

Product Description A-514™ Chromate Free Etch Primer is a high quality etch primer that provides excellent adhesion and corrosion resistance to a variety of substrates. A-514 features an easy to use 1:1 mix ratio.

Components



Primers **A-514**
Activators **A-516**

Typical Substrates

- Bare steel
- Aluminum
- Automotive grade galvanized metals

Surface Preparation



Clean and dry the surface. Sand surface with P120 – P180 grit abrasive. Remove all sanding debris with ICR-1402™ or ICR-0014™.

Mix Ratio

Primer
Activator



1 Parts
1 Part
NOTE: Activated material must stand 10 minutes prior to application.

Pot Life @ 72°F / 22.2°C



24 hours
NOTE: Freshly mixed material will provide best corrosion resistance.

Viscosity @ 72°F / 22.2°C

18 – 21 secs DIN4

Gun Set Up



High Efficiency	HVLP
1.2 mm – 1.4 mm	1.2 mm – 1.4 mm

Air Pressure



High Efficiency	HVLP
15 – 29 psi @ the gun	6 – 10 psi max @ the cap

Application



2 medium coats.
5 – 10 minutes flash between coats.

Dry Times to Prime or Seal @ 72°F / 22.2°C



Flash	5 – 10 minutes between coats
Air Dry	30 minutes
Baking	N/A
Short Wave	N/A

Chromate Free Etch Primer

A-514

Sanding



Dry & D.A.: N/A

Water Sanding: N/A

Recoat

If etch primer has dried longer than 24 hours, scuff the surface with a scuff pad or P320 sandpaper and apply another coat.

Topcoats

When dry, topcoat with:

- Pro-Spray 2K Primers
- Pro-Spray 2K Sealers

NOTE: Do not apply DTM, Epoxy, or Polyester Primer over A-514 Chromate Free Etch Primer.

Special Notes / Clean Up



NOTE: Do not topcoat directly over Etch Primer with Single Stage or Basecoat.
Do not use P-2020™ Plasticizing Additive in A-514.
Do not use over plastic parts or body filler.

Clean Up Clean equipment after use with a cleaning solvent. Dispose of solvent according to state, local and federal regulations.

Physical Data

VOC (RTS) per U.S. Gal	6.18 lbs
Recommended Dry Film Thickness:	0.5 mil – 1 mil
Total Solids by Weight (RTS)	20.05%
Coverage - Sq. Ft. /100 ml (RTS)	5.74

Health and Safety



For professional use only. KEEP OUT OF REACH OF CHILDREN. WARNING! CONTENTS ARE FLAMMABLE. VAPOR AND SPRAY MIST IS HARMFUL. SKIN AND EYE IRRITANT.

Do not handle the Pro-Spray products until the Material Safety Data Sheets have been read and understood in their entirety. Ensure that all employees are trained on Material Safety Data Sheets and all chemicals with which they come into contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist. Wear protective clothing, gloves and eye safety with a side shield.

This data sheet information is given in good faith but without warranty. The information contained herein represents the current state of our knowledge and is intended as a guide to our products and their uses; it is not intended for insurance of certain product properties or of their specific applications.

Follow all warnings on product labels.