TECHNICAL DATA SHEET

FP410 – 2K HS Primer

DESCRIPTION

FP410 is a premium two-component primer surfacer designed for high build and excellent filling of repairs. It provides excellent adhesion and gloss / color holdout. FP410 sands easily without clogging the sandpaper, while providing excellent resistance to sand scratch swelling.

PHYSICAL DATA

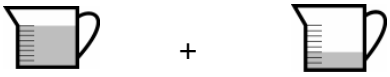
- VOC Sprayable: 4.38 lbs/gal
- Pot Life: @ 70°F = 1 hour
  @ 80°F = 45 min.
  @ 90°F = 30 min.

SUBSTRATES

- Properly Treated Steel*
- Treated Aluminum
- Fiberglass / SMC
- OEM Finishes
- Refinish Lacquers, Enamels, and Urethanes
- Etching Primers

*Steel must be treated with an Etching Primer or Metal Etch.

MIXING



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FP410
2K HS Primer

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FH411
Hardener

APPLICATION

- Adjust air pressure to: 30-40 psi for siphon feed gun
  20-30 psi for gravity feed gun
  30-40 psi for pressure feed gun with 5-10 psi pot pressure
  5-7 psi at the cap for HVLP gun
- Apply 2 – 3 medium coats, at a gun distance of 5” – 7” inches, with 5 – 10 minutes flash time between coats.
- Recommended dry film thickness after sanding is 2.0 – 2.5 mils.
- Maximum dry film thickness is 6 mils after sanding.
- Clean spray gun with an appropriate gun cleaner, immediately after use.

DRYING

Air Dry:	1.5 – 3 hours @ 70°F
Force Dry:	30 minutes @ 140°F
Short Wave Infrared:	15 minutes on high setting, @ 24” inches distance. **Note:** Purge for 10 minutes before using short wave infrared.
To sand:	2 hours for air dry, and upon cool down for force dry and short wave infrared.

Note: Excessive film builds and cooler temperatures will extend dry times.

Final Sanding	Sandpaper Grit
To seal	P400*
To topcoat	P600*
	*or equivalent

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