

TM
PRIME
XP

Prime HS Primer / Surfacer - Tech Sheet

PPX - 55

PPX - 55 HS High Build Primer / Surfacer is a two component Urethane Primer formulated to be applied as a High Build Primer or Final non-sanding wet-wet sealer. It is ideally suited for use in Automotive, Fleet, Industrial, Marine and Aerospace refinishing applications. PPX - 55 offers excellent filling properties, fast dry, superb adhesion, very easy sanding and superior color hold out.



Features and Benefits

High solids
Versatile choice of 3 hardeners
Fills quickly
Fits most shop conditions
Increased productivity

Hardeners

PXH - 102 Normal Temp Hardener
PXH - 103 Slow Temp Hardener
PXH - 104 Extra Slow Temp Hardener

Reducer

PR - 860 Cool Temp 60-70°F
PR - 870 Medium Temp 65 - 80°F
PR - 885 Warm Temp 75 - 90°F
PR - 895 Hot Temp 85 - 100°F

Compatible Substrates

- PPX - 55 HS Primer / Surfacer may be applied over :
- Properly prepared, treated & Epoxy primed bare steal, galvanized steel and aluminum.
 - Properly cleaned and sanded gel coated Fiberglass.
 - Properly cleaned and sanded OEM Finishes.
 - Properly cleaned and sanded E - Coat.
 - Quality Body Fillers & Putty's.
 - Quality Epoxy Primers
 - Quality Self Etching Primers
 - Quality Plastic Adhesion Promoters

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Preperations



- Wash the area to be painted with soap & water, then clean with a high quality cleaner.
- Sand the bare metal areas completely with 180-240 grit. Old finishes must be sanded by hand or sander with 320-400 grit dry or 600 grit wet.



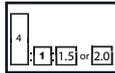
- Re-Clean with high quality cleaner.
- Steel & aluminum sunstrates must have a 2 step metal treatment, self Etching primer or epoxy primer coating before applying PPX - 55.

Mix Ratios



Standard Mix

PPX - 55	:	PXH Hardners	(Optional) PRxx Reducers
4	:	1	0 - 1



Sealer Mix

PPX - 55	:	PXH Hardners	PR-885/895 Slow/X-Slow Reducers
4	:	1	1.5 - 2

Note : When using as sealer, wait 15 min minimum and 30 minutes maximum. If passed 30 minutes, scuff or lightly sand the sealer and apply 1 medium coat.



Pot Life

4 : 1

1 Hour without reducer at 70°F (21°C)

1-2 Hour with reducer at 70°F (21°C)

1-2 Hour Flexibilized at 70°F (21°C)

Additives



Fisheye Eliminators - DO NOT USE !!!!!



Universal Retarder will slow the initial flash dry allowing slightly more time for the overspray to melt back into the surface when applying in high temperatures, high humidity or large surface areas.



Flex additive can be used to increase flexibility of PPX - 55. 10 % RTS Quart. This can be helpful during installation and the life of a flexible part.



Accelerator is not required. In severe cold conditions, 1/2 oz per RTS quart may be used.

Air Pressure & Gun Setup



HVLP	8-15 psi at the air cap
Compliant Gun Setup	29 - 40 psi at the gun
Approx. Distance	1.4-1.7 mm or equivalent
Inlet PSI	5" - 7"
	18 - 22 psi

Application



Apply	2 -3 single coats
Total Recommended Dry Film :	2.0 - 2.5 mils

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Dry Times



Between Coats

1ST Coat 15 - 20 Minutes
2ND Coat 20 - 25 Minutes



Air Dry to sand

1 - 1.5 Hour at 70°F (21°C)



Force Dry at 140°F (60°C)

Purge Time	20 Minutes
Bake Time	30 Minutes



Infra Red

Medium Wave :	20 Minutes
Short Wave :	10 Minutes



Sanding

Grade Wet :	400 - 600 grit
Grade Dry Machine :	320 - 500 grit



Note : Bake times are for metal temperatures. Additional time should be allowed in the force drying schedule for metal to reach recommended temperature.



Recoat

PPX - 55 may be recoated after sufficient dry time has been allowed and then sanded.

Equipment Cleaning



Spray guns, gun cups, storage pots, etc., should be cleaned thoroughly after each use with any appropriate general purpose solvent.

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Technical Information:

Primer :	Gray
Hardeners:	PXH - 102, PXH - 103, PXH - 104
Mixing Ratio:	4:1
Weight Solids (RTS):	67 %
Volume Solids (RTS):	43 %
Film Build:	2.2 - 2.5 mils per full coat
Coverage:	705 sq. ft. per gallon(RTS) 1 mil 100% transfer efficiency

V.O.C. as Delivered:	Regulatory V.O.C. lbs/gal	Regulatory V.O.C. g/l	Material V.O.C. lbs/gal	Material V.O.C. g/l
PPX - 55	4.2	508.2	4.2	508.2
V.O.C. (RTS):				
PPX - 55 w/PXH-102	4.1	496.1	4.1	496.1
PPX - 55 w/PXH-103	4.0	484.0	4.0	484.0
PPX - 55 w/PXH-104	4.0	484.0	4.0	484.0

see SDS for this product

Disposal/Safety:

FOR INDUSTRY USE ONLY

Read SDS Before Use

The contents of the package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.

The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.