

## VERSAPRIME 2K HB



### PRODUCT FEATURES

- Compatible with a wide range of topcoats including waterborne basecoats
- Easy Sanding
- Ultra High Build

### AVAILABILITY

VERSAPRIME 2K HB (Part A)	Unit	Per Case	Catalyst (Part B)	Unit	Per Case
APR-1261-1 Gray	GAL	2	BPR-1260-4 Catalyst	QT	4
APR-1261-4 Gray	QT	6	BPR-1260-6 Catalyst	HP	6
APR-1263-1 Buff	GAL	2			
APR-1263-4 Buff	QT	6			
APR-1262-1 Tintable	GAL	2			

### PHYSICAL PROPERTIES

Pot Life	2 hours	Humidity Resistant	Excellent
Flash Point	45° F	Color Holdout	Excellent
Dry Film Build	2.5 to 3.1 mils	Inter Coat Adhesion	Excellent
Sprayable Viscosity (RTS)	24" to 26" #2 Zahn Cup	Reparability Catalyzed	Excellent
Weight Solids (RTS)	58.6 to 60.06 %	Theoretical Coverage @ 1 mil (A+B)	
VOC (RTS)	<4.6 (lb./gal)	Gray	750 sq ft
		Buff	748.5 sq ft
		Tintable	765.83 to 773.05 sq ft

2K PRIMER

## SUBSTRATES

Properly sanded and treated:

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

## RECOMMENDED BARE METAL PRIMERS

Properly sanded and treated:

- EPOX-PRIMER & SEAL (GRAY, BLACK AND GRAY)
- 1K ETCHING PRIMER (GRAY)

## DRY TIMES



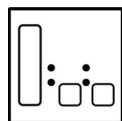
### Air Dry

<b>Flash</b>	10 to 15 minutes
<b>Sand &amp; Topcoat</b>	<b>Allow primer to dry</b>
@ 70°F	4 hours
@ 80°F	3 hours
@ 90°F For higher	2 hours
<b>Note</b>	All tests are performed at 70°F, higher temperatures will provide faster drying times.

### Force Dry

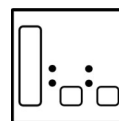
<b>Flash</b>	5 to 10 minutes
<b>Bake</b>	140° F for 25 to 35 minutes
<b>Sand &amp; Topcoat</b>	Allow substrate to cool to room temperature before sanding and top-coating.

## MIX RATIO GRAY & BUFF



<b>4</b>	Parts	VersaPrime 2K HB
<b>1</b>	Part	Catalyst
<b>1</b>	Part	AUR Series Urethane Reducer

## MIX RATIO TINTABLE ONLY



<b>5</b>	Parts	VersaPrime 2K HB
<b>1</b>	Part	Catalyst
<b>1</b>	Part	AUR Series Urethane Reducer

**Note** Use this ratio when primer is pre-mixed with color. Follow formulas found in Color Genie software or on back of color chart.

## SPRAY GUN SETUP



Gravity or Siphon Feed HVLP	1.8 to 2.0 mm	7-10 PSI
Conventional	1.8 to 2.0 mm	45-55 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. One-half (½) fluid ounce of AXIS 2K PERFORMANCE ACCELERATOR per mixed quart may be added to improve cure response in adverse facility conditions.

2K PRIMER

## SPRAY GUN ADJUSTMENT

- Adjust the material flow knob 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.

## SURFACE PREPARATION



- Wash surfaces with a mild detergent in warm water. Rinse well and 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 any of the bare metal primers listed on the previous page.
- After allowing the bare metal primer to dry thoroughly, lightly scuff sand to remove dust or debris.
- Re-wipe vehicle with AXIS PRE-CLEAN.

## APPLICATION



- Apply 2 to 3 medium wet coats. If spot priming, for best results apply first coat of VERSAPRIME 2K HB 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.
- Seal vehicle with AXIS VERSASEAL 2K sealer.

## EQUIPMENT CLEANING

Clean equipment with a compliant solvent. Refer to appropriate Air Quality District requirements for proper use of equipment and solvents. Do not leave catalyzed product in the gun more than 2 hours.

## 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. When mixed, also contains Isocyanate. 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.