

**2.1 VOC 2K Primer
A-510 (Gray)**

Technical Support: 1-800-776-0933

Product Description A-510™ (Gray) 2.1 VOC 2K Primer is a high quality, two-component, low VOC acrylic urethane primer that provide excellent build and color holdout. This primer is easy to sand and can be applied over a variety of substrates. Use A-510 as a primer surfacer in localities requiring the use of low VOC primers.

Components



Primers A-510 (Gray)
Activators PCA-451™ (Fast),
 PCA-452™ (Medium), PCA-453™ (Slow)

Typical Substrates

- **OEM primer, GRP/fiberglass, polyester putties:** direct application if properly prepared
- **Existing finishes:** in good condition
- **Bare steel, aluminum, galvanized metals:** after priming with an Etch Primer
- **Thermoplastic acrylic, old lacquer finishes:** primer must be applied to the complete panel

Surface Preparation



Clean and dry the surface. Sand surface with P180–P320 grit abrasive. Remove all sanding debris with ICR-0020™. Wipe dry with a clean cloth and allow surface to dry thoroughly.

Mix Ratio

Refer to "Activator & Thinner Selection Guide-VOC COMPLIANT".

Primer 4 Parts
Activator 1 Part



Pot Life @ 72°F / 22.2°C



1 hour

Viscosity @ 72°F / 22.2°C

26–28 secs BSB4
 22–24 secs DIN4

Gun Set Up



High Efficiency 1.6 mm–1.8 mm
HVLP 1.6 mm–1.8 mm

Air Pressure



High Efficiency 15–29 psi @ the gun
HVLP 6–10 psi max @ the cap

Application



- 2–3 single coats
- 5–10 minutes flash between coats

NOTE: Refer to individual gun manufacturer for proper spray gun setting.

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Dry Times to Sand @ 72°F / 22.2°C



Flash	5–10 minutes before baking
Air Dry	1½–3 hours
Baking	20–30 minutes @ metal temperature of 140°F/60°C
Short Wave	Refer to infrared manufacturer's guide for set-up guidelines

Sanding



Dry & D.A.:	P400 P600
Water Sanding:	P500–P600

Recoat

Topcoat within 24 hours after sanding. If time exceeds 24 hours, the primed surface must be sanded and cleaned again prior to application of primer or topcoat.

Topcoats

When dry, topcoat with:

- Prospray 2K Sealers
- Prospray Single Stage
- Prospray Basecoat/Clearcoat

Special Notes / Clean Up



Clean Up Clean equipment after use with a cleaning solvent. Dispose of solvent according to state, local and federal regulations.

Physical Data

VOC (RTS) per U.S. Gallon	2.1 lbs/gal, 251 g/l
Recommended Dry Film Thickness	2.0–3.0 mils

Health and Safety



For professional use only. KEEP OUT OF REACH OF CHILDREN. WARNING! CONTENTS ARE FLAMMABLE. VAPOR AND SPRAY MIST IS HARMFUL. SKIN AND EYE IRRITANT.

Do not handle the Prospray products until the Safety Data Sheets have been read and understood in their entirety. Ensure that all employees are trained on using the Safety Data Sheets and all chemicals with which they come into contact. The manufacturer recommends the use of an air-supplied respirator when exposed to vapors or spray mist. Wear protective clothing, gloves and eye safety with a side shield.

This data sheet information is given in good faith but without warranty. The information contained herein represents the current state of our knowledge and is intended as a guide to our products and their uses; it is not intended for insurance of certain product properties or of their specific applications.

Follow all warnings on product labels.