



TECHNICAL DATA SHEET

P80 1K GRAY DTM (DIRECT TO METAL) PRIMER

07202021



P80 is a 1K, high build, high production, acrylic urethane primer with excellent hold out and easy to sand properties. Light Gray color makes it easy to achieve opacity with a minimum number of color coats.



COMPONENTS

- P80
- R60/70/85

Primer
Fast/Medium/Slow National Rule Reducers



MIXING RATIO

P80 Primer is ready to spray. 10% reducer may be added.



POT LIFE

N/A



CLEAN UP

Use Lacquer Thinner or zero VOC solvents. (Check local regulations)



PHYSICAL DATA

Solids wt. 49.37 % (+ or - 2%)
Volume wt. 37.99 % (+ or - 2%)

VOC

Coating: 3.30 lbs/gal - 395.96 g/l
Material: 2.23 lbs/gal - 268.05 g/l



DRY / FLASH TIMES

Dust Free: 10 minutes @ 68°F/20°C
Dry to Touch 20 minutes @ 68°F/20°C
Dry to Sand 1 hour per coat @ 68°F/20°C
Force Dry 20 minutes @ 140°F/60°C



GUN SETUPS

HLVP Gravity Feed 1.4 mm – 1.7 mm
Pressure Pot HLVP 1.0 mm – 1.2 mm
Air Assist Airless 1.0 mm - 1.2 mm
Conventional 1.5 mm - 1.8mm



SURFACE PREPARATION

Use HyMax Clean Wipe (S01) to clean substrate free of grease, dirt, and foreign contaminants.

Best:
SA2 sandblast Blow all dust and contaminants off and apply P80 primer within 8 hours.

Better:
Hot Phosphate wash system, blow dry and apply P80 primer Within 8 hours.

Good:
Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminants before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply P80 primer within 4 hours.

Aluminum: Only suitable if Hystar Epoxy Primer is applied first.

Galvanized Steel: Only suitable if P10 Primer is applied first.



APPLICATION AT 77° F/25°C

- One to three medium wet coats, allow 10-20 minutes flash between coats.



SAFETY

Refer to Material Safety Data Sheet (MSDS) for complete safety instructions. The technical data sheet listed has been compiled in good faith for your convenience and guidance. No warranty, expressed or implied, is intended or given by the information on this sheet.

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