

JP35x Series

2.1 VOC Multi Purpose Primer

Background

SHOP-LINE® JP35x series is a fast drying, two component, low VOC primer-sealer which may be used as a primer surfacer or as a wet-on-wet sealer when integrated with clear coat. JP35x Series is available in white, gray and black.

Components

Primer	Hardener	Reducer
JP354 2.1 VOC Multi-Purpose Primer - White	JH358 Multi-Purpose Primer Hardener	JR554 Low VOC Compliant Reducer (Fast)
JP355 2.1 VOC Multi-Purpose Primer - Gray		JR555 Low VOC Compliant Reducer (Medium)
JP356 2.1 VOC Multi-Purpose Primer - Black		JR556 Low VOC Compliant Reducer (Slow) 75-85°F (24-29°C) (refer to SLTB-001 <i>Shop-Line</i> Thinner Guide)

Clearcoats

JC780 2.1 VOC Polyurethane Speed Clear
 JC7200 2.1 VOC HS European Clearcoat
 JC830 2.1 VOC Production Clear
 JC7100 2.1 VOC HS European Multi-Panel Clearcoat
 JC815 Low VOC Speed Clear

Compatible Products

Can be applied over:

Cleaned sanded and etch primed steel, galvanized and aluminum.
 Sanded and cleaned body filler, SMC and gel-coated fiberglass.
 Properly cleaned and sanded E-Coat
 Cleaned, cured and sanded OEM and refinish coatings.
 SX1071 ECOBASE™ 5.5 Etch Prime
 SU470LV 1K Compliant Adhesion Promoter
 JP209 Gray Polyester Primer Filler
 JP390 2.1 VOC Epoxy Primer

Can be topcoated with:

JP390 1.2 VOC Epoxy Primer
 JP36x 2.1 VOC Urethane Sealer Series
 JBPX *Shop-Line* Plus 3.5 VOC Acrylic Urethane Basecoat
 JBX 3.5 VOC Basecoat
 JTX 2.8 VOC Direct Gloss Acrylic Urethane
 JLX 2.8 VOC Acrylic Enamel

Preparation

Surface Cleaning:

SXA103 MULTI-PREP™
 SXA330 ACRYLI-CLEAN® Wax and Grease Remover
 SWX350 H₂O-SO-CLEAN® Waterborne Pre-Cleaner
 SX1009 2.9 VOC Bug and Tar Remover

Sanding

For use as a primer: 180-220 Grit machine on bare steel
 For use as a sealer: 320-400 Grit machine on primer or old finishes.

Mixing



Primer Surfacer: $\frac{\text{JP35x} : \text{JH358} : \text{JR55x}}{4 : 1 : 2}$



Wet on Wet Sealer: $\frac{\text{JP35x} : \text{JC830/JC7100/JC815} : \text{JC780/JC7200} : \text{JH358} : \text{JR55x}}{3 : 1 : 1 : 1}$



Pot Life: 45 minutes at 70°F (21°C) at 4:1:2
1 Hour at 70°F (21°C) at 3:1:1:1



Additives: SLV814 Universal Flexiblizer 10% to RTS mix

Air Pressure and Gun Setup



HVLP: 8 - 10 psi at the air cap
Compliant: 29 - 40 psi at the gun

Gun Setup: 1.3 - 1.6 mm or equivalent

Note: For best overall results, refer to spraygun manufacturer's recommendations for inlet air pressures.

