



# 2K Regular Build Primer

2.1 VOC

## Product Numbers:

6520-1 Gray (gallon)

6520-4 Gray (quart)

6530-1 Black (gallon)

6501-4 Activator (quart)

6501-6 Activator (half pint)

## Mixing: 4:1

Mix 4 parts Build Primer to 1 part Activator. This primer can be reduced with SPI Urethane Reducers 870, 885, and 895 or equivalent Low VOC reducers. Do not reduce more than 25%.

**Caution! Due to the thickness of this primer it is very important that you completely mix the activator in with the primer. MIX ONE FULL MINUTE!**

## Pot Life:

60 minutes at 70 degrees. Do not leave mixed product in the paint gun for more than 30 minutes.

## Spraying: Gun tip recommendation 1.8 – 2.5

**Always coat bare metal with epoxy first! Remove any internal gun strainers.** Mix only what you immediately need and clean the gun when you are finished. Spray a full wet coat and let it flash. Spray a total of two to three coats being sure to let each coat flash before spraying the next coat. Flash times will vary from 3-5 minutes depending on temperature.

## Filling:

This primer is the same as our High Build Primer except it will spray a little thinner. This is an excellent primer for the high-quality shop that does not need a very high filling primer. This primer is made to fill like the major paint manufacturers best 2K primers. A sealer is not required for this primer prior to painting.

## Sanding:

Depending on how you applied it and current temperature this primer should be ready to sand in 45-60 minutes. If sanded primer has set more than 24 hours you must scuff first with a gray scuff pad or equivalent before applying another product.

## Winter:

Add 2-4oz of SPI 900-4 Polar Accelerator per sprayable quart in shops with inadequate heat.

## Summer:

Add 2-6oz of SPI 925-4 Urethane Retarder per sprayable quart if the primer is drying too fast.