

GENERAL INFORMATION

A-500 Extra Build-Easy Sand Primer Grey is a high quality, two-component, acrylic urethane primer with excellent build, colour holdout and durability. A-500 Extra Build-Easy Sand Primer Grey can be tinted with Prospray toners (solid colours only). This will achieve top coat opacity in fewer coats, increase productivity and reduce topcoat colour consumption.

MIXING RATIO



4 : 1 M.S. Activator + 10 - 25% 2K H.S. Thinner

	HARDENER	SMALL REPAIR	MEDIUM REPAIR	LARGE REPAIR
20°C - 25°C (68°F - 77°F)	ICA 800		√	√
	ICA 801		√	
	ICA 803	√		
25°C - 30°C (77°F - 86°F)	ICA 800		√	√
	ICA 801	√	√	
	ICA 803	√		
>30°C (86°F)	ICA 800		√	√
	ICA 801	√		
	ICA 803	√		

Use matching thinners.

GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,4-1,8	2/29
HE	1,4-1,8	2/29

APPLICATION



1 - 3 coat 60 - 180 µm (2,4-7,2 mil)
Apply medium wet coats.

FLASH-OFF AND DRY TIMES



	AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	5 - 10 minutes	Flash off	5 - 10 minutes	
Dust free	20 - 30 minutes	Dust free	-	
Dry to handle	30 - 60 minutes	Dry to handle	20 - 30 minutes	
Dry to tape	90 - 180 minutes	Dry to tape	20 - 30 minutes	
Dry to sand	> 180 minutes	Dry to sand	20 - 30 minutes	
Dry to polish	-	Dry to polish	-	



INFRARED DRYING



15 minutes
(7 minutes half bake and 8 minutes full bake)

SUBSTRATES



Sanded OEM primer (e coat), GRP / fibreglass, polyester body fillers, sanded existing finishes in good condition and etch primers.

A-500 Extra Build-Easy Sand Primer Grey can be applied over properly prepared and primed plastic. If the plastic is flexible, the primer must be mixed with P-2020 Plasticising Additive at a ratio of 5 parts primer to 1 part P-2020 Plasticising Additive, then activated and thinned according TDS.

COMPONENTS



ICA-800 M.S. Slow Activator
ICA-801 M.S. Normal Activator
ICA-803 M.S. Rapid Activator
A-118 2K Universal Medium Thinner
A-119 2K Universal Fast Thinner
ICR-1692 2K H.S. Fast Thinner
ICR-1693 2K H.S. Medium Thinner
ICR-1694 2K H.S. Slow Thinner

Optional Intermix Solid toners.

ADDITIVES



P-2020 Plasticising Additive
Add before activator.

POT LIFE AT 20°C (68°F)



15 - 30 minutes

SURFACE PREPARATION



Pre clean the surface with W820 Antistatic Degreaser wipe on and wipe dry. Sand surface with P240 - P320 grit abrasive. Remove all sanding debris with sanding vacuum & clean with W820 Antistatic Degreaser wipe on and wipe dry. Dry & D.A. P400 - P500 and water sanding P500 - P800. Topcoat within 24 hours after sanding. If time exceeds 24 hours, the primed surface must be sanded and cleaned again prior to application of primer or topcoat.



Any bare metal areas should be coated with A-514 Chromate Free Etch Primer for correct adhesion and corrosion protection. Mask entire vehicle to eliminate unwanted overspray.

NEXT LAYER



Prospray intermix Single Stage
Prospray intermix Basecoat
EBB-20 Engine Bay Binder

PHYSICAL DATA



PHYSICAL DATA		
Chemical Base	2K Polyurethane Primer	
Physical Properties	Viscosity (RTS)	18 - 20 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1.323
	Flash Point Closed Cup	26°C / 79°F
	Volume % Solids	40
	Economy	7m ² /L/60 µm
		285 ft ² /qt/2,4 mil
	Gloss	-
	Colour	Grey

PROTECTION



Use suitable respiratory protection (**we recommend the use of a fresh air supply respirator**).

For more detailed information please visit the following link for the Safety Data Sheet:

sds.prospray.eu

CLEANUP



Clean equipment after use with a cleaning solvent.

Dispose of solvent according to local regulations.

STORAGE / SHELF LIFE



Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES

