

Supa-Fil® 96N 2K Polyurethane Primer/Filler



DESCRIPTION

A 2K Polyurethane Primer/Filler that may be used over fiberglass, previously painted surfaces, properly treated ferrous and non-ferrous metals.



COMPONENTS

- 96N..... Gray
- HPC000 Activator
- X01..... Fast Exempt Reducer
- X02..... Med. Exempt Reducer

3.5 VOC Compliance

National Rule 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

Supa-Fil must be activated. Mix four (4) parts Supa-Fil Primer to one (1) part HPC000 Activator. Supa-Fil may be reduced up to 50% with any of the urethane reducers listed above. (4:1:0-50%)



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



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

- Fiberglass
- Properly sanded OEM finishes
- Direct to SunLock 88
- DTM 2000
- SMC
- 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.
- Supa-Fil may be thinned and used as a sealer.

TINTING

96N GRAY

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



FLASH / DRY TIMES AIR DRY @ 77°F (25°C)

Flash between coats	10-15 Minutes
To Sand	1-2 Hours
To Topcoat	45 Minutes



INFRARED CURE

See Infrared Curing Information on pages 78



GUN SETUPS CONVENTIONAL

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

HVLP

Gravity Feed	1.6 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	3.5 lbs. per gallon (mixed)
Volume Solids	51.9% (mixed)
Theoretical Coverage	833 sq. ft. per mil per gallon
Recommended DFT	Not to exceed 5 mils
Zahn #2 Viscosity (RTS)	27-30 seconds