

# 2K Regular Build Primer

**4:1**

Rev. 06/2017

## Product Numbers:

6500-1B Buff / Yellow - Gallon

6520-1G Gray - Gallon

6530-1 Black - Gallon

6501-4 Activator - Quart

**Gun Tip: 1.8 – 2.5**

## Mix: 4:1

4 parts primer to 1 part activator. This primer can be reduced with SPI urethane reducers 870, 885 and 895 or 0 VOC reducers in compliant areas. Do not reduce more than 25%.

**CAUTION! Due to the thickness of this primer it is very important that you completely mix the activator in with the primer. MIX ONE FULL MINUTE!**

## Pot Life:

30-45 minutes at 75°

## Spraying:

**Always coat bare metal with epoxy first!**

Mix only what you immediately need and clean the gun when you are finished. Spray a full wet coat and let it flash. Spray a total of two or three coats being sure to let each coat flash before spraying the next coat. Flash times will vary from 3-5 minutes depending on temperature.

## Filling:

This primer is the same as our High Build Primer except it will spray a little thinner at about 1.8 to 2.0 mills per coat depending on the primer / paint gun used. This is an excellent primer for the high-quality shop that does not need a very high filling primer. This primer is made to fill like the major paint manufacturers best 2K primers. A sealer is not required for this primer prior to painting.

## Sanding:

Depending on how you applied it and current temperature this primer should be ready to sand in 30-60 minutes. If sanded primer has set more than 24 hrs, you must scuff first with a red scuff pad or equivalent before applying another product.

## Winter:

Add 2oz of SPI 900-4 Polar Accelerator in shops with inadequate heat.

## Summer Heat:

Add 2-4oz of SPI 925 Retarder per sprayable quart if pinholes are a problem.