



|                                   | <b>A-614™<br/>LOW VOC<br/>ETCH PRIMER</b>             | <b>A-513™<br/>AEROSOL<br/>SELF ETCH PRIMER</b>  | <b>A-618™ &amp; A-619™<br/>2.1 VOC<br/>EPOXY PRIMER</b> | <b>A-536™ &amp; A-537™<br/>2.1 VOC<br/>DTM PRIMER</b>  | <b>A-510™<br/>2.1 VOC 2K<br/>URETHANE PRIMER</b>                    | <b>A-524™<br/>PLASTIC BUMPER<br/>PRIMER CLEAR (RTS)</b>     | <b>A-525™<br/>AEROSOL PLASTIC<br/>ADHESION PROMOTER</b>     | <b>A-540™<br/>2.1 VOC<br/>SEALER</b>                                 |
|-----------------------------------|---|---|---|--|---|---|---|--|
| 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<br>Apply 1 light coat           | N/A  |
| ACTIVATOR                         | A-616™  | N/A   | A-620™  | A-538™   | PCA-551™, PCA-552™ or PCA-553™                                      | N/A   | N/A   | 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<br>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                                      | Grey & Black  | Grey   | Grey  | Clear   | Clear   | Grey   |
| DRY TIME @ 72°F                   | 5 - 10 minutes between coats                          | 1 - 2 minutes flash;<br>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   | 10 - 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 |