

PRODUCT DATA SHEET FP405 2.1 1K High Build Primer

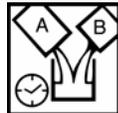
PRODUCT AT-A-GLANCE



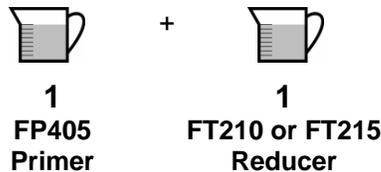
SUBSTRATES

- Properly Treated Steel*
- Fiberglass / SMC
- OEM Finishes
- Refinish Lacquers, Enamels, and Urethanes
- Etching Primers

*Steel must be treated with an Etching Primer or Metal Etch.



MIXING



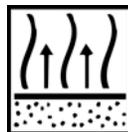
REDUCER SELECTION

FT210 = Below 85°F
 FT215 = Above 85°F



APPLICATION

- 2 - 3 medium wet coats, at a gun distance of 8" - 10" inches. Allow each coat to become hand slick, before applying the next coat.
- Recommended dry film thickness is 2.0 - 2.5 mils.
- HVLP = 5 - 7 psi @ cap.
- Clean spray gun with an appropriate gun cleaner, immediately after use.



DRYING

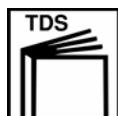
Air Dry Times @ 70°F

To sand: 30 minutes to sand

Note: Excessive film builds and cooler temperatures will extend dry times.

Final Sanding
To seal
To topcoat

Sandpaper Grit
P400*
P600*
*or equivalent



PHYSICAL DATA

Pot Life:	Unlimited
VOC Ready to Spray:	1.83 lbs /gal
Theoretical coverage:	190 square feet/gallon @ 1mil dry

PRODUCT DESCRIPTION:

FP405 is a single component, low VOC primer. This primer offers a high film build, quick dry times, and can be sanded in 30 minutes. FP405 is designed for spot and small area repairs. Larger bare metal areas must be properly treated. Eventhough FP405 does not have a maximum recoat window after sanding, it is recommended to scuff and solvent clean after 1 week to prevent against any airborne contaminants.

SURFACE PREPARATION:

Bare Substrates:

Repairs or sand-throughs can be directly primed without etching.

1. Solvent clean with appropriate surface cleaner and wipe dry with a clean, dry cloth.
2. Apply 2-3 coats of etch primer.

Prepainted Substrates:

1. Wash surfaces with a mild detergent in hot water. Rinse well and wipe dry with a clean, dry cloth.
2. Solvent clean with appropriate surface cleaner and wipe dry with a clean, dry cloth.
3. Sand repair area and featheredge using 80, 180, 280, 320 and finish with 400 grit treated sandpaper on a random orbital sander, thus extending the repair area to accommodate the primer application. Solvent clean with appropriate surface cleaner and wipe dry with a clean, dry cloth.



PERSONAL PROTECTION

- For use by trained professionals only.
- Read label, directions, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.

REGULATORY DATA

	As Packaged		As Applied	
	G/L	Lbs/Gal	G/L	Lbs/Gal
VOC Total	71	.59	36	.30
VOC Less Exempt	219	1.83	219	1.83
	Lbs/Gal Solids	Lbs/Lbs Solids	Lbs/Gal Solids	Lbs/Lbs Solids
HAPs	.262	2.19	.262	2.19
	Wt.%	Vol.%	Wt.%	Vol.%
Volatiles	63.3	76.2	77.9	88.1
Water	0	0	0	0
Exempt Compounds	57.2	67.3	74.2	83.6
	G/L	Lbs/Gal	G/L	Lbs/Gal
Density	1182	9.87	987	8.24