

## 800K 2K Primer Surfacer

### U.S. National Rule Primer Surfacer Application with LH810, LH820

**Description:** Limco 800K 2K Primer Surfacer is a very fast curing, easy sanding primer, that provides good sand scratch filling, no settling in the can, excellent adhesion and topcoat holdout.

**Materials:**

Primer Surfacer:	800K
Hardeners:	LH810 LH820
Flex Agent:	892

Substrate/Pretreatment:	Cleaning	Sanding	Second Cleaning
Well cured old paint work	203 Wax and Grease Remover	P240 - P400 grit	139 Final Wash Cleaner
O.E.M. primed spare parts	203 Wax and Grease Remover	P240 - P400 grit	139 Final Wash Cleaner
Bare steel	203 Wax and Grease Remover	P80 - P180 grit	139 Final Wash Cleaner
Galvanized Steel	203 Wax and Grease Remover <i>Then, pre-prime with LP20 or LP100</i>	Coarse scuff pad	139 Final Wash Cleaner
Aluminum	203 Wax and Grease Remover <i>Then, pre-prime with LP20 or LP100</i>	P120 - P180 grit	139 Final Wash Cleaner
Fiberglass plastic parts (without gelcoat)	R-M 902 Plastic Prep-Cleaner	P220 grit	R-M 902 Plastic Prep-Cleaner

**NOTES:** On Galvanized Steel and Aluminum, make sure sanding is not so vigorous that it removes the galvanized coating.  
With the second cleaning, make sure all residue is removed. Pay special attention when cleaning Galvanized Steel and Aluminum.

**Topcoats:**











- Supreme PLUS Acrylic 1K Single Stage
- Supreme PLUS Acrylic 2K Single Stage
- Supreme PLUS Urethane Single Stage
- Supreme PLUS Basecoat

**Remarks:** Always check local VOC laws to ensure that the use of these Limco products is compliant in your area.

# T E C H N I C A L   D A T A

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			Flexed
	<b>Mixing ratio:</b>	4:1	4:1:1
	<b>Primer</b>	4 parts 800K	4 parts 800K
	<b>Hardener</b>	1 part LH810 or LH820	1 part LH810 or LH820
	<b>Flex Agent</b>	—	1 part 892
	<b>Potlife at 68°F/20°C</b>	1.5 hours	1.5 hours
	<b>Spray viscosity Ford #4 @ 68°F/20°C</b>	18 - 21 seconds	18 - 21 seconds
	<b>Gravity gun nozzle HVLP</b>	1.5 - 1.7 mm	1.5 - 1.7 mm
	<b>Spray pressure HVLP at the cap</b>	8 - 10 psi	8 - 10 psi
	<b>Application</b>	2 - 3 medium wet coats	2 - 3 medium wet coats
	<b>Flash-off time @ 68°F/20°C</b>	5 minutes between coats	5 minutes between coats
	<b>Film build</b>	2.0 - 3.0 mils	2.0 - 3.0 mils
	<b>Coverage</b>	567 sq. ft./gal @ 1.0 mils	644 sq. ft./gal @ 1.0 mils
	<b>Drying:</b>		
	<b>68°F/20°C</b>	60 minutes with LH810; 1.5 - 2 hours with LH820	90 minutes with LH810; 2.5 hours with LH820
	<b>140°F/60°C</b>	20 minutes	20 minutes
	<b>Infra red short wave</b>	N/A	N/A
	<b>Infra red medium wave</b>	N/A	N/A
	<b>Sanding:</b>		
	<b>Wet by Hand</b>	P320 - P400 grit	P320 - P400 grit
	<b>Dry by Hand</b>	P400 grit	P400 grit
	<b>Dry by Machine</b>	P320 - P400 grit	P320 - P400 grit
	<b>VOC as applied</b>	≤ 580 gms/liter (≤ 4.8 lbs/gal)	≤ 580 gms/liter (≤ 4.8 lbs/gal)
	<b>Comments</b>		