

Sun-Fil® 92B060 2K Polyurethane Primer/Filler



DESCRIPTION

A 2K Polyurethane Primer/Filler with outstanding filling qualities. Sun-Fil 92B060 may be sprayed reduced or non-reduced as a sealer or surfacer.



COMPONENTS

- 92B060 Neutral Buff
- HPC000 Activator
- 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

Sun-Fil 92B060 must be activated. Mix 4 parts Sun-Fil 92B060 to one (1) part HPC000 Activator. Sun-Fil 92B060 may be reduced up to 10% with any of the urethane reducers listed above. (4:1:0-10%)



POT LIFE @ 77°F (25°C)

1-2 hours
(Reduction may extend pot life.)



CLEAN UP

Valspar Refinish 100 Thinner
(Check local regulations)



ADDITIVES

ACCELERATOR: T566 up to 2 oz. per gal.
FISHEYE: Not Recommended
FLEX ADDITIVE: N/A

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.
- Clean surface with 155 Surface Cleaner or 170 AquaClean and wipe dry with clean cloth before product flashes.
- SPECIAL NOTE: Use SunLock 88 as a pre-treatment on bare steel, aluminum, galvanized (See SunLock 88 information).



SUBSTRATES

- Properly sanded OEM finishes
- Fiberglass
- SMC
- V880
- DTM 2000
- Direct to SunLock 88
- VP Series Epoxy Primers



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APPLICATION

- Spray medium wet coats to desired film thickness.
- Allow each coat 10-15 minutes flash or until finish is dull.
- Sun-Fil may be thinned and used as a sealer.



FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	10-15 Minutes
To Sand	1-2 Hours
(Longer dry times give optimum sand scratch resistance.)	
To Topcoat	45 Minutes



INFRARED CURE

See Infrared Curing Information on pages 78

TINTING

92B060 BUFF

- May be tinted with up to 1 pint of Universal Intermix tint per gallon.
- Tint should be added BEFORE activation.



GUN SETUPS

CONVENTIONAL

Gravity Feed	1.6 mm - 2.0 mm
Siphon Feed	1.8 mm - 2.0 mm

HVLP

Gravity Feed	1.5 mm - 1.8 mm
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AIR PRESSURES

Conventional @ Gun

	PANEL	OVERALL
Gravity Feed	30 - 35 psi	40 - 45 psi
Siphon Feed	30 - 40 psi	45 - 55 psi

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

VOC	4.3 lbs. per gallon unreduced (Mixed)
Volume Solids	39.2%
Theoretical Coverage	630 sq. ft. per mil per gallon
Recommended DFT	Not to exceed 5 mils
Zahn #2 Viscosity (RTS)	27-30 seconds