

LACQUER PRIMER



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PRODUCT FEATURES

- Compatible with a wide range of topcoats.
- Easy sanding
- Very Fast drying
- Excellent adhesion
- Excellent color holdout

AVAILABILITY

Lacquer Primer	Unit	Per Case	Lacquer Primer	Unit	Per Case
APR-1212-1 Gray	GAL	2	APR-1214-1 White	GAL	2
APR-1212-4 Gray	QT	6	APR-1214-4 White	QT	6
APR-1211-1 Black	GAL	2			
APR-1211-4 Black	QT	6			
APR-1213-1 Red	GAL	2			
APR-1213-4 Red	QT	6			

PHYSICAL PROPERTIES

Pot Life	n/a	Theor. Cov. @ 1 mil (RTS)	297 to 299 sq ft
Flash Point	34°F (1.111°C)	Sprayable Viscosity (RTS)	22" to 28" #2 Zahn Cup
Dry Film Build	2 to 3 mils per coat	Weight Solids (RTS)	24 %
VOC (RTS) When mixed with the following compliant solvents		Shrinkage	Minimal
ASC-0130-x Acetone	2.1 lbs./gal	Color Holdout	Excellent
AVT-0360-x Loc VOC Thin Fast	2.7 lbs./gal	Inter Coat Adhesion	Excellent
AVT-0370-x Loc VOC Thin Med	2.8 lbs./gal		
AVT-0380-x Loc VOC Thin Slow	2.8 lbs./gal		

SUBSTRATES

Properly sanded and treated:

- Steel
- Aluminum
- Galvanized
- Some Plastics
- Fiberglass
- Body Filler
- OEM Finishes

DRY TIMES



@ 70°F

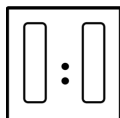
Air Dry

Flash 10 to 15 minutes

Sand & Topcoat 1 hour @ 70 °F

Note Follow topcoat manufacturer's recommendation for dry times and sanding. If topcoating with enamel (whether synthetic, acrylic or urethane), recoat the entire surface with a non-sanding sealer to provide a uniform holdout between primed and unprimed areas.

MIX RATIO



- 1 Part Primer Lacquer Primer
- 1 Part Solvent Compliant Solvent

SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.4 to 1.6 mm	7 to 10 PSI
Conventional	1.4 to 1.6 mm	45 to 55 PSI

COLD SHOP CONDITIONS

For maximum performance, vehicle should be kept above 70°F. Temperatures below 60°F will severely retard dry times and through cure.

SPRAY GUN ADJUSTMENT

- Adjust the material flow according to product viscosity.
- Fully close the material flow knob then turn knob counter clockwise two full turns. Open or close knob 1/4 of a turn at a time until desired atomization and pattern width is achieved. Secure by means of counter nut.

Note: Proper spray gun adjustment will determine the final finish, improper adjustment may cause orange peel, runs, poor drying and poor adhesion just to name a few defects.

SURFACE PREPARATION

- Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean dry cloth, then clean with AXIS PRE-CLEAN, using generous amounts and changing rags frequently prior to painting.
- Sand area as necessary to remove any rust or corrosion, and then repair all body damage.
- Dry sand old finishes by hand or machine with 320P to 400P grit paper or wet sand using 400P grit paper.
- Prime exposed metal with AXIS 1:1 WC PRE-TREATMENT.
- After allowing the WC PRE-TREATMENT to dry thoroughly, scuff sand if necessary to remove dust.
- Re-wipe vehicle with AXIS WC PRE-CLEAN.

APPLICATION

- Apply 2 to 3 medium wet coats. If spot priming, for best results apply first coat of 2.1 VOC Lacquer Primer starting with the outer layer working yourself towards the center of the repair.
- Block sand primed bodywork with 400P grit or finer wet or dry sandpaper.

EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents.

PRODUCT SAFETY INFORMATION

Before using any AXIS Product, be sure to read all safety directions and warnings. WEAR PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. FOR USE ONLY BY TRAINED PROFESSIONALS. Not for sale to or use by the general public. For more information CONSULT MATERIAL SAFETY DATA SHEET.