



TECHNICAL DATA SHEET

RCP-50 2K-HS SPEED PRIMER•SEALER•SURFACER GREY

RCP-50 2K High Build Primer•Sealer•Surfacer is a two-component acrylic urethane primer surfacer formulated to be applied as a high build sanding primer, or a final non-sanding primer•sealer. RCP-50 is ideally suited for use in automotive refinishing, fleet refinishing as well as automotive and truck OEM applications. RCP-50 offers excellent filling properties with minimal coats, fast dry, excellent adhesion, easy sanding and superior color holdout.

Products

RCP-50
RCH-5075

2K High Build Primer-Sealer-Surfacer – Grey
2K High Build Urethane Primer Catalyst - Normal

Application

Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover and wipe dry with a clean cloth. Apply 2-3 single wet coats of an Corrosion Resistant Epoxy Primer•Sealer according to instructions on data sheet.

Surface Preparation, Prepainted Substrates

Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with Wax/Grease Remover. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. For spot repairs, scuff sand area where primer will be applied. For overall refinishing, scuff sand the entire car with 320 sandpaper or fine scuff pad.

Mixing Directions: High Build Primer Surfacer

4 Parts RCP-50
1 Part RCH-5075

2K Urethane Primer•Sealer•Surfacer
2K Urethane Primer Catalyst

Mixing Directions: Normal Build & Sealer

4 Parts RCP-50
1 Part RCH-5075
Up to 1 Part High Grade Urethane

2K Urethane Primer•Sealer•Surfacer
2K Urethane Primer Catalyst
Universal Thinners Series

Application: High Build and Normal Build

Adjust air pressure at the gun to 40-50 psi for siphon feed guns or 6-10 psi when using a HVLP. Use less pressure to minimize over spray on small jobs. Apply 2-3 medium wet coats at a gun distance of 8 -12 inches as needed to fill voids and block sand with 180 to 280 grit treated sandpaper. Allow 10 to 20 minutes flash time between coats. Recoat times will vary with temperature, air movement and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system. Finish sand repaired area with 320 grit sandpaper using a DA Sander or hand sand.

Application: Sealer

Adjust air pressure at the gun to 30-45 psi for siphon feed gun or 6-10 psi when using a HVLP. Use less pressure to minimize over spray on small jobs. Apply 1 coat at a gun distance of 8-12 inches. Allow 20-30 minutes flash time before top coating. Recoat time will vary with temperature, air movements and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system.

Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature. Excessive film thicknesses, low temperature and poor air movement will retard dry times.

Air Dry	High Build	Normal Build	Sealer
Dust Free	12-18 mins	10-15 mins	5-15 mins
Tack Free	25-30 mins	15-20 mins	10-15 mins
To Sand	1-2 hours	1-2 hours	30 mins
To Topcoat	2-3 hours	2-3 hours	30 mins

Potlife

2-3 hours for high build and normal build
4 to 5 hours for sealer

Fish Eye

Do Not Use Fish Eye Eliminator in this product.

Flex Additive

A Flexible Additive may be needed when painting certain Flexible parts. The use of flex additive may be used mixed 4:1:10% by volume.

Primer Gun Recommendation

HVLP (1.4mm-1.6mm Tip Size / 6 – 10 PSI at Air Cap)

Conventional (1.4mm-1.6mm Tip Size / 40-50 PSI at Gun)

Accelerator

To improve cure and reduce the sanding time, or for faster cure in colder conditions, add 2 to 4 ounces of AS-20 Urethane Cure Accelerator to one gallon of catalyzed primer. **Caution:** The addition of cure accelerator can significantly reduce working potlife.

Technical Data

Weight Solids		Mixing Ratio, High Build	4/1
Package	62%	Mixing Ratio, Normal Build	4/1/1
Ready to Spray, High Build	65%		
Ready to Spray, Normal Build	5% min	Potlife	2 to 5 hours
		Viscosity @ Gun	20-40 #2 Zahn
Volume Solids		Recommended Film Thickness	2.5 to 8.0 mil
Package	44%	Flash Point	72'FTCC
Ready to spray, High Build	41%		
Ready to spray, Normal Build	37%	Coverage, High Build	690 sq ft/gl
		Coverage, Normal Build	530 sq ft/g
VOC @ Gun, High Build	4.3 lb/gl	Air Pressure @ Gun	45-50 psi
VOC @ Gun, Normal Build	4.6 lb/gl	Gloss	flat

Performance Data

Flexibility	Excellent	Direct Impact	Excellent	Chip Resistance	Excellent
Salt Resistance	Excellent	Humidity Resistance	Excellent	Hardness	3H
Color Holdout	Excellent	Settling Resistance	Excellent	Water Resistance	Excellent

