



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)

Flash Between Coats	10 minutes
To Sand	1 hour
To Topcoat	1 hour

Force Dry (Convection Heat of 145°F/60°C)

Purge time before applying heat	10 minutes
Force Dry Time	20 minutes @ 145° F/60°C
Sand	After cool down



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: 30 psi (2.0 bar)
 See spray gun manufacturer info



10. PHYSICAL DATA

RTS REGULATORY DATA:	4:1	
	(No Reducer)	
	LBS./GAL	g/L
Actual VOC	1.7 Max.	200 Max.
Regulatory VOC (less water and exempt solvents)	2.1 Max.	250 Max.
Density	11 - 14	1320 - 1680
	WT. %	VOL. %
Total Volatile Content	25 - 45	40 - 60
Water Content	0	0
Exempt Compound Content	20 - 35	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.