

## PRODUCT DATA SHEET

### FP415 2.1 2K High Build DTM Primer

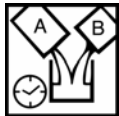
PRODUCT AT-A-GLANCE



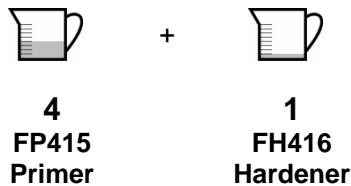
#### SUBSTRATES

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

\* For complete refinishing of larger bare metal areas, it is recommended to use an etch primer to ensure complete corrosion protection.

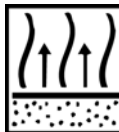


#### MIXING



#### APPLICATION

- Apply 2 – 3 even, full wet coats, at a gun distance of 5" – 7" inches. Allow each coat to flash to a dull finish, until necessary film build is achieved.
- HVLP = 5 – 7 psi @ cap.
- Recommended dry film thickness after sanding is 2.0 – 2.5 mils.
- Clean spray gun with an appropriate gun cleaner, immediately after use.



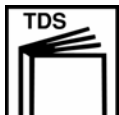
#### DRYING

Air Dry: 1 – 2 hours @ 70°F  
 Force Dry: 20 – 30 minutes up to 140°F  
 Short Wave Infrared: 5 minutes flash, 10 minutes on high setting @ 36" inches distance.  
**Note:** Purge for 10 minutes before using short wave infrared.

To sand: 90 minutes for air dry. Upon cool down for force dry and short wave infrared.

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

<u>Final Sanding</u>	<u>Sandpaper Grit</u>
To seal	P400*
To topcoat	P600*



#### PHYSICAL DATA

- VOC Sprayable: 1.9 lbs/gal
- Pot Life (below 90°F and 50%RH): 1 hour
- Theoretical coverage: 742 square feet/gal @ 1 mil dry

**PRODUCT DESCRIPTION:**

FP415 is a two component, low VOC primer surfacer. This primer offers a high film build, excellent gloss holdout, and excellent sanding characteristics.

**SURFACE PREPARATION:**

**Bare Substrates:**

Repairs or sand-throughs can be directly primed without etching.

1. Solvent clean with appropriate surface cleaner and wipe dry with a clean, dry cloth.

**Prepainted Substrates:**

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
2. Solvent clean with appropriate surface cleaner and wipe dry with a clean, dry cloth.
3. Sand repair area and featheredge using 80, 180, 280, 320 and finish with 400 grit treated sandpaper on a random orbital sander, thus extending the repair area to accommodate the primer application. Solvent clean with appropriate surface cleaner and wipe dry with a clean, dry cloth.



**PERSONAL PROTECTION**

- For use by trained professionals only.
- Read label, directions, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.

**REGULATORY DATA**

	As Packaged		As Applied	
	G/L	Lbs/Gal	G/L	Lbs/Gal
VOC Total	152	1.26	143	1.19
VOC Less Exempt	253	2.11	228	1.90
	Lbs/Gal Solids	Lbs/Lbs Solids	Lbs/Gal Solids	Lbs/Lbs Solids
HAPs	.005	.04	.048	.40
	Wt.%	Vol.%	Wt.%	Vol.%
Volatiles	34.6	57.2	35.8	53.7
Water	0	0	0	0
Exempt Compounds	23.6	40.1	25.0	37.3
	G/L	Lbs/Gal	G/L	Lbs/Gal
Density	1387	11.58	1323	11.04