

20U-23 2K White Urethane Primer as a National Rule Sealer

1. Properties / Information





- 20U-23 2K White Urethane Primer is a performance sealer that provides good filling properties and quick drying with good melt-in and topcoat holdout. Do **not** mix with 20U-24 2K Grey Urethane Primer.

2. Surface Preparation

| Substrate/Pretreatment: | Cleaning | Sanding | Second Cleaning |
|---------------------------------------------------|------------------------------------------------------------------|------------------|-----------------|
| Well cured old paint work | 70U-15 Degreaser | P240 - P400 grit | 70U-10 Cleaner |
| O.E.M. primed spare parts | 70U-15 Degreaser | P240 - P400 grit | 70U-10 Cleaner |
| Bare steel | 70U-15 Degreaser <i>Then, pre-prime with 23U-10 or 25U-30</i> | P80 - P180 grit | 70U-10 Cleaner |
| Galvanized Steel | 70U-15 Degreaser <i>Then, pre-prime with 23U-10 or 25U-30</i> | Coarse scuff pad | 70U-10 Cleaner |
| Aluminum | 70U-15 Degreaser <i>Then, pre-prime with 23U-10 or 25U-30</i> | P120 - P180 grit | 70U-10 Cleaner |
| Flexible plastic parts | 70U-20 Cleaner <i>Then, pre-prime with 21-20</i> | P220 grit | 70U-10 Cleaner |
| Fiberglass, rigid plastic parts (without gelcoat) | 70U-15 Degreaser | P220 grit | 70U-10 Cleaner |

NOTES: On Galvanized Steel and Aluminum, make sure sanding is not so vigorous that it removes the galvanized coating. With the second cleaning, make sure all residue is removed. Pay special attention when cleaning Galvanized Steel and Aluminum.







3. Application

| | | | |
|-------------------------------------------------------------------------------------|--------------------------------------------------|---------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------|
|  | Mixing ratio | 6:1:2 6 parts 20U-23 1 part 50U-15, 50U-20 or 50U-30 2 parts 60U-10, 60U-20, 60U-30 or 60U-40 | Flexed - 4:1:1:2 4 parts 20U-23 1 part 80U-10 1 part 50U-15, 50U-20 or 50U-30 2 parts 60U-10, 60U-20, 60U-30 or 60U-40 |
| | Pot life at 68°F / 20°C | 75 - 90 minutes | 75 - 90 minutes |
|  | Spray viscosity Ford 4 at 68°F / 20°C | 12 - 15 s | 13 - 16 s |
|  | Spray gun HVLP | 1.3 - 1.5 mm | 1.3 - 1.5 mm |
| | Spray pressure HVLP at the cap | 6 - 10 psi | 6 - 10 psi |
|  | Application | 1 - 2 medium wet coat | 1 - 2 medium wet coat |
| | Film thickness | 1.0 - 1.5 mil | 1.0 - 1.5 mil |

Undercoat Technical Information

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4. Flash off / Drying / Sanding

| | | | |
|-----------------------------------------------------------------------------------|------------------------------------------|-------------------------------------------|-------------------------------------------|
|  | Flash-off at 68°F / 20°C | 5 minutes between coats | 5 minutes between coats |
|  | Drying at 68°F / 20°C at 140°F / 60°C | 30 minutes flash before topcoating N/A | 30 minutes flash before topcoating N/A |
|  | Infrared short wave medium wave | N/A N/A | N/A N/A |
|  | Wet sand by Hand | N/A | N/A |
|  | Dry sand by Hand | N/A | N/A |
|  | Dry sand by Machine | N/A | N/A |

5. VOC / Comments

| | | |
|----------------|--------------------------------------------------------|-----------------------------|
| VOC as applied | 424 gms/liter (3.5 lbs/gal) | 429 gms/liter (3.6 lbs/gal) |
| Comments | Do not mix with 20U-24 2K Grey Urethane Primer. | |

Materials described are for application by professional trained personnel only using proper equipment. Products may be hazardous & should be used according to label directions & technical data information. Appropriate respiratory protection should be worn at all times while products are in use — read product label and Safety Data Sheet (SDS) for specific details. Statements & methods described are based upon the latest standard of technology known to the manufacturer. Application procedures cited are suggestions only & are not to be interpreted as warranty for events resulting from their use. Dilution ratios are intended to provide maximum performance within the typical Volatile Organic Compound (VOC) restriction for product use. Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.