

**Low VOC Etch Primer
A-614**

Technical Support: 1-800-776-0933

Product Description A-614™ Low VOC Etch Primer is a high quality etch primer that provides excellent adhesion and corrosion resistance to a variety of substrates. A-614 features an easy to use 1:1:1 mix ratio.

Components



Primers **A-614**
Activators **A-616**
Thinner **PCR-1772**

Typical Substrates

- Bare steel
- Aluminum
- Automotive grade galvanized metals

Surface Preparation



Clean and dry the surface. Sand surface with P120–P180 grit abrasive. Remove all sanding debris with ICR-0020™, ICR-0014™, ICR-1402™, or ICR-0010™ Aerosol. Wipe completely dry using a clean, lint free cloth.

NOTE: Some areas are restricted to ICR-0010-12 only.
In Canada, the use of a pump sprayer may be permitted.

Mix Ratio

Primer **1 Part**
Activator **1 Part**
Thinner **1 Part**

Pot Life @ 72°F / 22.2°C



24 hours
NOTE: Freshly mixed material will provide best corrosion

Viscosity @ 72°F / 22.2°C

18 – 21 secs DIN4

Gun Set Up



High Efficiency	HVLP
1.2 mm–1.4 mm	1.2 mm–1.4 mm

Air Pressure



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

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

Application



2 medium coats
5–10 minutes flash between coats

Dry Times to Prime or Seal @ 72°F / 22.2°C



Flash	5–10 minutes between coats
Air Dry	30 minutes
Baking	N/A
Short Wave	N/A

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Sanding



Dry & D.A.: N/A

Water Sanding: N/A

Recoat

If etch primer has dried over 24 hours, scuff the surface with a scuff pad or P320 grit sand paper and apply another coat.

Topcoats

When dry, topcoat with:

- Prospray 2K Primers
- Prospray 2K Sealers

NOTE: DO NOT topcoat directly with Prospray Single Stage or Basecoat.
DO NOT apply Epoxy Primer or DTM Primer over A-614 Low VOC Etch Primer.

Special Notes / Clean Up



Do not topcoat directly over A-614 Low VOC Etch Primer.

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

Physical Data

VOC (RTS) per U.S. Gal	5.5 lbs Max.
Recommended Dry Film Thickness:	0.5 mil–1 mil
Total Solids by Weight (RTS)	14.04%

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.