



# FINISH PRO™ 2K PLUS II DTM PRIMER GRAY

79001, 79004

Version: 2.0 Date of issue: 07/10/2019 Revision Date: 08/15/2019 Supersedes: 07/10/2019

## TECHNICAL DATASHEET

FINISH PRO™ 2K PLUS II DTM PRIMER GRAY is a high solids VOC compliant 2K 4:1 acrylic coating that can be used as a multi-role coating.

- Excellent opacity and coverage.
- Excellent film build surface levelling properties.
- Can be air dried, low baked or IR Cured.
- Easy to sand with high gloss holdout.

### Application Guide

#### Tools Required



Personal Protective Equipment (see Safety Data Sheet), HVLP Gun, solvent/water-based degreasers

#### Surface Preparation



Original Paint	Degreaser	Abrasion
Bare Steel	Fast/Slow Solvent-Based Degreaser	P280 (dry), P320 (wet)
Aluminum	Fast/Slow Solvent-Based Degreaser	P180
Galvanised	Fast/Slow Solvent-Based Degreaser	P180*
GRP, Fiberglass, SMC	Water-Based Degreaser	P180*
Polyester Body Filler	Fast/Slow Solvent-Based Degreaser	P240 (dry)
OEM E-Coat	Fast/Slow Solvent-Based Degreaser	P240 (dry)
		Lightly abraded

FINISH PRO™ 2K PLUS II DTM PRIMER GRAY is multifunctional and has superb adhesion to all the substrates above.

Clean and degrease removing dirt, oil, grease and wax with a cleaning solution, such as a solvent/water-based degreaser (please check local VOC regulations).

Abrade with grit paper as stated above for each respective substrate.

Re-clean, dry and degrease the abraded substrate ready for application.

\*For optimum results on galvanised steel and aluminium surfaces, apply 1-2 light even coats of an Etch-Primer according to manufacturer's instructions.

#### Mixing ratio



		Parts by Volume	Final Volume			
			250 ml	500 ml	750 ml	1000 ml
79001, 79004	Primer base	4	337 g	674 g	1011 g	1347 g
79064, 79066	Fast Activator (41-68F)	1	47 g	94 g	141 g	188 g
79074, 79076	Medium Activator (59-95F)		49 g	98 g	147 g	196 g
79084, 79086	Slow Activator (77-113F)		49 g	99 g	148 g	197 g

#### Gun Application



	High Build Primer	Primer Surfacer	Wet-on-Wet Sealer
Mixing Ratio	4:1	4:1:1	4:1:2
Viscosity (Zahn #2)	50 – 65 s	20 – 24 s	14 – 16 s
Working Pot-Life at 68 °F	1 - 2 hour	1 - 2 hours	2 – 3 hours
Gun Tip Size	1.7 - 2.0 mm	1.6 - 1.8 mm	1.3 – 1.4 mm
Air Pressure at Gun	1.8 - 2.0 bar (26-29PSI)	1.8 - 2.0 bar (26-29 PSI)	1.8 - 2.0 bar (26-29 PSI)








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<div>Coats</div> <div></div>	Number of Coats	1 - 2	2 - 3	1 - 2
	Flash-off at 68°F between coats	15 minutes	10 minutes	10 minutes
	Flash-off at 68°F prior forced drying	15 minutes	10 minutes	10 minutes
	Dry Film Build	180 µm (7mil)	100 - 120 µm (4-5 mil)	30 – 60 µm (1-2 MIL)
	Approximate Theoretical Coverage* @ 1 mil DFT	807 ft²/ Gallon	674 ft²/Gallon	578.0 ft²/Gallon
<div>Drying Time</div> <div></div>	Air Drying Sandable at 20°C	3 - 4 hours	3 - 4 hours	2 – 3 hours
	Force Drying Sandable at 60°C (surface temperature)	30 minutes	30 minutes	30 minutes
<div>Sanding</div> <div></div>	Dry Sanding	P320 - P400	P320 - P400	P320 - P400
	Wet Sanding	P500 – P800	P500 – P800	P500 – P800
<div>Over-Painting</div> <div></div>	FINISH PRO™ 2K PLUS II DTM PRIMER GRAY can be overpainted with most water-based or solvent-based paint systems or solid colors.			
Technical information				
<div>Physical properties</div> <div></div>	Appearance	Viscous, Liquid.		
	Color	Gray		
	Specific gravity / density	≈ 1.69 (1.67 - 1.71) g/cm³		



