

High solids. Can be used as a very high build or medium build primer and as a non-sanding primer sealer. Provides exceptional fill and build characteristics providing a base that yields excellent topcoat holdout, gloss and D.O.I. Can be directly top coated with alkyd and acrylic enamels, lacquers, acrylic urethane enamels and waterborne basecoat clearcoat systems.

PRODUCT	SIZE	COLOR	ACTIVATOR
PF 650C	3.78 L (U.S. Gallon)	Buff	PF 651C 946 ml (U.S. Quart)
PF 656C	3.78 L (U.S. Gallon)	Gray	PF 651C 946 ml (U.S. Quart)
PF 658C	946 ml (U.S. Quart)	Gray	PF 659C 236 ml (0.5 U.S. Pint)

**READ ALL INSTRUCTIONS AND SAFETY PROCEDURES PRIOR TO USING!**

**IMPORTANT! This product contains hazardous materials.**

Proper protective equipment should be used at all times. Please consult labels on each product as well as the safety data sheet for complete safe handling procedures and personal protection information.

**NOTE: TEST ON A HIDDEN AREA BEFORE USING TO MAKE SURE THE PRODUCT PERFORMS TO YOUR SATISFACTION.**

**FEATURES:**

- Canada Compliant 2.1 VOC
- Excellent fill and build properties
- Superior hold-out
- Easy sanding

**COMPATIBLE SUBSTRATES:**

- Properly cleaned, sanded and treated steel, aluminum or fiberglass, and treated plastics
- Cured and sanded OEM finishes
- Cured and sanded body filler

**SURFACE PREPARATION:**

All substrates must be degreased and sanded. All rust must be removed.

1. Wash surface with soap and water.
2. Clean metal surfaces with PF 605 Wax & Grease Remover (Strong). Clean plastic surfaces with PF 606 / PF 525 Plastic Parts Cleaner. Wipe dry while the surface is still wet.
3. Completely sand surface with 180-220 grit paper.
4. Re-clean with PF 603 Wax & Grease Remover (Mild).
5. For maximum adhesion and corrosion resistance, treat bare metal with PF 652C or PF 654 Self Etching Primer.

**MIXING DIRECTIONS:**

**HIGH BUILD RATIO 4:1**

4 parts of Primer  
1 part of Activator

**MEDIUM BUILD RATIO 4:1:1**

4 parts of Primer  
1 part of Activator  
1 part of Reducer (PF 682C Slow, PF 683C Medium or PF 684C Fast)

Mix thoroughly between components. Stir regularly after catalyzed. Strain before spraying material.

**DIRECTIONS FOR USE:**

All drying times refer to shop temperature of 25°C (77°F) / 50% humidity. Allow additional drying time when optimal conditions are not reached.

**SPRAY GUN AND PRESSURE:**

<i>Gun Type</i>	<i>Fluid Tip</i>	<i>Air Pressure</i>
Siphon Feed	1.6–2.0 mm	40–50 psi
Gravity Feed	1.6–1.8 mm	35–45 psi
HVLP	1.6–1.8 mm	10 psi

Apply two to three coats. Allow 15 minutes flash time between coats. Film thickness, flash times, and temperatures will effect drying time. Maximum film thickness of this product when dried should not exceed 5 mils.

<b>REDUCERS:</b>	PF 682C Slow, PF 683C Medium or PF 684C Fast		
<b>DRYING TIMES @ 24°C (75°F):</b>	Flash: 15 minutes	Sanding: 4–6 hours	For optimal results, a final sanding with 600 grit or finer paper is recommended.
<b>FORCE DRYING @ 60°C (140°F):</b>	Purge Time: 15 minutes		Bake Time at 60°C (140°F): 20 minutes
<b>REPAIRING &amp; RECOATING:</b>	May be recoated after 30 minutes or upon cool down after force drying at @ 60°C (140°F) for 20 minutes. After 8 hours dry time, primer must be lightly sanded before topcoating.		
<b>ACCELERATOR:</b>	Do not use accelerator.		
<b>FISH EYE:</b>	Do not use Fish Eye Eliminator		
<b>POT LIFE:</b>	1–1½ hours (IMPORTANT NOTE: Some mixing bases may shorten the pot life.)		
<b>CLEANING INSTRUCTIONS:</b>	Clean equipment with lacquer thinner immediately after use.		

**Caution:** It is important to test the compatibility of this product with your paint system. This product is not recommended for use in temperatures below 16°C (60°F). The use below these temperatures will affect dry times and performance.

**TECHNICAL DATA:**

	<b>PF 656C, PF 658C</b>	<b>PF 650C</b>	<b>PF 651C, PF 659C</b>
<b>Physical State</b>	Liquid	Liquid	Liquid
<b>Color:</b>	Gray	Yellow-brown	Clear to pale yellow
<b>Odour:</b>	Hydrocarbon odour	Solvent odour	Camphor-like
<b>Solubility :</b>	Negligible	Not available	Reacts slowly with water to liberate CO2 gas
<b>Flash point:</b>	4°C (39.2°F)		
<b>Auto ignition temperature:</b>	>200°C (392°F)	>300°C (572°F)	438°C (820.4°F)
<b>VOC (RTS)</b>	2.064 lbs/usg • 247.32 g/L	2.02 lbs/usg • 242.05 g/L	- lbs/usg • -g/L

**PRECAUTIONARY INFORMATION**

Refer to product label and Safety Data Sheet for health and safety information before using this product.

**SAFETY CONSIDERATION**

Safety Data Sheets are available at [www.proformproducts.com](http://www.proformproducts.com) or upon request at [info@proformproducts.com](mailto:info@proformproducts.com). These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

**TECHNICAL INFORMATION**

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

**PRODUCT USE**

Many factors beyond Pro Form’s control and uniquely within user’s knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user’s method of application.

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