



# FINISH PRO™ 2.1 PLUS II DTM PRIMER GRAY

79201, 79204

Version: 2.0 Date of issue: 07/08/2019 Revision Date: 08/16/2019 Supersedes: 07/08/2019

## TECHNICAL DATASHEET

FINISH PRO™ 2.1 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.

- High solids content.
- Easy to sand with great holdout.
- Protective sealant properties eliminate the need for epoxy sealants.
- Tintable with 10% mixing base.
- Excellent adhesion direct to metal and over OEM paint, e-coat, fiberglass, most plastics and polyester filler.
- Triple Tight Tin fits on a standard mixing bank.

### Application Guide

#### Tools Required



*Personal Protective Equipment (see Safety Data Sheet), P180 – P600 abrasives, HVLP Gun, solvent/water-based degreasers, Etch Primer*

#### Surface Preparation



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

FINISH PRO™ 2.1 PLUS II DTM PRIMER GRAY is multifunctional and has superb adhesion to all the substrates above.

For best results, good preparation is essential. Abrade with grit paper as stated above for each respective substrate. 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 as per manufacturer's instructions.

#### Mixing ratio



|              |                            | Parts by Volume | Final Volume |        |        |         |
|--------------|----------------------------|-----------------|--------------|--------|--------|---------|
|              |                            |                 | 250 ml       | 500 ml | 750 ml | 1000 ml |
| 79201, 79204 | Primer Base                | 4               | 328 g        | 655 g  | 983 g  | 1310 g  |
| 79364, 79366 | Fast Activator (41-68°F)   | 1               | 53 g         | 106 g  | 159 g  | 212 g   |
| 79374, 79376 | Medium Activator (59-95°F) |                 | 55 g         | 111 g  | 166 g  | 221 g   |
| 79384, 79386 | Slow Activator (77-113°F)  |                 | 58 g         | 116 g  | 174 g  | 232 g   |

#### Gun Application



|                                 | High Build Primer         | Primer Surfacer           | Wet-on-Wet                |
|---------------------------------|---------------------------|---------------------------|---------------------------|
| <b>Mixing Ratio</b>             | 4:1                       | 4:1:1                     | 4:1:2                     |
| <b>Viscosity (Zahn #2)</b>      | 50 – 70 s                 | 20 – 22 s                 | 16 – 18 s                 |
| <b>Working Pot-Life at 68°F</b> | 1 - 2 hours               | 1 – 2 hours               | 2 – 3 hours               |
| <b>Gun Tip Size</b>             | 1.7 - 2 mm                | 1.6 - 1.8 mm              | 1.3 – 1.7 mm              |
| <b>Air Pressure at Gun</b>      | 1.8 - 2 bar (26 - 29 PSI) | 1.8 - 2 bar (26 - 29 PSI) | 1.8 - 2 bar (26 - 29 PSI) |



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### Coats



| 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 (7 MIL) | 100 - 120 (4-5 MIL) | 30 - 60 µm (1-2 MIL) |
| Approximate Theoretical Coverage* @ 1 MIL DFT | 802 ft²/Gal    | 667 ft²/Gal         | 574 ft²/Gal          |

### Drying Time



|   |             |             |             |
|---|-------------|-------------|-------------|
| <b>Air Drying</b><br>Sandable at 20°C                         | 3 - 4 hours | 3 - 4 hours | 2 - 3 hours |
| <b>Force Drying</b><br>Sandable at 60°C (surface temperature) | 30 minutes  | 30 minutes  | 30 minutes  |

### Sanding



|             |             |             |             |
|-------------|-------------|-------------|-------------|
| Dry Sanding | P320 - P400 | P320 - P400 | P320 - P400 |
| Wet Sanding | P500 - P800 | P500 - P800 | P500 - P800 |

### Over-Painting



FINISH PRO™ 2.1 PLUS II DTM PRIMER GRAY can be overpainted with most water-based or solvent-based paint systems or solid colors.

