



PRODUCT DESCRIPTION

P27, P27B and P27W SpectraPrime™ Color Surfacers are 2.1 VOC premium quality 2K-urethane primer surfacers designed for optimum performance in areas that require low VOC coatings. These color surfacers are fast drying 2-component surfacers that provide the best in gloss holdout, resistance to film shrinkage, easy sanding, and contain Ure-Flex technology™ which means this primer does not require the addition of a flex additive for plastic parts repair/refinishing. The P27, P27B and P27W color surfacers can be converted to a 2.1 VOC wet-on-wet sealer *with the addition of a converter (S42)*. (See P27 Sealer PDS for instructions- AS2736)

SUITABLE SUBSTRATES



- Treated Steel
- Galvanized Steel
- Treated Aluminum
- OEM Enamels
- Refinish Enamels
- Fiberglass
- Body Filler
- Etching Primer
- SW Adhesion Promoter UPO 7228

MIXING



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P27, P27B, P27W
Primer Surfacer

H45
Hardener

ES15, ES20, ES25
or AS9
Reducer

SURFACER SURFACE PREPARATION:

For Painted Surfaces:

1. Wash the area that is to be coated (allow to dry).
2. Remove any excess grease with G2K153 (Ultra) or G2T151.
3. Scuff surface with 180-grit sandpaper.
4. Clean surface with G2K153 (Ultra) or G2T151.

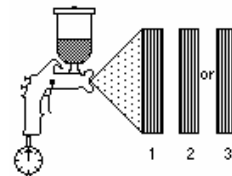
For Bare Metal:

1. Remove oil/grease with G2K153 (Ultra) or G2T151.
2. Scuff surface with 180-grit sandpaper.
3. Clean surface with G2K153 (Ultra) or G2T151.
4. Prime surface with E2G970.

APPLICATION



1. Apply 2-3 medium/wet coats at a gun distance of 5" to 7."
2. Allow each coat to flash 5 to 10 minutes.
3. 6-9 psi air cap pressure HVLP
4. 20-30 psi inlet pressure for High Transfer equipment
5. Film build (prior to sanding) should be between 2-6 mils.



PRODUCT DATA SHEET



DRYING SCHEDULE

Force Dry: ES25 is recommended for force dry applications: 25-30 minutes @ 140°F

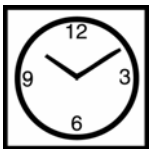
- Note: Do not force dry when using AS9 (Exempt Accelerated Solvent)
- As soon as product has dried and you are able to sand, you can proceed with applying basecoat.

Air Dry Cure Schedule: Less than 1 hour with AS9, 2-3 Hours at 70°F with ES-15 or ES-20, overnight or bake recommended with ES25 Slow Reducer.

Short Wave Infrared: 10 minute flash @ 100°F followed by a 10 minute full power @ 130°F using ES25 Reducer and a lamp distance of 36”.

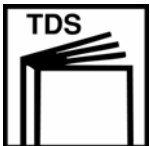
* Note: Higher film builds will require longer dry times.

RECOAT



- P27, P27B, P27W Primer Surfacer
- P27, P27B, P27W Sealer
- AWX® Waterborne topcoats
- Ultra 7000® topcoats
- Maximum recoat time after sanding = 7 days. After 7 days, scuff sand using a gray nylon pad

NOTES



- Clean equipment immediately after use with appropriate gun and equipment cleaner.
- Excessive number of coats will extend dry times.
- Pot life: 1 hour
- On soluble substrates, use P27, P27B and P27W Surfacer on complete panels only.
- If top coating directly over P27, P27B or P27W Surfacer, sand with P600 grit sandpaper.
- Meets 2009 SCAQMD VOC standards

PERSONAL PROTECTION



- For use by trained professionals only.
- Read label, directions, and MSDS before use.
- Use appropriate Personal Protective Equipment while mixing and spraying.

REGULATORY DATA

Primer Surfacer Series RTS	As Packaged		As Applied	
	Lb/Gal	G/L	Lb/Gal	G/L
Density	12.93	1549	11.61	1391
	% by Wt.	% by Vol.	% by Wt.	% by Vol.
Volatiles	31.5	47.1	42.6	56.8
Water	0.0	0.0	0.0	0.0
Exempt Compounds	17.0	21.0	31.8	39.4
	Lb/Gal	G/L	Lb/Gal	G/L
VOC Total	1.87	224	1.24	149
VOC Less Exempt	2.36	283	2.05	246
	Lb/Gal	KG/L	Lb/Gal	KG/L
HAPs	0.48	0.058	0.40	0.047