

2.1 VOC Epoxy Primer A-618 (Grey) & A-619 (Black)

Technical Support: 1-800-776-0933

Product Description Pro-Spray A-618™ Grey and A-619™ Black 2.1 VOC Epoxy Primers provide excellent adhesion and corrosion resistance to properly prepared metal, fiberglass and aluminum substrates as well as plastic body fillers. 2.1 VOC Epoxy Primers feature an easy-to-use 1:1 mixing ratio and may be topcoated with Pro-Spray 2K Primer Sealer, Pro-Spray Single Stage, Pro-Spray Solvent Basecoat/Clearcoat and Pro-Spray H2O Basecoat/Clearcoat systems.

Components



Primers **A-618 (Grey)**
 A-619 (Black)
Activators **A-620**

Typical Substrates

- Bare steel
- SMC
- Galvanized metals
- Fiberglass
- Body Fillers
- ABS
- Polycarbonate
- Cured and sanded OE finishes
- Aluminum

Surface Preparation



Clean and dry the surface. Sand surface with P120 – P180 grit abrasive. Remove all sanding debris with ICR-0020™ Waterborne Surface Cleaner. Wipe completely dry with a clean lint free cloth.

Mix Ratio

Primer 1 Part
Activator 1 Part

Pot Life @ 72°F / 22.2°C



12 hours

Viscosity @ 72°F / 22.2°C

26–28 secs Zahn #2

NOTE: Activated material must stand 20 minutes prior to application.

Grey Shade Mixing Ratio

Final Grey Shade color must be activated according to the Mix Ratio above.

Code	Description	Grey Shade					
		GS-1	GS-2	GS-3	GS-4	GS-5	GS-6
		Ratio	Ratio	Ratio	Ratio	Ratio	Ratio
A-618	Grey Epoxy	1 Part	4 Parts	3 Parts	2 Parts	1 Part	0 Parts
A-619	Black Epoxy	0 Part	1 Part	1 Part	1 Part	1 Part	1 Part

Gun Set Up



High Efficiency **HVLP**
1.4 mm–1.6 mm 1.4 mm–1.6 mm

Air Pressure



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

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

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Application



2–3 single coats (approx. 1.0–1.5 mil.)
Allow 10–20 minutes flash time between coats

NOTE: DO NOT apply A-618 or A-619 over A-614™ Low VOC Etch Primer

Dry Times to Topcoat @ 72°F / 22.2°C



Flash	10–20 minutes between coats
Air Dry	1–2 hours
Baking	30 minutes @ metal temperature of 140°F/60°C. Allow to dry completely
Short Wave	10 minutes. Allow to cool completely

Refer to the infrared manufacturer's guide for set-up regulations.

Sanding (if to dry more than 24 hours)



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

Recoat

Top coat within 48 hrs. If time exceeds 48 hours the primer must be sanded and cleaned prior to application of additional primer or top coat.

Topcoats

When dry, topcoat with:

- Pro-Spray 2K Urethane Primers
- Pro-Spray Solvent Basecoat/Clearcoat
- Pro-Spray 2K Sealers
- Pro-Spray Single Stage
- Pro-Spray H2O Basecoat/Clearcoat

Special Notes / Clean Up



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

Physical Data

VOC (RTS) per U.S. Gal	2.1 lbs
Recommended Dry Film Thickness:	minimum 2 mils
Total Solids by Weight (RTS)	45.28%

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 Pro-Spray products until the Material Safety Data Sheets have been read and understood in their entirety. Ensure that all employees are trained on Material 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.