

## PRIMERS & PRIMER SURFACERS

PRODUCT	MIX RATIO	REDUCER/HARDENER	POT LIFE	APPLICATION	DRY TIME	SANDING	GUN SETUP	TIPS
<b>MP-550</b> Self Etching Primer	<b>1:1</b> 1 part MP-550 1 part MA-505 6.5 VOC	Shop Temperatures 60-68°F MA-505 68-80°F MA-505 80-90°F MA-505 90°F & up MA-505	24 Hours Store in sealed plastic container	1 to 2 wet coats 6 to 10 psi HVLP Flash 10-15 min between coats	77°F Air 30 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.4 - 1.7 mm 6 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 30 minutes cure time before coating with additional primers or sealer. Self Etch Primer must be coated with primer or sealer within 24 hours. If beyond 24 hours, lightly scuff and recoat with Self Etch Primer.</li> <li>If topcoating with color, allow to cure a minimum of 1 to 2 hours.</li> <li>Do not apply over lacquer based products.</li> <li>DO NOT APPLY OVER BODY FILLER</li> <li>Seal for maximum performance and color holdout.</li> </ul>
<b>MP-600</b> Self Etching Wash Primer	<b>1:1</b> 1 part MP-600 1 part MA-610 6.5 VOC	Shop Temperatures 60-68°F MA-610 68-80°F MA-610 80-90°F MA-610 90°F & up MA-610* See Tips	24 Hours Store in sealed plastic container	1 medium wet coat 6 to 10 psi HVLP	77°F Air 30 Mins.	Wet Sand: N/A Dry Sand: N/A	HVLP 1.3 - 1.7 mm 6 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 30 minutes cure time before coating with additional primers or sealer. Self Etch Wash Primer must be coated with primer or sealer within 4 hours. If beyond 4 hours, lightly scuff and recoat with Self Etch Wash Primer.</li> <li>Do not directly topcoat with color. First apply a primer surfacer or sealer.</li> <li>*Use MR-899 in temperatures over 90°F, mixed 1:1:1.</li> <li>Do not apply over body filler or use as a filling primer.</li> <li>Do not apply over lacquer based products.</li> <li>MP-600 will be transparent. Do not exceed 0.5 dry mils.</li> <li>You should be able to see through the primer when applied.</li> <li>Multiple coats may cause lifting, blistering and peeling.</li> </ul>
<b>MP-800</b> Plastic Parts Adhesion Promoter	<b>RTS</b> 7.0 VOC	Shop Temperatures 60-68°F N/A 68-80°F N/A 80-90°F N/A 90°F & up N/A	N/A	1 light coat 10 psi HVLP Flash 10 minutes before Sealer	77°F Air 30 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.3 - 2.1 mm 6 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 30 minutes cure time before coating with additional primers or sealer.</li> <li>No more than .3 - .5 mils is required</li> <li>Do not directly topcoat with color. First apply a primer surfacer or sealer.</li> <li>Do not apply over body filler or use as a filling primer.</li> <li>Accelerator: Do Not Use.</li> <li>Do not apply over lacquer based products.</li> </ul>
<b>MP-Epoxy Series</b>	<b>4:1:1/2</b> 4 parts MP-Series 1 part MAV-420 1/2 part MR-800 Series Reducer 4.6-4.8 VOC	Shop Temperatures 60-68°F MAV-420 MR-0860 68-80°F MAV-420 MR-0870 80-90°F MAV-420 MR-0885 90°F & up MAV-420 MR-0895	5 Hours	1 to 2 wet coats 5 to 10 psi HVLP Flash 10-15 minutes between coats	77°F Air 1 Coat / 1 Hour 2 Coats / Overnight Dry	Wet Sand: 800 Grit or finer Dry Sand: N/A	HVLP 1.5 - 2.1 mm 5 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 60 minutes before topcoating PRIMER with additional primer, sealer or color. If PRIMER Dried Film Thickness exceeds 1.0 mil, allow OVERNIGHT DRY before topcoating.</li> <li>Allow 60 minutes before topcoating SEALER with primer, sealer or color.</li> <li>If a second coat of sealer was applied, allow to dry overnight.</li> <li>Do not use over lacquer.</li> <li>May be reduced 1/2 part for use as a primer.</li> <li>Recoat within 72 hours. If greater than 72 hours, scuff sand/re-epoxy before topcoating.</li> <li>Temperatures below 75°F, added cure time is recommended.</li> <li>If MP-Epoxy is applied without an induction period, the paint may fail.</li> </ul>
<b>MP-120 Series</b> AccuShade Primer/Sealer	<b>4:1</b> 4 parts MP-120 Series 1 part MA-122 4.6 VOC	Shop Temperatures 60-68°F MA-122 68-80°F MA-122 80-90°F MA-122 90°F & up MA-122	2 Hours	1-2 wet coats 5 to 10 psi HVLP	77°F Air 10-15 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.3 - 1.5 mm 5 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Topcoat within 30 minutes.</li> <li>Do not use over lacquer based products.</li> <li>Do not apply over bare metal.</li> <li>Do not add fisheye eliminator.</li> <li>Allow 20-30 minutes air dry before "rib" sanding.</li> <li>Spray to a smooth satin finish.</li> <li>Agitate MP-120 Series products well before use.</li> <li>In hot weather conditions retarder may be added to MP-120 Series.</li> </ul>