## Technical information

### Physical properties



|                            |                            |
|----------------------------|----------------------------|
| Appearance                 | Viscous, Liquid.           |
| Color                      | Gray                       |
| Specific gravity / density | ≈ 1.645 (1.6 - 1.69) g/cm³ |



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### VOC Information



|  |   |   |  |  |
|--|---|---|--|--|
| <b>7920</b><br><b>As Packaged Regulatory VOC</b><br><b>As Packaged Actual VOC</b><br><b>Percent Solids</b><br><b>Volatiles</b><br><b>Water Content</b><br><b>Water Content</b><br><b>Exempt Compounds</b><br><b>Exempt Compounds</b><br><b>% HAPS</b><br><b>Specific gravity / density</b> | <b>Unmixed</b><br><br>268 g/l (2.24 lb/gal)<br>203 g/l (1.69 lb/gal)<br>76 wt%<br>24.0 wt%<br>0 wt%<br>0 vol%<br>11.7 wt%<br>24.3 vol %<br>6.3 wt%<br>1638 g/l (13.7 lbs/gal) |   |  |  |
| <b>Mixed with 7936 Fast Activator</b>  | <b>4:1</b><br><br><b>7920:7936</b>  | <b>4:1:1</b><br><br><b>7920:7936:Reducer*</b>   | <b>4:1:2</b><br><br><b>7920:7936:Reducer*</b>  |  |
| <b>As Applied Regulatory VOC</b><br><b>As Applied Actual VOC</b><br><b>Percent Solids</b><br><b>Volatiles</b><br><b>Water Content</b><br><b>Water Content</b><br><b>Exempt Compounds</b><br><b>Exempt Compounds</b><br><b>% HAPS</b><br><b>Specific gravity / density</b>                  | 248 g/l (2.1 lbs/gal)<br>170 g/l (1.4 lbs/gal)<br>70.63 wt%<br>29.4 wt%<br>0 wt%<br>0 vol%<br>18.2 wt%<br>31.7 vol%<br>5.4 wt%<br>1522 g/l (12.7 lbs/gal)                     | 234 g/l (2.0 lbs/gal)<br>127 g/l (1.1 lbs/gal)<br>60.51 wt%<br>39.5 wt%<br>0 wt%<br>0 vol%<br>30.1 wt%<br>45.6 vol%<br>4.3 wt%<br>1362 g/l (11.4 lbs/gal) | 234 g/l (2.0 lbs/gal)<br>111 g/l (0.9 lbs/gal)<br>55.46 wt%<br>44.5 wt%<br>0 wt%<br>0 vol%<br>36.0 wt%<br>52.4 vol%<br>4.0 wt%<br>1301 g/l (10.8 lbs/gal)        |  |
| <b>Mixed with 7937 Medium Activator</b>  | <b>4:1</b><br><br><b>7920:7937</b>  | <b>4:1:1</b><br><br><b>7920:7937:Reducer*</b>   | <b>4:1:2</b><br><br><b>7920:7937:Reducer*</b>  |  |
| <b>As Applied Regulatory VOC</b><br><b>As Applied Actual VOC</b><br><b>Percent Solids</b><br><b>Volatiles</b><br><b>Water Content</b><br><b>Water Content</b><br><b>Exempt Compounds</b><br><b>Exempt Compounds</b><br><b>% HAPS</b><br><b>Specific gravity / density</b>                  | 248 g/l (2.1 lbs/gal)<br>170 g/l (1.4 lbs/gal)<br>70.43 wt%<br>29.6 wt%<br>0 wt%<br>0 vol%<br>18.5 wt%<br>31.3 vol%<br>5.4 wt%<br>1531 g/l (12.8 lbs/gal)                     | 222 g/l (1.8 lbs/gal)<br>118 g/l (1.0 lbs/gal)<br>57.92 wt%<br>42.1 wt%<br>0 wt%<br>0 vol%<br>33.3 wt%<br>46.9 vol%<br>3.9 wt%<br>1342 g/l (11.2 lbs/gal) | 222 g/l (1.8 lbs/gal)<br>105 g/l (0.9 lbs/gal)<br>53.59 wt%<br>46.4 wt%<br>0 wt%<br>0 vol%<br>38.3 wt%<br>52.8 vol%<br>3.6 wt%<br>1289 g/l (10.7 lbs/gal)        |  |
| <b>Mixed with 7938 Slow Activator</b>  | <b>4:1</b><br><br><b>7920:7938</b>  | <b>4:1:1</b><br><br><b>7920:7938:Reducer*</b>   | <b>4:1:2</b><br><br><b>7920:7938:Reducer*</b>  |  |
| <b>As Applied Regulatory VOC</b><br><b>As Applied Actual VOC</b><br><b>Percent Solids</b><br><b>Volatiles</b><br><b>Water Content</b><br><b>Water Content</b><br><b>Exempt Compounds</b><br><b>Exempt Compounds</b><br><b>% HAPS</b><br><b>Specific gravity / density</b>                  | 248 g/l (2.1 lbs/gal)<br>170 g/l (1.4 lbs/gal)<br>69.85 wt%<br>30.1 wt%<br>0 wt%<br>0 vol%<br>19.1 wt%<br>31.4 vol%<br>5.4 wt%<br>1542 g/l (12.9 lbs/gal)                     | 248 g/l (2.1 lbs/gal)<br>142 g/l (1.2 lbs/gal)<br>62.78 wt%<br>37.2 wt%<br>0 wt%<br>0 vol%<br>27.3 wt%<br>42.9 vol%<br>4.8 wt%<br>1430 g/l (11.9 lbs/gal) | 248 g/l (2.1 lbs/gal)<br>121 g/l (1.0 lbs/gal)<br>57.01 wt%<br>43.0 wt%<br>0 wt%<br>0 vol%<br>34.0 wt%<br>51.0 vol%<br>4.4% by weight<br>1350 g/l (11.2 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.

