



PRODUCT

DATA

SHEET

DESCRIPTION: **PRO-5250 2.1 VOC DTM 2K Primer** – is a high quality Low VOC two component DTM primer designed to provide ease of sanding as well as exceptional adhesion, color holdout, film build and cure time.

INSTRUCTIONS: Clean all areas with TCI WG1 Wax & Grease remover #1 or #2, Featheredge and sand original finish. Surface should be clean and dry. Spray 2-3 medium coats of PRO-5250 (Mixed w/520 series Activator and QR860 Reducer/Acetone) allowing each coat to flash to a dull appearance before applying next coat. For best results force dry or allow PRO-5250 to dry overnight. PRO-5250 may be block or machine sanded with P320 or P400: or wet sanded with P400-500 grit before applying topcoat.

GENERAL: Appearance Gray Liquid
Viscosity Full Bodied
Shelf Life One Year (unopened)
VOC (primer) 1.88 lb. /gal.
RTS VOC 2.1 lb. / gal
Pot Life 60 - 90 Minutes @ 75° F
Product size – PRO-5250-G (gallons) PRO-5250-Q (quarts)

PRODUCTS/MIXING: 4 PARTS PRO-5250 2.1 VOC 2K DTM Primer
1 PART 520 series Activator:
May be Mixed 4:1:1 with acetone to improve flow

SUBSTRATES: Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel, SMC, F/G, E-Coat and OEM finish.
Recommended substrate temperature - minimum 50° F / maximum 100° F.

GUN SET-UP: TIP AIR PRESSURE
Siphon Feed 1.8-2.0 mm 30-40 psi
Gravity Feed 1.6-2.0 mm 25-40 psi
HVLP (gravity) 1.602.0 mm 6-10 psi

GUN CLEAN-UP: Clean equipment immediately using spray gun cleaning solvent.

FLASH/DRY TIMES @ 77 Degrees F:
FLASH BETWEEN COATS 10-20 min.
TO SAND 60-90 Min.
TO TOPCOAT 30 Min.

TECHNICAL INFO: For additional technical information call (800-824-4999)

SAFETY DATA: Refer to MSDS for 5250, 521,(22),(23)