

87N Enamel Primer Sealer



DESCRIPTION

87N is a single component fast drying, non-sanding Primer Sealer with excellent adhesion and moisture resistance for very good corrosion resistance.



COMPONENTS

- 87N..... Gray

3.5 VOC Compliance

- X01.....Fast Exempt Reducer
- X02.....Medium Exempt Reducer

4.6 VOC Compliance

- 171.....Fast Reducer up to 75°F (24°C)
- 172.....Medium Reducer 75-85°F(24-29°C)
- 173.....Slow Reducer 85-95°F(29-35°C)
- 174.....Very Slow Reducer 95°F(35°C) plus



MIXING RATIO

For 3.5 VOC Compliance

Mix three parts 87N Primer to one part X01 or X02. (3:1) Activator (optional): eight parts 87N Primer to one part HPC218. (8:1)

For 4.6 VOC Compliance

Mix three parts 87N Primer to one part urethane reducers 171-174. (3:1) Activator (optional): eight parts 87N Primer to one part HPC000. (8:1)



POT LIFE @ 77°F (25°C)

N/A



CLEAN UP

Valspar Refinish 100 Thinner
(Check local regulations)



ADDITIVES

ACCELERATOR: Not Required
FISHEYE: Not Recommended
FLEX ADDITIVE: Not Required

Note: Do not spray when surface temperature is below 50°F (10°C).



SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.



- Wipe surface with 155 Surface Cleaner or 170 AquaClean and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with 320-400 grit wet or dry sandpaper or equivalent.
- Clean surface with 155 Surface Cleaner or 170 AquaClean and wipe dry with clean cloth before product flashes.





SUBSTRATES

- Properly prepared OEM
- Properly prepared previously painted surfaces
- Properly treated steel and aluminum
- 88 Sunlock
- 92B060 Sun-Fil
- Supa-Fil 96N/21N
- DTM 2000



APPLICATION

- Spray one to two medium wet coats allowing 20 minutes between coats. (Allow each coat to flash dull.)



FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	20 Minutes
To Topcoat	40 Minutes



GUN SETUPS CONVENTIONAL

Gravity Feed	1.6 mm - 1.8 mm
Siphon Feed	1.6 mm - 1.8 mm

HVLP

Gravity Feed	1.4 mm - 1.5 mm
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AIR PRESSURES

Conventional @ Gun

	PANEL	OVERALL
Gravity Feed	35 - 40 psi	35 - 40 psi
Siphon Feed	40 - 50 psi	40 - 50 psi

HVLP @ Cap	8 - 10 psi	8 - 10 psi
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PHYSICAL DATA

VOC	Coating VOC 3.48 lbs. per gallon
.	Material VOC 3.05 lbs. per gallon
Volume Solids	44.84%
Theoretical Coverage	719 sq. ft. per mil per gallon
Recommended DFT	0.5 - 1.5 mils
Zahn #2 Viscosity (RTS)	18-21 seconds