



## GENERAL INFORMATION

98N is a Polyurethane primer sealer formulated to provide excellent flow, adhesion, recoatability, and sealing characteristics. 98N is compliant as a sealer under national rule and 2.8 VOC regulations, provided proper mix ratios are followed.



## 1. COMPONENTS

- 98N Polyurethane Primer/Sealer
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Warp Speed<sup>®</sup> Activator
- X01 Fast Exempt Uni-Solvent
- X02 Medium Exempt Uni-Solvent
- 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



## 2. MIXING RATIO

Mix 4 parts base to 1 part HPC0, HPC1, HPC2, or HPC3 activator and reduce 10-25% by volume. For national rule compliance, 171-174 reducers may be used.

For compliance under 2.8 VOC regulations, X01 or X02 must be used.

**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 pot life)



## 4. CLEAN UP

Valspar Refinish 100 Thinner (check local regulations).



## 5. ADDITIVES

ACCELERATOR: T566 up to 2oz. per gallon.

FISHEYE: Not Recommended.

FLEX ADDITIVE: N/A

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



## 6. SURFACE PREPARATION

- Over bare metal apply anti-corrosive primer(s) per data sheets instruction and allow to dry per instruction before applying 98N.
- Over previously painted substrates, abrade well with 400-600 grit sand paper then wipe clean with an approved water base or solvent base surface wipe.



## 7. SUBSTRATES

- Properly sanded OEM finishes
- Properly cleaned OEM E-Coat
- VP or CPSVP Series Epoxy Primer/Sealer
- 92B060
- 96N
- 88G016
- DTM2004 and CPSDTM Series



## 8. APPLICATION

- Spray 1-2 medium wet coats, overlap 50%.



## 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

Siphon Feed

#### HVLP @ Cap

#### PANEL

30-40 psi

30-35 psi

8-10 psi

#### OVERALL

45-55 psi

40-45 psi

8-10 psi



## 12. PHYSICAL DATA

VOC Coating	2.8 - 3.8 lbs/gal
Volume Solids	42.3 (mixed)
Theoretical Coverage	678 sq. ft. per mil per gallon
Recommended DFT	0.5 - 1.5 mils
Zahn #2 Viscosity (RTS)	19 - 21 seconds