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<b>7900</b>	<b>Unmixed</b>		
As Packaged Regulatory VOC	404 g/l (3.37 lb/gal)		
As Packaged Actual VOC	404 g/l (3.37 lb/gal)		
Percent Solids	76.23 wt%		
Volatiles	23.8 wt%		
Water Content	0 wt%		
Exempt Compounds by weight	0 wt%		
Exempt Compounds by volume	0 vol%		
% HAPS	11.1 wt%		
Specific gravity / density	1684 g/l (14.0 lbs/gal)		
<b>Mix with 7906 Fast Activator</b>	<b>4 : 1</b> <b>7900: 7906</b>	<b>4 : 1 : 1</b> <b>7900:7906:Reducer*</b>	<b>4 : 1 : 2</b> <b>7900:7906:Reducer*</b>
As Applied Regulatory VOC	445 g/l (3.7 lbs/gal)	529 g/l (4.4 lbs/gal)	558 g/l (4.7 lbs/gal)
As Applied Actual VOC	445 g/l (3.7 lbs/gal)	529 g/l (4.4 lbs/gal)	558 g/l (4.7 lbs/gal)
Percent Solids	71.16 wt%	61.24 wt%	58.37 wt%
Volatiles	28.84 wt%	38.76 wt%	41.6 wt%
Water Content	0 wt%	0 wt%	0 wt%
Water Content	0 vol%	0 vol%	0 vol%
Exempt Compounds by weight	0 wt%	0 wt%	0 wt%
Exempt Compounds by volume	0 vol%	0 vol%	0 vol%
% HAPS	12.6 wt%	19.9 wt%	28.7 wt%
Specific gravity / density	1544 g/l (12.9 lbs/gal)	1365 g/l (11.4 lbs/gal)	1341 g/l (11.2 lbs/gal)
<b>Mix with 7907 Medium Activator</b>	<b>4 : 1</b> <b>7900: 7907</b>	<b>4 : 1 : 1</b> <b>7900:7907:Reducer*</b>	<b>4 : 1 : 2</b> <b>7900:7907:Reducer*</b>
As Applied Regulatory VOC	445 g/l (3.7 lbs/gal)	529 g/l (4.4 lbs/gal)	570 g/l (4.7 lbs/gal)
As Applied Actual VOC	445 g/l (3.7 lbs/gal)	529 g/l (4.4 lbs/gal)	570 g/l (4.7 lbs/gal)
Percent Solids	71.17 wt%	61.24 wt%	56.22 wt%
Volatiles	28.8 wt%	38.8 wt%	43.8 wt%
Water Content	0 wt%	0 wt%	0 wt%
Water Content	0 vol%	0 vol%	0 vol%
Exempt Compounds by weight	0 wt%	0 wt%	0 wt%
Exempt Compounds by volume	0 vol%	0 vol%	0 vol%
% HAPS	12.6 wt%	19.9 wt%	24.9 wt%
Specific gravity / density	1544 g/l (12.9 lbs/gal)	1365 g/l (11.4 lbs/gal)	1301 g/l (10.8 lbs/gal)
<b>Mix with 7908 Slow Activator</b>	<b>4 : 1</b> <b>7900: 7908</b>	<b>4 : 1 : 1</b> <b>7900:7908:Reducer*</b>	<b>4 : 1 : 2</b> <b>7900:7908:Reducer*</b>
As Applied Regulatory VOC	446 g/l (3.7 lbs/gal)	530 g/l (4.4 lbs/gal)	570 g/l (4.8 lbs/gal)
As Applied Actual VOC	446 g/l (3.7 lbs/gal)	530 g/l (4.4 lbs/gal)	570 g/l (4.8 lbs/gal)
Percent Solids	71.15 wt%	61.22wt%	56.20 wt%
Volatiles	28.8% wt%	38.8 wt%	43.8 wt%
Water Content	0 wt%	0 wt%	0 wt%
Water Content	0 vol%	0 vol%	0 vol%
Exempt Compounds by weight	0 wt%	0 wt%	0 wt%
Exempt Compounds by volume	0 vol%	0 vol%	0 vol%
% HAPS	9.7% wt%	15.1 wt%	20.5 wt%
Specific gravity / density	1545 g/l (12.9 lbs/gal)	1366 g/l (11.4 lbs/gal)	1302 g/l (10.9 lbs/gal)

These values are based on theoretical calculations. Batch-to-batch variations may lead to small differences in VOC values. Please be aware that the addition of additives such as a Reducer will lead to changes in VOC content. A generic Fast Reducer formulation has been used in this case to estimate the set of 4:1:1 Primer Surfacers VOC values. \* 4:1:1 and 4:1:2 values are based on mixing with a generic "fast" reducer. Please ensure you use a reducer that will not cause your final mix to exceed local VOC limits.

### Equipment Cleaning

Clean gun immediately after use with a thinner or gunwash. Please choose gun-cleaner products which are VOC compliant in your area.

### Important Remarks

Do not use activated product beyond pot life. Activated material should not be returned to the original can of non-activated material.

### Shelf Life & Storage



Order Code	Format	Shelf Life	Comment
79001 FINISH PRO™ 2K PLUS II DTM PRIMER GRAY	1 US Gallon Tin	2 years	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
79004 FINISH PRO™ 2K PLUS II DTM PRIMER GRAY	1 QT Tin	2 years	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
79064 FINISH PRO™ 2K PLUS II FAST ACTIVATOR	1 QT Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
79066FINISH PRO™ 2K PLUS II FAST ACTIVATOR	250 ml Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed

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79074 FINISH PRO™ 2K PLUS II MEDIUM ACTIVATOR	1 QT Tin	1 year	on base of tin. Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
79076 FINISH PRO™ 2K PLUS II MEDIUM ACTIVATOR	250 ml Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
79084 FINISH PRO™ 2K PLUS II SLOW ACTIVATOR	1 QT Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.
79086 FINISH PRO™ 2K PLUS II SLOW ACTIVATOR	250 ml Tin	1 year	Shelf life from date of manufacture or a 5 digit batch code, depending on the production line used, printed on base of tin.

Store in a well-ventilated place. Keep cool. Keep container tightly closed. Store locked up.

**Recommended storage temperature**

**41 - 77°F**

### IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.

*This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. FINISH PRO™ disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the FINISH PRO™ website at [WWW.FINISH-PRO.COM](http://WWW.FINISH-PRO.COM). FINISH PRO™ is not responsible for the results obtained by others over whose methods we have no control and thereof FINISH PRO™ is not liable for consequential or incidental damages including loss of profits.*