

## GENERAL INFORMATION

A-614 2K Epoxy Primer Grey is a multi-use high solids epoxy primer designed for both wet-on-wet and high fill applications. It has excellent adhesion and corrosion resistance properties in direct to metal applications.

This TDS is about the Sanding version.

## MIXING RATIO



4 : 1 + 35 - 40% Primer : Activator : Thinner

## GUN SETUP



	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,6 - 1,8	2
HE	1,6 - 1,8	3 - 4
Pressure pot	1,1 - 1,2	4

Air pressure mentioned in table is base on inlet air.

## APPLICATION



1 - 2 coat 30 - 40 µm per coat

## FLASH-OFF AND DRY TIMES



AIR DRY 20°C / 68°F		FORCED DRY	
Flash off	10 minutes	Flash off	-
Dust free	-	Dust free	-
Dry to handle	Overnight	Dry to handle	3 hours at 35°C 30 minutes at 60°C
Dry to tape	-	Dry to tape	-
Dry to sand	-	Dry to sand	-
Dry to polish	-	Dry to polish	-

## SUBSTRATES



On properly cleaned and prepared steel, zinc, aluminium, polyester putties and OEM finishes.

## POT LIFE



8 hours

Waiting longer for application might affect the application properties.

## COMPONENTS



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## ADDITIVES



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## SURFACE PREPARATION



Cleaning: Clean by using wipe on/wipe off method.  
Sanding: Sand surface thoroughly with P180 dry discs. For preparation and OEM finishes sand with P280 - P320 dry discs or scuffing pad. Wet P600. Cleaning: After preparation of substrate repeat cleaning procedure.



Mask entire vehicle to eliminate unwanted overspray.

## NEXT LAYER



Prospray Intermix Basecoat system  
Prospray Intermix Single Stage system  
Prospray Engine Bay System

## PHYSICAL DATA



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Chemical Base	Special resins mixed with modified epoxy	
Physical Properties	Viscosity (RTS)	18 - 20 sec DIN Cup4 30°C
	Specific Gravity (kg/l)	1,55
	Flash Point Closed Cup	27°C / 80,6°F
	Volume % Solids	50%
	Economy	10,8 m²/L/40 µm RTS
	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](https://sds.prospray.eu)

## CLEANUP



Use cleaning thinner.

## STORAGE / SHELF LIFE



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

## NOTES



All reported product properties on the TDS are determined at a temperature of 30°C unless specified otherwise.