



GENERAL INFORMATION

CPS HS Primer is a colored Multi-Use 2K polyurethane Surfacer/Sealer formulated to provide the ultimate in performance, productivity, versatility, leveling, adhesion, Color Holdout, and superior sanding and sealing characteristics.



1. COMPONENTS

- CPS HS CPS HS Binder
- CPS1-5 CPS Toners
- 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) and over
- 171HP High Performance Reducer Fast
- 172HP High Performance Reducer Medium
- 173HP High Performance Reducer Slow
- 174HP High Performance Reducer Very Slow
- X01 Fast Uni-Solvent LV
- X02 Medium Uni-Solvent LV
- HPC0 Slow Activator
- HPC1 Standard Activator
- HPC2 Fast Activator
- HPC3 Very Fast Activator



2. MIXING RATIO

Mix three (3) parts CPSHS to one (1) part CPS 1-5 to create desired color then activate and reduce for desired application.

PRIMER- 4:1:1 (by volume)

Mix four (4) parts CPSHS to one (1) part HPC activator and reduced with one (1) part solvents or reducers listed above.

USA VOC compliant rules:

For VOC 2.8 compliant use Uni-Solvent LV X01 or X02.
For VOC national rule use solvents or reducers listed above

SEALER- 4:1:2 (by volume)

Mix four (4) parts CPSHS to one (1) part HPC activator and reduced with two (2) parts Uni-Solvent.

USA VOC compliant rules:

For VOC 2.8 compliant use Uni-Solvent LV X01 or X02.
For VOC national rule use solvents or reducers listed above



3. POT LIFE @ 77°F (25°C)

	HPC0	HPC1	HPC2	HPC3
As Surfacer	40 min.	40 min.	30 min.	20 min.
As Sealer	45 min.	45 min.	35 min.	25 min.



4. CLEAN UP

Uni-Solvent 171-174 or Uni-Solvent LV X01, X02 (check local regulations).



5. SURFACE PREPARATION

- Surfaces should be prepared using the proper undercoat system following recommended procedures.
- Sanding grits coarser than 220P grit should be finish sanded with finer grit prior to application.
- Clean surface with Aqua Clean 170.



6. SUBSTRATES

- Properly prepared previously prepared surfaces
- Properly prepared OEM finishes
- VP50 Series Epoxy Primer
- DTM Series Primer
- SE88 or ASE200



7. APPLICATION

- Spray one to three medium wet coats or until desired build is achieved.
Do not exceed 6 mils 250 µm).



7. APPLICATION (Continued)

- Allow each coat 5-10 minutes flash or until flash is dull.
- Surface temperature should be 50 - 100°F (10 - 38°C) with less than 80% ambient humidity preferred.



8. FLASH / DRY TIMES

AIR DRY @ 77°F (25°C)

	As Surfacer	As Sealer
Flash between coats	5-10 min.	4-8 min.
To Sand	60 min.	Nib Sand 20 min.
To Topcoat	60 min.	20 min.

Note - when applied as a sealer:

After 24 hours, Surface must be scuffed before applying basecoat or topcoat.



9. INFRARED CURE

See Infrared Curing Information.



10. GUN SET UP

CONVENTIONAL GUN

Gravity Feed

Siphon Feed



HVLP

Gravity Feed

As Primer

1.4 mm - 1.8 mm

1.4 mm - 1.8 mm

As Sealer

1.3 mm - 1.5 mm

1.3 mm - 1.4 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed

Siphon Feed

HVLP Inlet Air

30-45 psi (2.0-3.1 bar)

30-45 psi (2.0-3.1 bar)

30 psi (2.0 bar)

See spray gun manufacturer info



11. PHYSICAL DATA

Reduced with Uni-Solvent 171-174

	As Surfacer	As Sealer
VOC (PKG) per U.S. Gal.	2.5	2.5
VOC (RTS) per U.S. Gal.	3.32	3.86
Recommended DFT	50-150 µm	13-25 µm
Total Solids by Weight (RTS)	67.7%	61.4%
Total Solids by Volume (RTS)	49.8%	42.7%
Sq. Ft. Coverage/US Gal. (RTS)	799	685
Flash Point (RFS)	45°F / 7°C	45°F / 7°C
Total HAPS (lb HAPS/gal solid)	0.984	1.21

Reduced with Uni-Solvent LV X01 or X02

	As Surfacer	As Sealer
VOC (RTS) per U.S. Gal.	2.56	2.56
Flash Point (RFS)	-4°F / -20°C	-4°F / -20°C
Total HAPS (lb HAPS/gal solid)	0.493	0.493