• RP2100 High-Solids Urethane Primer
• RH4201 Urethane Hardener

2. MIXING RATIO
Mix four (4) parts RP2100 with one (1) part RH4201 (4:1)

3. POT LIFE @ 77°F (25°C)
30 min to 1 hour

4. CLEAN UP
Check local regulations.

5. SURFACE PREPARATION
• Wash surface with mild detergent and rinse with water. Dry surface.
• Wipe with a post sanding cleaner following manufacturer’s directions.
• Sand and featheredge substrate P220-P320 grit.

6. SUBSTRATES
• Properly treated steel, aluminum and galvanized metals.
• Fiberglass
• SMC
• Properly sanded OEM finishes
• Epoxy Primers
• Etching Primer

7. APPLICATION
Number of Coats: 1-3
Application Density: Medium-wet to wet
Overlap: 50%
Flash: 5-10 min or until surface is dull
Film Thickness Range:
Dry: 2.0 mils - 3.0 mils/50 - 75 μm
Wet: 4.0 mils - 6.5 mils/100 - 260 μm
Application Conditions:
Min. Temp: 50°F/10°C (Substrate Temp.)
Max. Temp: 100°F/38°C (Substrate Temp.)
Ambient Humidity: Less than 80% preferred

8. FLASH / DRY TIMES
Ambient Application (Reported at 77°F/25°C and 80% Humidity)

<p>| | |</p>
<table>
<thead>
<tr>
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<tbody>
<tr>
<td>Flash Between Coats</td>
<td>10 min</td>
</tr>
<tr>
<td>To Sand</td>
<td>1 hour</td>
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<tr>
<td>To Topcoat</td>
<td>1 hour</td>
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Force Dry (Convection Heat of 145°F/60°C)

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<thead>
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<tbody>
<tr>
<td>Purge time before applying heat</td>
<td>10 minutes</td>
</tr>
<tr>
<td>Force Dry Time</td>
<td>20 minutes @ 145°F/60°C</td>
</tr>
<tr>
<td>Sand</td>
<td>After cool down</td>
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</tbody>
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9. GUN SET UP
CONVENTIONAL
Gravity Feed: 1.4 mm - 1.8 mm
Siphon Feed: 1.6 mm - 2.0 mm
HVLP: 1.4 mm - 1.8 mm

AIR PRESSURES
Conventional @ Gun
Gravity Feed: 30-40 psi (2.0-2.8 bar)
Siphon Feed: 35-50 psi (2.5-3.4 bar)
HVLP Inlet Air: See spray gun manufacturer info

10. PHYSICAL DATA

<table>
<thead>
<tr>
<th>RTS REGULATORY DATA:</th>
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<tbody>
<tr>
<td>(No Reducer)</td>
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<tr>
<td>Actual VOC</td>
<td>1.7 Max.</td>
</tr>
<tr>
<td>Regulatory VOC (less water and exempt solvents)</td>
<td>2.1 Max.</td>
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<tr>
<td>Density</td>
<td>11 - 14</td>
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<tr>
<td>Total Volatile Content</td>
<td>25 - 45</td>
</tr>
<tr>
<td>Water Content</td>
<td>0</td>
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<tr>
<td>Exempt Compound Content</td>
<td>20 - 35</td>
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</tbody>
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4:1
LBS./GAL        g/L
Actual VOC       1.7 Max.        200 Max.
Regulatory VOC   2.1 Max.        250 Max.
Density          11 - 14          1320 - 1680
Total Volatile Content | 25 - 45 |
Water Content    | 0      |
Exempt Compound Content | 20 - 35 |

If used as instructed, this product is designed to comply with VOC standards in low-VOC jurisdictions. Confirm compliance with state and local air quality rules before use.