



# 991 POLYPRIMER Hi-Fill Surfacer

## HIGH PERFORMANCE HI-FILL POLYESTER PRIMER SURFACER



### DESCRIPTION

POLYPRIMER is a corrosion-resistant, sanding primer surfacer based on an air-drying polyester resin. VOC is <250 g/l (2.1 lbs/gl). The pigmentation is carefully balanced for optimum sanding properties. It is designed for fast drying and has excellent filling properties and adhesion over fiberglass, metal, plastic, and wood. It can be topcoated with all types of finishes, including acrylics, lacquers, synthetic enamels and two-component urethane coatings.

### PRODUCT FEATURES

Meets air quality regulations  
 Excellent filling properties  
 Minimum shrinking due to high solids content  
 Low VOC  
 Lead- and chromate-free  
 Isocyanate-free

### PRODUCT NUMBERS

PART A: **991 GRAY PRIMER**  
 PART B: **998 CATALYST**

### DIRECTIONS FOR USE

#### SURFACE PREPARATION



Prior to application, the surface must be dry, clean and free from wax, grease, oil, rust, dirt or any other foreign matter. Use PCL 2040 NOVOC® Compliant Universal Solvent or PCL 8007 Compliant Cleaning Solvent on unpainted surfaces. Sand and featheredge original finish with 220 or 320 wet or dry sandpaper. Use PCL 2K EPOXY PRIME-N-SEAL 6711 or 6713 over bare metal for optimum adhesion.

#### MIXING

Mix 2 1/2 oz. of Liquid Hardener with one gallon of 991 Polyprimer. Contents must be mixed thoroughly. Do not mix more than can be applied in one application.

**Pot Life:** Pot life is approximately 30 to 35 minutes at 77°F. The pot life will shorten at higher temperatures and/or in larger quantities.

#### THINNING

No thinning is required. Once activated, Polyprimer is ready to spray. If thinning is desired, use PCL 2010 Acetone or PCL 2040 NOVOC® Compliant Universal Solvent.



### APPLICATION

Apply a wet mist coat with 5 minutes flash-off time. Follow with a medium wet coat. Allow 15 minutes between subsequent coats. Do not apply more than 3 medium coats.

**CAUTION:** Dry spray of Polyprimer may cause blistering of color coat.



## DRY TIMES

**SANDING:** Depending on temperature, Polyprimer can be sanded between 45 minutes to 1 hour. For optimum results, dry sand using 320 to 400 grit paper.



## PHYSICAL PROPERTIES

All Values Ready to Spray

### PART A: 991 Gray

### Standard Mix Ratio

|                           |  |
|---------------------------|--|
|                           | 2 ½ oz. of 998 to one gallon                   |
| Max. VOC (LE)             | 194 g/L (1.62 lbs./gal) *                      |
| Max. VOC (AP)             | 140 g/L (1.17 lbs./gal) *                      |
| Avg. Gal. Wt.:            | 1343 g/L (11.20 lbs./gal)                      |
| Avg. Wt. Volatiles:       | 10.45 %  |
| Avg. Wt. Exempt Solvent:  | 19.47%   |
| Avg. Wt. Water:           | 0.0 %  |
| Avg. Vol. Exempt Solvent: | 27.79%   |
| Avg. Vol. Water:          | 0.0 %  |
| Theoretical Coverage:     | 738 ft <sup>2</sup> at 1 mil                   |
| Dry Film Build per Coat:  | Approximately 2.0 - 3.0 mils dry film per coat |
| Flash Point:              | See SDS/MSDS                                   |

\* Max VOC (LE) and VOC (AP) data based on Method 24 testing of ready to spray product, styrene component acts as a reactive diluent, a portion crosslinks into resin.

## VOC REGULATED AREAS

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

## SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS/MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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