

Excel 2K High-Speed Urethane Primer System

Surface Preparation

Clean all areas to be painted. Remove all dirt, grease and other contaminants. Featheredge and sand original finish.

Mixing Ratio

Mix the components in the order and ratio indicated

4 : 1

Mixing Ratio	Overall Mixture	Spot & Panel Mixture
Primer Surfacer (300)	4 Parts	4 Parts
Urethane Grade Reducer (161/162/163)	1 Part	-----
Catalyst	1 Part	1 Part
Mixed VOC	4.57 lb/gal	4.04 lb/gal

Pot Life

Pot Life of activated primer is approximately 1 hour at 4:1:1 or 20 minutes at 4:1 at 72° F.

Basecoats

BASF, Dupont, ICI, PPG, Sherwin Williams, Sikkens, Spies Hecker, Valspar.

Gun Set-Up

1.8mm-2.0mm for conventional and HVLP guns.
35-45 psi at the gun for Conventional guns.
28-35 psi at the gun for HVLP guns.

Application & Dry Times

Apply 2 full wet coats to achieve 3 mils of film that can be sanded and topcoated in 1 hour. Sanding and cure time may be longer depending on thickness of application and/or temperature. Let each coat flash 5-10 minutes. Film builds over 3 mils will have a better appearance and color holdout by letting dry overnight prior to topcoating. It can also be forced-dried for 30 minutes at 140°F (60°C) after allowing final coat to flash 20 minutes. Films in excess of 3 mils should not be forced dried. Excel 2K High-Speed Primer must always be sanded before topcoating. Note: Maximum adhesion to bare metal including aluminum and galvanized steel, will be obtained by priming with single stage self-etching pretreatment primer. Make sure single stage is thoroughly dry prior to recoating.

Clean Up

Clean equipment immediately after use with Excel Urethane Grade reducer (161/162/163) or Excel 99/100 Virgin Lacquer Thinner. Do not leave activated material in the spray gun..

Safety & Handling

Read all directions and warnings before using this product.

