



## 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 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 PR4 to 1 part HPC218 (4:1). May be reduced up to 25% with X01 or X02 Uni-Solvent (4:1:0-25%).



## 3. POT LIFE @ 77°F (25°C)

1-2 Hours



## 4. CLEAN UP

Valspar Refinish 100 Thinner or X01 Uni-Solvent (check local regulations).



## 5. ADDITIVES

ACCELERATOR: N/A  
FISHEYE: Not Recommended.  
FLEX ADDITIVE: N/A

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



## 6. 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 thermopolyolefin (TPO) or polypropylene (PPO), wipe with PR1 and apply PR2 before applying PR3 or PR4.
- If it is an approved substrate for PR3 and PR4 then you may wipe surface with 170 and apply to scuffed part.



## 7. 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)



## 8. OTHER SUBSTRATES

- 88G016 and V880
- Properly cleaned and sanded fiberglass and OEM finish



## 9. APPLICATION

- Spray medium wet coats to desired film thickness.
- Allow each coat 10-15 minutes flash or until finish is dull.



## 10. 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.



## 11. 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  
Siphon Feed

#### PANEL

30-35 psi  
30-40 psi

#### OVERALL

40-45 psi  
45-55 psi  
8-10 psi

#### HVLP @ Cap



## 12. PHYSICAL DATA

	PR4 (4:1)
VOC	2.1 lbs./gal.
Volume Solids	53.2%
Theoretical Coverage	672 sq. ft./mil/gallon
Recommended DFT	1.0 - 2.0 mils
Zahn #2 Visc. (RTS)	18-20 seconds

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