



## GENERAL INFORMATION

CPS9EN is a tintable single component fast drying, non-sanding Enamel Primer Sealer with excellent adhesion and moisture resistance for very good corrosion resistance.



## 1. COMPONENTS

- 999EN Neutral Primer
- CPS 1-5 Colorants
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Very Fast Activator
- X01 Fast Uni-Solvent LV
- X02 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

Mix three (3) parts 999EN to one (1) part CPS 1-5.  
Mix tinted 999EN with 30% solvents or reducers listed above

### USA VOC compliant rules:

For VOC 3.5 compliant use Uni-Solvent LV X01 or X02.  
For VOC national rule use solvents or reducers listed above



## 3. OPTIONAL MIXING RATIO

Activator (optional): Ten (10) parts 999EN Primer to one (1) part HPC activators (10:1).



## 4. POT LIFE @ 77°F (25°C)

4 hours with activator



## 5. CLEAN UP

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



## 6. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Wipe surface with 155 Surface Cleaner (steel) or 170 Aqua Clean (steel/aluminum) and wipe dry with clean cloth before product flashes.
- Sand and featheredge substrate with P320 grit dry sandpaper or wet equivalent.
- Clean surface with 155 Surface Cleaner or 170 Aqua Clean and wipe dry with clean cloth before product flashes.



## 7. SUBSTRATES

- Properly prepared OEM
- Properly prepared previously painted surfaces
- Properly treated steel and aluminum
- SE88



## 8. APPLICATION

- Spray one to two medium wet coats allowing 20 minutes between coats. (Allow each coat to flash dull.)

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



## 9. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

Flash between coats	20 Minutes.
To Topcoat	40 Minutes



## 10. GUN SET UP

### CONVENTIONAL GUN

- Gravity Feed 1.3 mm - 1.5 mm
- Siphon Feed 1.6 mm - 1.8 mm



### HVLP

- Gravity Feed 1.3 mm - 1.5 mm

### AIR PRESSURES

#### Conventional @ Gun

- Gravity Feed 35-40 psi (2.5-2.8 bar)
- Siphon Feed 40-50 psi (2.8-3.4 bar)

#### HVLP Inlet Air

#### PANEL

- 35-40 psi (2.5-2.8 bar)
- 40-50 psi (2.8-3.4 bar)
- 30 psi (2.0 bar)
- See spray gun manufacturer info



## 11. PHYSICAL DATA

	RTS @ 3.5 LBS./ GAL.	RTS @ 4.6 LBS./ GAL.
VOC (PKG) per US Gal.	3.5	4.6
National Rule (RTS)- Total Solids by Weight (RTS)	53.13% max.	49.97% max
Total Solids by Volume (RTS)	38.18% max	37.39% max%
Sq. Ft. Coverage/US Gal. @ 1 mil (RTS)	612.5	599.8
National Rule (RTS)- Total HAPS (lb HAPS/ solid gal.)	0.07	0.74