

# 4:1 Primer

## 2K Urethane Primer

### Technical Data Sheet #36



#### Components

36 2K Urethane Primer Gray  
361 2K Urethane Primer Activator  
7070, 8080, 9090 Universal Reducers

#### Mix by Volume

- 4 Part 36 2K Urethane Primer Gray
- 1 Part 361 2K Urethane Primer Activator
- 1 Part 7070, 8080, 9090 Universal Reducers

#### Pot Life

- 1 hour @ 75°F – Catalyzed Primer
- Accelerator, reducer and temperature will affect pot life
- Clean equipment immediately after use

#### Equipment Setup

Gun Type	Fluid Tip	Air Pressure
HVLP	1.4–1.6mm	6–8 PSI at cap
High Efficiency	1.4–1.6mm	17–19 PSI Inlet Pressure

**Note:** These are starting points for spray gun recommendations. Refer to spray gun manufacturers recommendations for proper setup and operation. Additional adjustments may be necessary

#### Application

- Apply over properly prepared surfaces. Large bare metal areas should be coated with Lumabase 40 Epoxy Primer prior to primer surfacer.
- Solvent clean surface with 10 Wax & Grease Remover before sanding.
- Sand existing areas with P180–320 grit sandpaper and solvent clean with 10 Wax & Grease Remover.
- Apply in single full wet coats, allowing 5–10 minutes flash between coats.
- For best results, do not apply more than 3 coats.

#### Time to Sand

- Air dry: 45 mins–1 hour at 75°F per coat. Apply 2–3 coats. If 3 coats have been applied, allow to dry overnight.
- Recommended minimum dry film thickness after sanding is 1.5–2.0 mils.
- Infrared Short Wave 15 minutes full power at 36”.

#### Time to Topcoat

- Primer must be sanded before top coating.
- Topcoat within 4–6 hours after sanding.
- If primer has dried longer than 4–6 hours recommended recoat time, scuff with P400–P600 grit sandpaper or finer before applying topcoat.

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## Performance Tips

- Shop and surface temperatures should be maintained above 75°F prior to work.
- Ensure proper metal conditioning and preparation procedures are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions for topcoats are followed.
- Ensure accurate measuring is followed during mixing.

## Clean-up

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

## Disposal

Dispose of all paint and paint related materials in accordance with state and local regulations.

## Safety & Health

Read and follow all technical product information, labels, and SDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

**Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Safety Data Sheets (SDS) supplied with the materials.**

**KEEP OUT OF REACH OF CHILDREN**