Tech Data Sheet

830X Urethane Primer Surfacer

Urethane Primer Surfacer is a two-component acrylic urethane primer surfacer formulated to be applied as a sanding primer. Urethane Primer Surfacer offers excellent adhesion, easy sanding and superior color holdout. Urethane Primer Surfacer does not shrink and can be tinted with basecoat tints.

Products

8301	Urethane Primer Surfacer – Gray, gallon
8304	Urethane Primer Surfacer – Gray, quart
1004	Primer/Clear Hardener, quart
1032	Primer/Clear Hardener, half pint

Application

Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover and wipe dry with a clean cloth. Apply three single wet coats of Epoxy Primer 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 a good grade wax and 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 grit sandpaper or fine scuff pad.

Mixing Directions

4 Parts 8301, 8304	Urethane Primer Surfacer – Gray
1 Part 1004, 1032	Primer/Clear Hardener

Application

Adjust air pressure at the gun to 30-45 psi for siphon feed guns. 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.

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	Normal Build
Dust Free	10-15 min
Tack Free	15-20 min
To Topcoat	45-60 min

Pot Life

Three to four hours for normal build.

Technical Data

Weight Solids
Package: 59.8%
Ready to Spray: 49.7%

Volume Solids
Package: 40.2%
Ready to spray: 33.3%

VOC @ Gun: 4.8lbs/gal

Mixing Ratio: 4:1
Pot Life: 3 to 5 hours
Viscosity @ Gun: 20-40 #2 Zahn
Recommended Film Thickness: 2.5 to 8.0 mil
Flash Point: 72°FTCC
Coverage: 520 sq ft/gal
Air Pressure @ Gun: 45-50 psi
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