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 scratch filling, no settling in the can, excellent adhesion and topcoat holdout. | | | 51 |
|---|---|----------------|------------------|------------------------------|
| 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 Then, pre-prime with LP20 or LP100 | | Coarse scuff pad | 139 Final Wash Cleaner |
| Aluminum | 203 Wax and Grease Remover Then, pre-prime with LP20 or LP100 | | 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 StageSupreme PLUS Acrylic 2K Single StageSupreme PLUS Urethane Single StageSupreme PLUS Basecoat

Remarks:

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

TECHNICAL DATA

800K 2K Primer Surfacer

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

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

Comments

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use—read product label and Material Safety Data Sheet (MSDS) for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warrank for events resulting from their use. Divition ratios are intended to provide maximum performance within the kypical Volatile Organic Compound (VCC) restriction for product use. Specific VGC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.