

## 2.8 VOC Single Stage

Technical Support: 1.800.526.6704

**Product Description** Prospray® 2.8 VOC Single Stage colors utilize the current Prospray Intermix System, a low VOC binder combined with Low VOC activators, and an exempt thinner, to provide a full range of compliant solid and metallic colors.

### Components



**Mixed 2.8 VOC Single Stage Color**  
**Activators** PCA-451™ (Fast), PCA-452™ (Medium) or PCA-453™ (Slow)  
**Thinners** PCR 1463™ and PCR 1464™

### Typical Substrates

- Prospray 2.1 VOC 2K sealers
- Prospray 2.1 VOC 2K primers
- Properly prepared OE finishes
- 2.1 VOC DTM primers
- 2.1 VOC Epoxy primers

### Surface Preparation



Finish sand with P400 – P600. Clean area with pre-paint cleaner, wipe dry thoroughly. Use of Prospray 2K sealer is recommended.

### Mix Ratio

<b>Color</b>		<b>2 Parts</b>
<b>Activator</b>		<b>1 Part</b>
<b>Thinner</b>		<b>15%</b>

### Pot Life @ 72°F / 22.2°C

 2 hours

### Viscosity @ 72°F / 22.2°C

15–17 secs DIN4

### Gun Set Up



<b>High efficiency</b>	<b>HVLP</b>
1.2 mm–1.4 mm	1.2 mm–1.4 mm

### Air Pressure



<b>High efficiency</b>	<b>HVLP</b>
15–29 psi @ the gun	6–10 psi max @ the cap

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

### Application



- 2–3 medium wet coats.
- 10–20 minutes flash between coats.
- Use of drop coats on metallics is acceptable.

### Dry Times @ 72°F / 22.2°C



<b>Flash</b>	10–20 minutes between coats
<b>Air Dry</b>	Overnight
<b>Baking</b>	20 minutes @ 140°F/60°C
<b>Short Wave</b>	Refer to infrared manufacturer's guide for set-up regulations

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### Polishing / Buffing



Buffing is normally not required since single stage colors have a high gloss finish. However, on solid colors only, you may sand with 1500 grit or finer and polish as needed after the finish has fully cured (6 hours—overnight).

### Special Notes / Clean Up



**Note** Use slow activator for best results.

**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 2.8 lbs (maximum)  
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.