<b>MP-350</b> Premium Acrylic Primer Grey	<b>2:3</b> 2 parts MP-350 3 parts MR-100LV 4.8 VOC	Shop Temperatures 60-68°F MR-100LV 68-80°F MR-100LV 80-90°F MR-100LV 90°F & up MR-100LV	Indefinite	1 to 3 wet coats 8 to 10 psi HVLP Flash 5-10 minutes between coats	77°F Air 30 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.5 - 2.1 mm 8 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 30 minutes before sanding or topcoating with additional primer, sealer or color.</li> <li>Follow mix ratio closely, under reducing product will make product difficult to sand.</li> <li>To avoid sand scratch bridging, do not apply very heavy coats.</li> <li>For maximum performance and color holdout use primer/sealer.</li> <li>Do not use Fisheye Eliminator.</li> <li>Must use MR-100LV for VOC compliance.</li> </ul>
<b>2KPB</b> High Performance 2K Primer Buff	<b>4:1</b> 4 parts 2KPB 1 part 2KPA 4.8 VOC	Shop Temperatures 60-68°F 2KPA 68-80°F 2KPA 80-90°F 2KPA 90°F & up 2KPA	1 - 2 Hours	2 to 3 wet coats 5 to 10 psi HVLP Flash 10-15 minutes between coats	77°F Air 4-5 Hours 140°F Bake 30 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.5 - 2.1 mm 5 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 4-5 hours before sanding.</li> <li>To avoid sand scratch swelling, do not apply heavy coats.</li> <li>Use MX-841 Flex-Aid mixed 4:1 + 10% by volume to RTS mix.</li> <li>May be accelerated, add 1/2 oz per RTS quart.</li> <li>For maximum performance and color holdout use primer/sealer.</li> </ul>
<b>MP-2K GREY</b> Quick Sand Urethane Primer Buff	<b>4:1</b> 4 parts MP-2KGR 1 part MA-2K 4.8 VOC	Shop Temperatures 60-68°F MA-2K 68-80°F MA-2K 80-90°F MA-2K 90°F & up MA-2K	1.5 - 2 Hours	2 to 3 wet coats 5 to 10 psi HVLP Flash 10-15 minutes between coats	77°F Air 2-4 Hours 140°F Bake 30 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.5 - 2.1 mm 5 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 2-4 hours before sanding or topcoating primer with additional primer, sealer or color.</li> <li>Do not use over lacquer based products.</li> <li>Allow 10 minute additional flash time in temperatures below 60°F. Temperatures below 60°F, greatly reduce product's cure time.</li> <li>To avoid sand scratch swelling, do not apply heavy coats.</li> <li>May shrink if coats are rushed or applied heavy.</li> <li>Flex Agent recommended when repairing flexible substrates OFF the vehicle @ 4:1:10% with MX-841 Flex-Aid.</li> <li>For maximum performance and color holdout use primer/sealer.</li> </ul>
<b>MP3-HS</b> Ultra High Build 2K Primer Grey	<b>4:1</b> 4 parts MP3-HS 1 part MA3-HS 4.5 - 4.8 VOC	Shop Temperatures 60-68°F MA3-HS *MR-0860 68-80°F MA3-HS *MR-0870 80-90°F MA3-HS *MR-0885 90°F & up MA3-HS *MR-0895 <small>*See notes for information regarding the use of urethane reducers in MP3-HS</small>	1 - 2 Hours	2 to 3 wet coats 8 to 10 psi HVLP Flash 15 minutes between coats	77°F Air 4-6 Hours 140°F Bake 30 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.5 - 2.1 mm 8 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 4-6 hours before sanding and topcoating.</li> <li>Do not use over lacquer based products.</li> <li>Do not add fisheye eliminator.</li> <li>*Up to 1 part MR-0800 Series reducer may be added to increase flow.</li> <li>Flex Agent recommended when repairing flexible substrates OFF the vehicle @ 4:1:10% with MX-841 Flex-Aid.</li> <li>For maximum performance and color holdout use primer/sealer.</li> </ul>
<b>MP4-2K</b> Lightning Primer Grey	<b>4:1</b> 4 parts MP4-2K 1 part MA4-2K 4.8 VOC	Shop Temperatures 60-68°F MA4-2K 68-80°F MA4-2K 80-90°F MA4-2K 90°F & up MA4-2K	2 - 4 Hours	2 to 3 wet coats 8 to 10 psi HVLP Flash 10-15 minutes between coats	77°F Air 45 Mins. 140°F Bake 30 Mins.	Wet Sand: 800 Grit or finer Dry Sand: 400 Grit or finer	HVLP 1.5 - 2.1 mm 8 - 10 psi @ the air cap	<ul style="list-style-type: none"> <li>Allow 1 hour before sanding or topcoating primer with additional primer, sealer or color.</li> <li>Do not use over lacquer based products.</li> <li>Do not add fisheye eliminator or accelerator.</li> <li>For spot or panel use.</li> <li>Does not contain isocyanates.</li> <li>For maximum performance and color holdout use primer/sealer.</li> <li>In hot temperatures, shorten flash time between coats.</li> </ul>

