



2K Hi-Build Primer-Surfacer P330-1700

Description P330-1700 2K Hi-Build Primer-Surfacer is a fast drying, two component grey urethane primer-surfacer for auto refinsh.

Products	2K Hi-Build Primer-Surfacer:	P330-1700	
	Hardener:	P315-3700	
	Thinner:	P830-2065	Fast
		P830-2075	Medium
		P830-2085	Slow
		P830-2095	Extra Slow
P830-2097		Super Slow	

Suitable for use over:

Old paintwork in good condition, fiberglass / GRP, body filler; properly cleaned and sanded. For steel, aluminum and galvanized steel, apply Self-Etch Primer P330-1100 first.

- P330-1100 Self-Etch Primer
- P330-1200 Epoxy Primer
- P330-1800 Plastic Primer

Compatible

Topcoats: Value-PRO VA, VU and VB/VBP

Surface Preparation

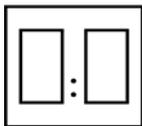
Old paintwork: Wash with soap and water and Rinse well. Remove tar and grease with P830-2066 Cleaner before sanding. Sand, re-clean with P830-2066 prior to application of P330-1700.

Sanding



- Bare metal: Machine sand 120-180 grit
- Old finishes: Hand sand 400 grit wet
Or machine sand 180-240 grit dry

Mixing



- Primer: P330-1700
- Hardener: P315-3700
- *Thinner: P830-XXXX

By volume:

- 4 Parts
- 1 Part
- 1 Part

Additives

- P300-9002
- P300-9005

*For higher build applications, thinner may be reduced by 50% to a 4:1:0.5 ratio.

Pot Life: (4:1:1)

1 hour @ 70°F/21°C

Application

Conventional gun:

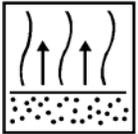
Tip size 1.5 – 1.8 mm
Air pressure 40-50 psi at the gun

HVLP gun:

Tip size 1.3 – 1.9 mm
Air pressure 10 psi max at the cap

Refer to manufacturer's inlet pressure requirements.

Coats2-4 coats
(3.0-8.0 mils dry film)

Flash Time

5-10 minutes between coats (@ 70°F/21°C)

Drying

Air Dry (@ 70°F/21°C):

1½ -3 hours to sand and topcoat (4:1:1)
3 - 6 hours to sand and topcoat (4:1:0.5)

Force Dry:

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

Infra Red (medium wave):

10-15 minutes

Process NotesP330-1700 **must** be sanded prior to overcoating or topcoating.P330-1700 may be tinted up to 10% by volume with Value-PRO™ solid color mixing toners prior to activating and thinning. **DO NOT** use metallic or pearl toners.

Clean up equipment immediately after use, using Value-PRO thinner or another suitable solvent. Dispose of waste in accordance with applicable regulations.

VOC

Package = 4.01 lb/gal, Applied (4:1:1) = 4.66 lb/gal

Coverage538 sq. ft. / gal, at 1 mil dry film. (4:1:1)

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
