



Multi Purpose 2.1 VOC Primer

P330-1900

Description P330-1900 Multi-Purpose 2.1 VOC Primer is a fast drying, two component gray primer which may be used as a primer surfacer or as a wet-on-wet sealer when integrated with P390-4004 and P390-4005 clear coats.

Products	Multi-Purpose 2.1 VOC Primer:	P330-1900	
	Multi-Purpose Primer Hardener:	P315-3900	
	Compliant Thinner:	P830-2034	Fast
		P830-2035	Medium
		P830-2036	Slow

Suitable for use over:

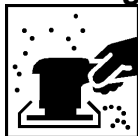
OEM & refinish coatings in good condition, fiberglass / GRP, body filler; all properly cleaned and sanded.

For steel, aluminum and galvanized steel, first apply SX1071 Etch Primer

Surface Preparation

Old finishes: Wash with soap and water and rinse well. Remove tar and grease with SWX350 *O-So-Clean* before sanding. Sand, re-clean with SWX350 prior to application of P330-1900.

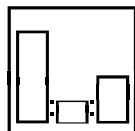
Sanding



Bare metal: Machine sand 180 - 220 grit

Old finishes: For use as a primer: 180 - 220 grit.
For use as a sealer: 320 - 400 grit

Mixing



Primer-Surfacer

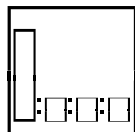
Primer	P330-1900
Hardener	P315-3900
Thinner	P830-203X

By volume:

4	Parts
1	Part
2	Part

Additives

- SLV814 Flex additive 10% to RTS quart



Wet on Wet Sealer

Primer	P330-1900
Clearcoat	P390-4004/-4005
Hardener	P315-3900
Thinner	P830-203X

By volume:

3	Parts
1	Part
1	Part
1	Part

Pot Life: ½ hour at 4:1:2
1 hour at 3:1:1:1

Application

Conventional gun:

Tip size 1.3 – 1.6 mm

Air pressure 40-50 psi at the gun



HVLP gun:

Tip size 1.3 – 1.6 mm

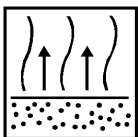
Air pressure 10 psi max at the cap

Refer to manufactures inlet pressure requirements.

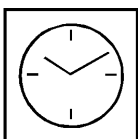
Coats

2 - 4 coats for Primer-Surfacer

1 - 2 coats for Wet on Wet sealer

Flash Time

5-10 minutes between coats at 70°F/21°C

Drying

Air Dry 70°F/21°C:

Primer Surfacer: 1 ½ -3 hours to sand (4:1:2)

W-o-W Sealer: 15 minutes to topcoat (3:1:1:1)

Force Dry:

4:1:2

20 - 30 minutes at 140°F/60°C to sand and topcoat.

Infrared :

10-15 minutes

Process Notes

When P330-1900 is used as a primer surfacer, it must be sanded prior to overcoating or topcoating.

Clean up equipment immediately after use, using suitable solvent. Dispose of waste in accordance with applicable regulations.

Film Build Per coat

4:1:2 : 1.2-1.5 mils

3:1:1:1 : 1.5-2 mils

Coverage

4:1:2 : 592 sq. ft. / gal, at 1 mil dry film.

3:1:1:1 : 602 sq. ft. / gal, at 1 mil dry film.

PRIMER-SURFACER	Standard System	Flexible System
RTS Combinations:	P330-1900 : P315-3900 : P830-203X	P330-1900 : P315-3900 : P830-203X + 10% SLV814
Volume Ratio:	4 : 1 : 2	4 : 1 : 2 +10%
Applicable Use Category	Primer	Primer
VOC Actual (g/L)	120	113
VOC Actual (lbs/gal)	1.00	0.94
VOC Regulatory (less water less exempt (g/L)	235	228
VOC Regulatory (less water less exempt) (lbs/gal)	1.96	1.90
Density (g/L)	1450 - 1490	1430 – 1466
Density (lbs/gal)	12.10 – 12.43	11.93 – 12.23
Volatiles wt. %	49.4 – 50.7	51.2 – 52.5
Water wt. %	0.0	0.0
Exempt wt. %	41.1 – 42.7	43.3 – 44.8
Water vol. %	0.0	0.0
Exempt vol. %	49.0	50.3

PRIMER-SEALER	Standard System	Flexible System
RTS Combinations:	P330-1900 : P390-400X : P315-3900 : P830-203X	P330-1900 : P390-400X : P315-3900 : P830-203X +10% SLV814
Volume Ratio:	3 : 1 : 1 : 1	3 : 1 : 1 : 1 +10%
Applicable Use Category	Primer-Sealer	Primer-Sealer
VOC Actual (g/L)	123 - 138	116 - 129
VOC Actual (lbs/gal)	1.03 – 1.15	0.97 - 1.07
VOC Regulatory (less water less exempt (g/L)	236 – 242	228 - 234
VOC Regulatory (less water less exempt) (lbs/gal)	1.97 – 2.02	1.90 -1.95
Density (g/L)	1389 – 1402	1376 – 1409
Density (lbs/gal)	11.59 – 11.70	11.48 – 11.76
Volatiles wt. %	47.0 – 49.9	49.2 – 52.4
Water wt. %	0.0	0.0
Exempt wt. %	37.1 – 41.2	39.8 – 44.1
Water vol. %	0.0	0.0
Exempt vol. %	43.0 – 48.0	44.9 – 49.2

See Material Safety Data Sheet and Labels for additional safety information and handling instructions
EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION:
 USA (412) 434-4515; CANADA (514) 645-1320; MEXICO 91-800-00-214