\* 4:1:1 and 4:1:2 values have been based on mixing with a generic "Low VOC fast" reducer. Please ensure you use a reducer that will not cause your final mix to exceed local VOC limits.

### Shelf Life & Storage



|   |  |                   |   |  |
|---|--|-------------------|---|--|
| <b>Equipment Cleaning</b>                     | Clean gun immediately after use with a thinner or gunwash. Please choose gun-cleaner products which are VOC compliant in your area.  |                   |   |  |
| <b>Important Remarks</b>                      | Activated material should not be returned to the original can of non-activated material. Do not use activated product beyond pot life. After 10 minutes standing, the paint may need mild agitation to reliquify before 2nd and 3rd coat applications. |                   |   |  |
| <b>Order Code</b>                             | <b>Format</b>  | <b>Shelf Life</b> | <b>Comment</b>  |  |
| 79201 FINISH PRO™ 2.1 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. |  |
| 79204 FINISH PRO™ 2.1                         | 1 QT Tin   | 2 years           | Shelf life from date of manufacture or a 5 digit batch code,  |  |

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|  |           |        |   |
|--|-----------|--------|---|
| PLUS II DTM PRIMER GRAY                        |           |        | depending on the production line used, printed on base of tin.  |
| 79364 FINISH PRO™ 2.1 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. |
| 79366 FINISH PRO™ 2.1 PLUS II FAST ACTIVATOR   | 250ml 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. |
| 79374 FINISH PRO™ 2.1 PLUS II MEDIUM 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. |
| 79376 FINISH PRO™ 2.1 PLUS II MEDIUM ACTIVATOR | 250ml 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. |
| 79384 FINISH PRO™ 2.1 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. |
| 79386 FINISH PRO™ 2.1 PLUS II                  | 250ml 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. AXIS PERFORMANCE COATINGS 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 AXIS PERFORMANCE COATINGS website at [WWW.AXISCOATINGS.COM](http://WWW.AXISCOATINGS.COM). AXIS PERFORMANCE COATINGS is not responsible for the results obtained by others over whose methods we have no control and thereof AXIS PERFORMANCE COATINGS is not liable for consequential or incidental damages including loss of profits.*