

TECHNICAL DATA SHEET

FP410 – 2K HS Primer



DESCRIPTION

FP410 is a premium two-component primer surfacer designed for high build and excellent filling of repairs. It provides excellent adhesion and gloss / color holdout. FP410 sands easily without clogging the sandpaper, while providing excellent resistance to sand scratch swelling.

PHYSICAL DATA

- VOC Sprayable: 4.38 lbs/gal
- Pot Life: @ 70°F = 1 hour
@ 80°F = 45 min.
@ 90°F = 30 min.

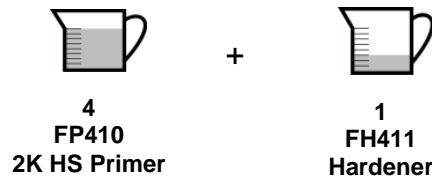
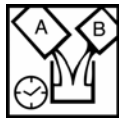


SUBSTRATES

- Properly Treated Steel*
- Treated Aluminum
- Fiberglass / SMC
- OEM Finishes
- Refinish Lacquers, Enamels, and Urethanes
- Etching Primers

*Steel must be treated with an Etching Primer or Metal Etch.

MIXING

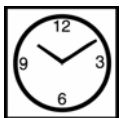


APPLICATION



- Adjust air pressure to: 30-40 psi for siphon feed gun
20-30 psi for gravity feed gun
30-40 psi for pressure feed gun with 5-10 psi pot pressure
5-7 psi at the cap for HVLP gun
- Apply 2 – 3 medium coats, at a gun distance of 5” – 7” inches, with 5 – 10 minutes flash time between coats.
- Recommended dry film thickness after sanding is 2.0 – 2.5 mils.
- Maximum dry film thickness is 6 mils after sanding.
- Clean spray gun with an appropriate gun cleaner, immediately after use.

DRYING



Air Dry: 1.5 – 3 hours @ 70°F
Force Dry: 30 minutes @ 140°F
Short Wave Infrared: 15 minutes on high setting, @ 24” inches distance.
Note: Purge for 10 minutes before using short wave infrared.

To sand: 2 hours for air dry, and upon cool down for force dry and short wave infrared.

Note: Excessive film builds and cooler temperatures will extend dry times.

Final Sanding
To seal
To topcoat

Sandpaper Grit
P400*
P600*
*or equivalent