



GENERAL INFORMATION

99998 is a neutral-colored 2K primer/sealer base formulated to provide excellent flow, adhesion, recoatability, and sealing characteristics.



1. COMPONENTS

- 99998 Neutral 2K Primer/Sealer
- CPS 1-5 Colorants
- HPC0 Universal Slow Activator
- HPC1 Universal Standard Activator
- HPC2 Universal Fast Activator
- HPC3 Universal Very Fast Activator
- X01/X02 Fast/Medium Uni-Solvent LV
- 171 Fast Uni-Solvent - up to 75°F (24°C)
- 172 Medium Uni-Solvent - 75-85°F (24-29°C)
- 173 Slow Uni-Solvent - 85-95°F (29-35°C)
- 174 Very Slow Uni-Solvent - 95°F (35°C) and above
- 171HP High Performance Reducer Fast
- 172HP High Performance Reducer Medium
- 173HP High Performance Reducer Slow
- 174HP High Performance Reducer Very Slow



2. MIXING RATIO

- 1) Mix three (3) parts 99998 to one (1) part CPS toner 1-5
- 2) Mix 4 parts of color primer to 1 part HPC0, HPC1, HPC2, or HPC3 activator and reduce 10-25% by volume with solvents or reducers listed above

USA VOC compliant rules:

For VOC 2.8 compliant use Uni-Solvent LV X01 or X02.
For VOC national rule use solvents or reducers listed above
Activator selection should be based on the size of the part to be painted, temperature, and airflow in the spraying environment



3. POT LIFE @ 77°F (25°C)

1-2 Hours (Reduction may extend potlife.)



4. CLEAN UP

Uni-Solvent 171-174 or Uni-Solvent LV X01, X02 (check local regulations).



5. ADDITIVES

ACCELERATOR: T566 up to 2 ounces per gallon



6. SURFACE PREPARATION

- Over bare metal apply anti-corrosive primer(s) per data sheets instruction and allow to dry per instruction before applying 99998.
- Over previously painted substrates, abrade well with 400-600 grit sand paper then wipe clean with an approved waterborne or solvent borne surface wipe.



7. SUBSTRATES

- Properly prepared previously painted surfaces
- Properly prepared OEM finishes
- Properly cleaned OEM e-coat
- Valspar 2K Primers/ Sealers
- SE88 1k Self Etch Primer



8. APPLICATION

Spray 1-2 medium wet coats, overlap 50%

NOTE: Do not spray when surface temperature is below 50°F (10°C).



9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

	HPC0	HPC1	HPC2	HPC3
Flash between coats	15-20 min	10-15 min	10-15 min	5-10 min
Dust Free	10-15 min	7-12 min	5-10 min	4-8 min
To Topcoat	45 min	30 min	30 min	20 min



10. INFRARED CURE

See Infrared Curing Information.



11. GUN SET UP

CONVENTIONAL GUN

Gravity Feed 1.6 mm - 2.0 mm
Siphon Feed 1.8 mm - 2.0 mm



HVLP

Gravity Feed 1.3 mm - 1.6 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed 30-40 psi (2.0-2.8 bar)
Siphon Feed 30-35 psi (2.0-2.5 bar)

HVLP Inlet Air

30 psi (2.0 bar)
See spray gun manufacturer info



12. PHYSICAL DATA

Density	11.21 lbs./gal. (X01/X02 Reduction)
VOC (PKG) per US Gal.	2.53 lbs./gal.
VOC Coating	2.8 lbs./gal. max (X01/X02 Reduction)
VOC Coating	4.6 lbs./gal. max (171-174 Reduction)
National Rule (RTS)- Total Solids by Weight (RTS)	55.19%
Total Solids by Volume (RTS)	41.36%
Sq. Ft. Coverage/US Gal. @ 1 mil (RTS)	663.5
National Rule (RTS)- Total HAPS (lb HAPS/solid gal.)	0.74
Recommended DFT	0.5 - 1.5 mils/10-35 µm
Zahn #2 Viscosity (RTS)	19 - 21 Seconds
Din cup #4 mm	16 - 18 Seconds
Flash Point	-4°F / -20°C