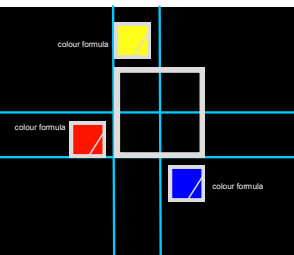


LOW VOC UNDERCOATS



	A-614™ LOW VOC ETCH PRIMER	A-513™ AEROSOL SELF ETCH PRIMER	A-618™ & A-619™ 2.1 VOC EPOXY PRIMER	A-536™ & A-537™ 2.1 VOC DTM PRIMER	A-509™ & A-510™ 2.1 VOC 2K URETHANE PRIMER	A-524™ PLASTIC BUMPER PRIMER CLEAR (RTS)	A-525™ AEROSOL PLASTIC ADHESION PROMOTER	A-540™ & A-542™ 2.1 VOC SEALER
DESCRIPTION	Etch with excellent adhesion and corrosion protection	Ready-to-use 1K Self Etch Primer	Epoxy with excellent adhesion and corrosion protection	High build, fast dry direct to metal primer	High quality primer that provides excellent build and color holdout	Ready-to-use	Ready-to-use 1K Aerosol Plastic Adhesion Promoter	Wet on Wet 2K Sealer
NOTES	N/A	Shake vigorously for 2 - 3 minutes	20 minute induction time	N/A	N/A	* Compliant in Canada only - <u>not</u> in California	Shake can for 1 - 2 minutes Apply 1 light coat	N/A
ACTIVATOR	A-616™	N/A	A-620™	A-538™	PCA-550™, PCA-551™, PCA-552™ or PCA-553™	N/A	N/A	PCA-550™, PCA-551™ PCA-552™ or PCA-553™
REDUCER / THINNER	PCR-1772	N/A	N/A	PCR-1770™ or PCR-1772™ (Optional: add up to 1 part)	N/A	N/A	N/A	PCR-1770™ or PCR-1772™
MIX RATIO	1:1:1	N/A	1:1	4:1:up to 1	4:1	N/A	N/A	3:1:1
INDUCTION TIME	N/A	N/A	20 minutes	N/A	N/A	N/A	N/A	N/A
POT LIFE @ 72°F	24 hours	N/A	12 hours	2 hours	1 hour	N/A	N/A	45 minutes
FILLING	Low	Low	Good	Very Good	Excellent	Very Low	Very Low	Good
Film build per coat	0.5 - 1.0 mil	0.6 - 1.2 mils 2 - 3 passes: 1.2 - 2.0 mils	1.0 - 1.5 mils	2.0 - 3.0 mils	2.0 - 3.0 mils	0.04 - 0.08 mils	0.04 - 0.08 mils	0.8 - 1.0 mils
Coats to apply	1 - 2 coats	1 - 2 coats	2 - 3 coats	2 - 3 coats	2 - 3 coats	1 double coat	1 light coat	1 medium coat
CORROSION PROTECTION	Excellent	Excellent	Excellent	Very Good	Good	N/A	None	N/A
COLOR	Grey	Light Grey	A-618 (Grey) A-619 (Black)	Grey	A-509 (White), A-510 (Grey)	Clear	Clear	A-540 (Grey), A-542 (White)
DRY TIME @ 72°F	5 - 10 minutes between coats	1 - 2 minutes flash; 10 - 15 minutes air dry	10 - 20 minutes between coats	One hour per coat with 10 minutes flash between coats	1½ - 3 hours	10 minutes before topcoat	10 minutes before topcoat	15 - 20 minutes before topcoat
MINIMUM RECOAT TIME	30 minutes	Within 1 hour	1 hour	After sanding with P600 grit, topcoat within 24 hours	After sanding with P600 grit, topcoat within 24 hours	10 - 15 minutes	10 - 15 minutes	15 minutes
MAXIMUM RECOAT TIME (if exceeded)	After 24 hours, scuff and apply another coat	After 24 hours, scuff and apply another coat	48 hours	After 24 hours, clean primer and resand with P600 grit	After 24 hours, clean primer and resand with P600 grit	After 1 hour, primer should be lightly scuffed and recoated	After 1 hour, primer should be lightly scuffed and recoated	1 hour. Allow to air dry overnight or force dry; sand with P800 grit