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LABORATORY PRODUCT REPORT

PR-2904 PRIMER

DESCRIPTION

PR-2904 primer is a two-part, chemically curing compound of spray consistency designed to promote adhesion between PR-2911 and a variety of metallic surfaces. It is effective over a temperature range of -65°F (-54°C) to +250°F (+121°C) with short term exposure to +360°F (+182°C).

APPLICATION PROPERTIES (Typical)

Color:	
Part A	Black
Part B	Tan
Mixed	Black
Mixing ratio:	Part A:Part B
By weight	9.3:100
Viscosity (Brookfield) poise (Pa-s)	
Part A, 7 @ 10 RPM	800 (80)
Part B, 2 @ 10 RPM	15 (1.5)
Mixed, 2 @ 10 RPM	20 (2.0)
Application Life, minutes	30
Time to topcoat @ 75°F (25°C), hrs	16
Film thickness, mils wet, minimum	10

SURFACE PREPARATION

To obtain good adhesion to metallic surfaces, parts shall be cleaned with solvents to remove dirt, grease and processing lubricants used in manufacturing. Just prior to primer application to surfaces which are chemically treated and/or chemically treated and coated with epoxy or urethane coatings, the surfaces should be cleaned with solvent, with oil-free, soap-free rags or paper towels (reclaimed solvents or Kim-wipe paper should not be used). Wash one small area at a time, then dry with a clean cloth before solvent evaporates to prevent redeposition of oil, wax or other contaminants.

To maintain a clean solvent supply, always pour the solvent on the washing cloth.

MIXING INSTRUCTIONS

PR-2904 Primer Kits consist of the proper proportions of base compound and accelerator and the entire contents are to be mixed, or mix 100 parts (by weight) of base compound with 9.3 parts (by weight) of accelerator.
Thoroughly stir base compound and accelerator in their respective containers until an even consistency is obtained before proportioning.

Slowly stir the accelerator into the base compound and thoroughly mix approximately 5 minutes with spatula for smaller kits or jiffy mixer for larger kits. Avoid entrapment of air. Be sure to scrape the sides and bottom of container.

APPLICATION INSTRUCTIONS

Application may be done by brush, roller or spray techniques.

For spray application, standard pressure pot, airless or air-assisted airless equipment may be used (check local EPA regulations regarding the use of spray equipment).

Apply PR-2904 Primer to a wet film thickness of 0.010 inches (0.26 mm) minimum, which will result in a dry film thickness of 0.007 inches (0.18 mm). Allow to dry for 16 hours at 77°F (25°C) and 50% relative humidity. Lower or higher temperatures/relative humidity may require longer or shorter dry times respectively.

If PR-2904 Primer has been applied more than 48 hours before applying topcoat, abrade surface and wipe with methyl ethyl ketone or other suitable solvent.

CLEANING OF EQUIPMENT

Spatulas or other equipment may be cleaned with 1,1,1 -trichloroethane.

STORAGE CONDITIONS

The storage life of PR-2904 Primer is six months for parts A and B when kept at temperatures below 80°F (27°C) in the original, unopened containers.

SAFETY PRECAUTIONS

WARNING: CONTAINS FLAMMABLE AND VOLATILE SOLVENTS

Keep away from heat, sparks, and flame. Proper safety precautions used with flammable material must be taken when applying this product. Comply with all local and safety regulations.

HEALTH PRECAUTIONS

PR-2904 Primer is a safe material to handle when reasonable care is observed. Ordinary hygienic principles, such as washing the compound from the hands before eating or smoking, should be observed. Avoid prolonged contact with skin, contact with open breaks in the skin, and ingestion. In case of contact with skin, wipe off excess, then wash with soap and water. Obtain medical attention in case of extreme exposure or ingestion.

PR-2904 Primer contains a small quantity of toluene. The threshold limit value in air is 200 parts per million for safe working conditions. Use adequate ventilation or air-supplied respirators during application. Avoid repeated or prolonged breathing of vapors. In case of extreme vapor exposure, remove affected person to fresh air immediately and obtain medical attention. For additional health and safety information, consult a Material Safety Data Sheet.

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