Application



Coats: 4:1:2 2 - 4 coats for Primer-Surfacer
3:1:1:1 1 - 2 coats for Wet-on-Wet Sealer

Dry Times



Between Coats: 5 - 10 minutes at 70°F (21°C)



Air Dry: **4:1:2 Primer Surfacer**
1-2 hours at 70°F (21°C) to sand and topcoat
3:1:1:1 Wet on Wet Sealer
15 minutes to topcoat



Force Dry: **4:1:2 Primer Surfacer**
20 - 30 minutes at 140°F (61°C) metal temperature



IR (Medium): **4:1:2 Primer Surfacer**
10 - 15 minutes



Topcoat: **Air Dry**
4:1:2 Primer Surfacer
1-2 hours to sand and topcoat
3:1:1:1 Wet on Wet Sealer
15 minutes to topcoat
Force Dry
4:1:2 Primer Surfacer
After cool down

Clean Up

Clean spray guns, gun cups, storage pots, etc., thoroughly with JR reducers, JT571 0.21 VOC General Purpose Solvent or another appropriate clean up solvent after each use. Follow EPA guidelines for proper storage and disposal of solvent-borne waste paint.

Properties

Film Build Per Coat

Applied 3:1:1:1 1.2 - 1.5 mils.

Applied 4:1:2 1.5 - 2 mils.

Square foot coverage at 1 mil

Applied 3:1:1:1 602 sq. ft. / gal. at 100% transfer

Applied 4:1:2 592 sq. ft. / gal. at 100% transfer

PRIMER - PRIMER SEALER	Standard System	Flexible System	Standard System	Flexible System
RTS Combinations	JP35x : JH358 : JR55x	JP35x : JH358 : JR55x + 10% SLV814	JP35x : JC780/ JC7200/JC830/ JC7100/JC815 : JH358 : JR55x	JP35x : JC780/ JC7200/JC830/ JC7100/JC815 : JH358 : JR55x + 10% SLV814
Volume Ratio:	4 : 1 : 2	4 : 1 : 2 +10%	3 : 1 : 1 : 1	3 : 1 : 1 : 1 +10%
Applicable Use Category	Primer	Primer	Primer - Sealer	Primer - Sealer
VOC Actual (g/L)	120	113	118 - 142	112 - 133
VOC Actual (lbs/gal)	1.00	0.94	1.00 - 1.19	0.93 - 1.11
VOC Regulatory (less water less exempt) (g/L)	232 - 246	225 - 237	239 - 250	221 - 237
VOC Regulatory (less water less exempt) (lbs/gal)	1.94 - 2.05	1.88 - 1.98	1.91 - 2.09	1.85 - 2.03
Density (g/L)	1414 - 1511	1406 - 1485	1369 - 1452	1357 - 1433
Density (lbs/gal)	11.88 - 12.61	11.73 - 12.39	11.42 - 12.12	11.32 - 11.96
Volatiles wt. %	51.4 - 53.9	53.1 - 55.5	47.0 - 52.8	49.2 - 54.5
Solids wt. %	46.1 - 48.6	44.5 - 46.9	47.2 - 53.0	45.5 - 50.8
Water wt. %	0.0 - 0.1	0.0 - 0.1	0.0	0.0
Exempt wt. %	43.5 - 45.4	45.5 - 47.7	37.1 - 43.6	39.8 - 45.7
Water vol. %	0.0 - 0.1	0.0 - 0.1	0.0	0.0
Exempt vol. %	49.0 - 51.1	50.3 - 52.3	43.0 - 48.4	44.9 - 49.8

Limitations

Shop-Line products should not be combined with components of other product lines.

Precautionary Information:

The contents of this package may have to be blended with other components before the product can be used. Before opening the packages be sure you understand the warning messages on the labels of all components since the mixture will have the hazards of all of its parts. Spray equipment must be handled with due care and in accordance with manufacturer's recommendations. Follow label directions for respirator use. Wear eye and skin protection. Observe all applicable precautions.

EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION (412) 434-4515; IN CANADA (514)-645-1320

See Safety Data Sheet and Labels for additional safety information and handling instructions.

Data Safety Sheets for the PPG products mentioned in this publication are available through your PPG *Shop-Line* brand distributor. To the best of our knowledge, the technical information in this bulletin is accurate; however, since PPG Industries is constantly improving its coating and paint formulas, the current technical data may vary somewhat from what was available when this bulletin was printed. Contact your *Shop-Line* brand distributor or visit www.ppgrefinish.com for the most up-to-date information.

