

1K Waterborne Primer - Direct to Metal and Plastics PF 485, PF 485-1, PF 485-5

1K Waterborne Primer is a direct to metal primer and for refinishing both thermoset and thermoplastic substrates or metal. The high build and fill properties provide excellent adhesion and topcoat holdout. Sands easily in 1-2 hours without featheredge tearing. Can be topcoated with most basecoat/clearcoat products within 4 hours.

PRODUCT	SIZE
PF 485	946 ml (U.S. Quart)
PF 485-1	3.78 L (U.S. Gallon)
PF 485-5	18.9 L (5 U.S. Gallons)

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.

SUITABLE SUBSTRATES:

- Thermoset and thermoplastic
- Metal

COMPATIBLE PREPARED SUBSTRATES:

Can be applied on properly cleaned metal surfaces on plastic body parts on the vehicle exterior such as body panels, bumpers, grills, and spoilers, or properly cleaned, sanded and treated steel.

NOTE: For TPO Plastic, the use of an adhesion promoter is necessary. To determine if TPO plastic, use a die grinder on the back side of the part and lightly grind. If it is of the TPO family, it will melt or smear. Otherwise, it will powder. If it powders, the substrate is not TPO. IF it is not TPO, DO NOT use adhesion promoter.

SURFACE PREPARATION:

1. Wash area thoroughly with soap and water to remove contaminants that solvent based cleaners cannot remove effectively.
2. Clean metal with PF 605 Wax & Grease Remover (Strong). Clean plastic surfaces with PF 606 Plastic Parts Cleaner. Wipe dry while the surface is still wet.
3. For TPO Plastics, apply a thin even coat of PF 608 TPO Adhesion Promoter to surface to be primed.
4. Allow 10 minutes flash time, but not more than 15 minutes before you proceed with the primer. If TPO Adhesion Promoter dries more than 15 minutes, the TPO plastic must be sanded before re-applying TPO Adhesion Promoter. For best results, do not apply more than one coat of adhesion promoter.

MIXING DIRECTIONS:

Stir thoroughly before using. If required, can be reduced with up to 10% distilled water.

APPLICATION:

NOTE: Product may settle a little depending on how long it has been sitting. Make sure to shake the can for 5 minutes prior to use. Apply 1-3 medium wet coats. Allow 10 minutes flash time @ 75°F (24°C) between each coat.

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SPRAY GUN AND PRESSURE:

<i>Gun Type</i>	<i>Fluid Tip</i>	<i>Air Pressure</i>
Siphon Feed	1.6-1.8 mm	40-55 psi
Gravity Feed	1.6-1.8 mm	40-55 psi
HVLP	1.6-1.8 mm	10 psi

ADDITIVES:

Do not use accelerator or fish eye eliminator.

DRY & FLASH TIME:

Dry times at 75°F (24°C) and 50% relative humidity.

Flash Time	10 - 15 minutes
To Sand	1 - 1½ hours
To Topcoat	1½ - 2 hours

FORCE DRYING:

Force dry 40 minutes @ 140°F or 5-10 minutes under infrared lights before sanding.

REPAIRING & RECOATING:

Primer must be sanded prior to recoating after 24 hours drying @ 75°F (24°C).

CLEAN UP:

Cleanup can be done with water immediately after use. If dry, MEK or Acetone can be used.

TECHNICAL DATA:

	PF 485, PF 485-1, PF 485-5
Physical State	Liquid
Color:	Black
Odour:	Characteristic odour
Solubility :	No data
Flash point:	75°C (167°F) For: Dipropylene Glycol Monomethyl Ether
Auto ignition temperature:	Not available
VOC:	0.4 lb/usg • 47.9 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 or upon request at info@proformproducts.com. These



Product Data Sheet

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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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