



PRODUCT DATA SHEET

2K Urethane Primer Surfacer

SUITABLE SUBSTRATES

Epoxy Primer Surfacer (SUM-UP230/SUM-UP232)

Properly prepared factory finishes

Other properly cured and prepped primer systems

PREPARATION

Thoroughly clean surface with a combination of soap and hot water, then rinse well and dry.

Use SUM-UP404 Wax & Grease Remover over entire surface to eliminate any traces of wax, grease, oil and other possible contaminants. Use a clean, dry towel to wipe solvent off surface.

Abrade entire surface area, completely removing any loose paint or portions of the film that demonstrate compromised adhesion. Feather out any portions where bare metal has been revealed.

Reclean entire surface with SUM-UP403 Surface Wash to completely remove all sanding debris.

Spot prime bare metal areas with SUM-UP230/SUM-UP232 Epoxy Primer or other suitable DTM primer.

If applying SUM-UP220 2K Urethane Primer Surfacer more than four days after application of SUM-UP230 or SUM-UP232 epoxy primer, be sure to abrade surface prior to application of 2K Urethane Primer Surfacer.

DIRECTIONS FOR USE

2K Urethane Primer Surfacer is designed for automotive refinish uses. Primer should be thoroughly agitated prior to opening the can. After shaking, primer should be stirred to ensure any corrosion inhibitors, extenders and other pigments that may have settled during storage are brought back into solution. Once stirred, can should be closed and shaken again.

Mix four parts 2K Urethane Primer Surfacer with one part of the appropriate Urethane Activator (4:1) depending on temperature and other conditions at the time of application:

ACTIVATORS:

SUM-UP100 (Fast)	Low-temp (Below 70° F)
SUM-UP101 (Medium)	Mid-temp (70° F - 80° F)
SUM-UP102 (Slow)	High-temp (Above 80° F)

Additional reduction is not necessary. If desired, reduction may be achieved with one of the following urethane-grade reducers. For maximum film build, do not reduce.

REDUCERS:

SUM-UP400 (Fast)	Low-temp (Below 70° F)
SUM-UP401 (Medium)	Mid-temp (70° F - 80° F)
SUM-UP402 (Slow)	High-temp (Above 80° F)
SUM-UP405	Zero-VOC Reducer

All components should be thoroughly mixed together before proceeding. Ensure all containers are closed tightly after each use.

Activated mixture has a potlife of approximately two to three hours at 70° F.



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GUN SETTINGS

For additional details about tip sizes, air pressures and other adjustments that may be worth considering, please refer to specific gun manufacturer's technical information.

<u>HVLP GUNS</u>	<u>CONVENTIONAL GUNS</u>
1.4 mm—1.6mm tip	1.4mm—1.8mm tip
8-10 psi (output)	40-50 psi

APPLICATION

Apply 2K Urethane Primer Surfacer in two medium wet coats, allowing 15 minutes flash time between each coat. Additional coats may be applied for more build.

DRY TIMES / RECOAT

FLASH TIME:	Allow 15 minutes
DUST FREE:	Allow 10-15 minutes
WET SAND:	Allow 2-3 hours
DRY SAND:	Allow 3-4 hours
CURE:	After 18-24 hours

All times above are approximate, at 70° F. Dry times will be shorter at elevated temperatures and longer at reduced temperatures. Additional factors including elevation, airflow and film thickness also should be considered.

Before sanding, use an aerosol or dry guide coat system over 2K Urethane Primer Surfacer to help identify low spots that may need additional coats of primer.

Once entire surface area has been leveled, primer may be top-coated for up to 18 hours without any additional prep. After 18-hour recoat window has passed, surface of primer must be abraded prior to topcoat application.

CLEANUP

Close all containers tightly after each use. Cleanup with gun wash or other appropriate solvent products to prevent damage to spray equipment.

2K Urethane Primer Surfacer may be used for several years after the actual date of manufacture as long as it is properly stored at a consistent temperature.

Isocyanate activators, however, such as SUM-UP100, SUM-UP101 and SUM-UP102, have a limited shelf life once opened. Seals should be cleaned and cans sealed tightly after each use. Activators should be used within one month from the date the can is first opened.

PERSONAL HEALTH / SAFETY

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS UNDER CONTROLLED CONDITIONS.

It is not intended for sale to the general public. Keep out of reach of children and pets.

Be aware, this system includes multiple components. It will not work if all components are not used as directed. Before opening any containers, read and understand all warning statements on all labels, as mixture will have hazards of all system components. Follow all precautions.

At a minimum, the following personal safety measures should be taken:

Apply this material only in a well ventilated, controlled spray-booth environment with sufficient air flow and explosion-proof electrical connections.

Wear an appropriate, properly fitted respirator (NIOSH-approved) during and after application, until all organic solvent vapors and spray mists are exhausted. Wear splash goggles, impervious gloves and protective clothing when mixing and spraying materials.

Refer to Material Safety Data Sheet for more information.

WARRANTY

This product is manufactured of first-class materials. Directions for use of this system are based on tests, information and experience believed to be reliable. Neither manufacturer nor seller has control over the methods and/or conditions of use or actual application of product. It is the responsibility of the user to determine the suitability of product for intended use. Product warranty shall be limited to the replacement of defective materials only. No other warranty is expressed or implied.