

## 20U-24 2K Grey Urethane Primer as a Primer Surfacer

### 1. Properties / Information





- 20U-24 2K Grey Urethane Primer is a quick cure, sandable primer that provides good sand scratch filling with excellent adhesion and topcoat holdout.

### 2. Surface Preparation

Substrate/Pretreatment:	Cleaning	Sanding	Second Cleaning
Well cured old paint work	70U-15 Degreaser	P240 - P400 grit	70U-10 Cleaner
O.E.M. primed spare parts	70U-15 Degreaser	P240 - P400 grit	70U-10 Cleaner
Bare steel	70U-15 Degreaser <i>Then, pre-prime with 25U-30</i>	P80 - P180 grit	70U-10 Cleaner
Galvanized Steel	70U-15 Degreaser <i>Then, pre-prime with 25U-30</i>	Coarse scuff pad	70U-10 Cleaner
Aluminum	70U-15 Degreaser <i>Then, pre-prime with 25U-30</i>	P120 - P180 grit	70U-10 Cleaner
Fiberglass, rigid plastic parts (without gelcoat)	70U-15 Degreaser	P220 grit	70U-10 Cleaner

**NOTES:** On Galvanized Steel and Aluminum, make sure sanding is not so vigorous that it removes the galvanized coating. With the second cleaning, make sure all residue is removed. Pay special attention when cleaning Galvanized Steel and Aluminum.







### 3. Application

	<b>Mixing ratio</b>	<b>4:1:1</b> 4 parts 20U-24 1 part 50U-15, 50U-20 or 50U-30 1 part 60U-10, 60U-20, 60U-30 or 60U-40	<b>Flexed - 4:1:1:1</b> 4 parts 20U-24 1 part 80U-10 1 part 50U-15, 50U-20 or 50U-30 1 part 60U-10, 60U-20, 60U-30 or 60U-40
	<b>Pot life at 68°F / 20°C</b>	45 minutes	45 minutes
	<b>Spray viscosity</b> Ford 4 at 68°F / 20°C	16 - 20 s	16 - 20 s
	<b>Spray gun HVLP</b>	1.5 - 1.7 mm	1.5 - 1.7 mm
	<b>Spray pressure HVLP at the cap</b>	6 - 10 psi	6 - 10 psi
	<b>Application</b>	1 - 2 medium wet coats	1 - 2 medium wet coats
	<b>Film thickness</b>	2.0 - 3.0 mil	2.0 - 3.0 mil
	<b>Coverage</b>	719 sq. ft./gal @ 1.0 mil	765 sq. ft./gal @ 1.0 mil

# Undercoat Technical Information

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### 4. Flash off / Drying / Sanding

	Flash-off at 68°F / 20°C	5 minutes	5 minutes
	Drying at 68°F / 20°C at 140°F / 60°C	60 - 90 minutes 30 - 40 minutes; allow 10 minutes flash before force drying.	60 - 90 minutes 30 - 40 minutes; allow 10 minutes flash before force drying.
	Infrared short wave medium wave	5 - 7 minutes N/A	5 - 7 minutes N/A
	Wet sand by Hand	P400 grit	P400 grit
	Dry sand by Hand	P320 grit	P320 grit
	Dry sand by Machine	P320 grit	P320 grit

### 5. VOC / Comments

VOC as applied	≤ 250 gms/liter (≤ 2.1 lbs/gal)	234 gms/liter (1.9 lbs/gal)
Comments		

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use — read product label and Safety Data Sheet (SDS) for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.