Rival™ RV400™ Urethane Primer

GENERAL

DESCRIPTION
A two-component, fast drying, easy-to-sand urethane primer-filler designed to deliver good filling properties in 2.1 lb./gal (250 g/l) VOC or 3.5 lb./gal (420 g/l) VOC level.

SUGGESTED USES
For use with:
Properly cleaned and sanded cured finishes and fiberglass gelcoat substrates
Metalok Adhesion Promoter 230S ™
Metalok Pretreatment Coatings 250S™ and 235S ™
Properly cleaned and chemical treated metal substrates

COMPATIBLE COATINGS
Compatible with Axalta Rival topcoat.

NOT RECOMMENDED FOR
Immersion service and marginally treated metal substrates.

DRY FILM CHARACTERISTICS

Chemical Resistance	VERY GOOD
Humidity Resistance over treated substrate	VERY GOOD
Weatherability with appropriate topcoat	VERY GOOD
Adhesion	VERY GOOD
Alkali Resistance	VERY GOOD
Solvent Resistance	VERY GOOD

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

MIX RATIO
Thoroughly mix prior to activation. The use of a Cyclone® shaker is recommended. Combine components and mix thoroughly. Filter material prior to spray application.

COMPONENTS

	Parts by Volume	
3.5 VOC Mixing Ratio	**Standard Cure**	**Increased Cure**
Rival RV400 Primer	6	6
RV135™ Activator	1	1
389S™ Accelerator – per RTS gallon	2 oz.	-
8989S™ Fast Accelerator – per RTS gallon	-	1 oz.

2.1 VOC Mixing Ratio	**Standard Cure**	**Increased Cure**
Rival RV400 Primer	6	6
RV128™ Activator	1	1
V-389S™ Low VOC Accelerator – per RTS gallon	2 oz.	-
8989S Fast Accelerator – per RTS gallon	-	1 oz.

INITIAL APPLICATION VISCOSITY
9-11 seconds with #3 Zahn Cup.

INDUCTION TIME
No induction is required.

POT LIFE - 70°F (21°C)
3.5 VOC
2 hours with 389S Accelerator
45 minutes with 8989S Accelerator

2.1 VOC
1 hour with V-389S Low VOC Accelerator
45 minutes with 8989S Accelerator

APPLICATION

APPLICATION CONDITIONS
Do not apply if material, substrate or ambient temperature is less than 50°F (10°C) or above 110°F (43°C). The substrate must be at least 5°F (3°C) above the dew point. Relative humidity should be below 90%.

APPLICATION EQUIPMENT
Refer to spray equipment documentation for setting recommendations.
Pressure Pot
Gravity Feed (recommended)
Siphon Gun
Airless Spray
Air Assisted Airless

APPLICATION
- Pressure pot application is recommended to provide the best atomization and delivery. Fluid delivery is recommended at 10-12 fluid oz/min.
- RV400 builds at approximately 1.0 mil DFT per pass with a recommended equipment setup.
- Apply using a cross-coat technique, top-to-bottom, and then side-to-side. Each coat should be medium-wet. No flash time is required between coats (2-3 mils DFT).
- For increased build, apply a single pass with 10 minutes flash. This is followed by the cross-coat application as above (3-4 mils DFT).
- Rival topcoats can be applied wet on wet over RV400 after a 1 hour flash time (2 hrs for maximum holdout).
- See DRY TIME section for sanding time recommendations.

APPLICATION SOLVENTS
No reduction necessary; product is ready-to-spray. Further reduction may result in an increased VOC.

CLEANUP SOLVENTS
130™ Acetone
105™ Lacquer Thinner
107™ Low VOC Gun Cleaner
108™ Low HAPS Cleaning Solvent

ADDITIONAL COMMENTS
Heating activated material above 110°F (43°C) will shorten pot life and cause product to gel.

AIR DRY

77°F (25°C) & 50% RH at recommended film thickness

	with	with
3.5 VOC	**2 oz 389S**	**1 oz 8989S**
2.1 VOC	**2 oz V-389S**	**1 oz 8989S**
Dry to touch:	30 minutes	30 minutes
Tack free:	1 hour	45 minutes
Print free:	1.5-2 hours	1 hour
Dry to Sand (air dry):	1.5-2 hours	1 hour

FORCE DRY

Dry to Sand – Accelerated
30 minutes after cool down from 30 minutes at 130-140°F (54-60°C) force dry

Note: Product must be sanded if force dried or allowed to dry for more than 16 hours.

PHYSICAL PROPERTIES

Maximum Service Temperature:	200°F (92°C) in continuous service 300°F (148°C) in intermittent heat
Weight Per Gallon (component only)	10.56 lbs.
Weight Per Liter (component only)	1235 grams
Suggested Dry Film Thickness	1.6 – 2.0 mils
Gloss	satin
Color	gray
Flash Point (Closed Cup)	see MSDS/SDS
Shelf Life	12 months minimum

RTS mixed 6:1 with:	**RV135 Includes 389S**	**RV128 Includes 8989S**
Gallon Weight pounds per gallon	10.33	10.36
Gallon Weight grams per liter	1234	1241
VOC AP pounds per gallon	1.6	1.3
VOC AP grams per liter	187	159
VOC LE pounds. per gallon	2.4	2.1
VOC LE grams per liter	285	248
Weight Solids	60.6%	61.9%
Volume Solids	43.7%	45.5%
Weight Volatiles	39.4%	38.0%
Weight Water	0.0%	0.0%
Volume Water	0.0%	0.0%
Weight Exempt Solvents	24.2%	25.2%
Volume Exempt Solvents	34.5%	36.0%
Theoretical Coverage per RTS Gallon at 1 mil DFT	701 ft^2 (65.2 m^2)	729 ft^2 (66.2 m^2)

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 MSDS/SDS 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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