



GENERAL INFORMATION

PR4 is a 2.1 VOC, 2K polyurethane primer formulated for refinishing of flexible parts where impact resistance and system flexibility are critical.



1. COMPONENTS

- PR4 Flexible 2K Polyurethane Primer
- HPC218 Zero VOC Polyurethane 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) plus
- 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 4 parts PR4 to 1 part HPC218 (4:1). May be reduced up to 25% with solvents or reducers listed above.

USA VOC compliant rules:

For VOC 2.1 compliant use Uni-Solvent LV X01 or X02.
For VOC national rule use solvents or reducers listed above.



3. POT LIFE @ 77°F (25°C)

1-2 Hours



4. CLEAN UP

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



5. SURFACE PREPARATION

- Wash surface with mild detergent and water.
- Rinse and dry surface.
- Scuff surface with a gray or yellow scuff pad.
- If the substrate is thermopolefin (TPO) or polypropylene (PPO), wipe with PR1 and apply PR2 before applying PR4.
- If it is an approved substrate for PR4 then you may wipe surface with 170 and apply to scuffed part.



6. PLASTIC SUBSTRATES

- PR2
- PC (Polycarbonate)
- SMC (Sheet Molded Compound)
- PPO (Polyphenylene Oxide)
- PA (Polyamide)
- PMMA (Acrylic)
- ABS (Acrylonitrile Butadiene Styrene)
- ASA (Acrylonitrile Styrene Acrylate)
- RTM (Resin Transfer Molding Compound)
- PPA (Poly Phynelene Amid)



7. OTHER SUBSTRATES

- Properly cleaned and sanded fiberglass and OEM finish



8. APPLICATION

- Spray medium wet coats to desired film thickness.
 - Allow each coat 10-15 minutes flash or until finish is 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	10 Minutes
To Sand	1.5 Hours
To Topcoat	30 Minutes*

* If not topcoated within 24 hours, primer must be sanded before topcoating.



10. GUN SET UP

CONVENTIONAL GUN

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



HVLP

Gravity Feed 1.4 mm - 1.7 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed 30-35 psi (2.0-2.4 bar)
Siphon Feed 30-40 psi (2.0-2.8 bar)

HVLP Inlet Air

20-30 psi (1.5-2.0 bar)
See spray gun manufacturer info



11. PHYSICAL DATA

	PR4 (4:1) with X01, X02
VOC	2.1 lbs./gal.
Volume Solids	53.2%
Theoretical Coverage	672 sq. ft. per mil/25 µm per gallon
Recommended DFT	1.0 - 2.0 mils (25 - 50 µm)
Zahn #2 Visc. (RTS)	18 - 20 Seconds
Din cup #4 mm	16 - 18 Seconds