

Direct to Metal 2K Urethane High Build Primer

PF 490, PF 493, PF 494, PF 492,
PF 490-1, PF 493-1, PF 494-1, PF 491

A direct to metal, high build premium quality, two component acrylic urethane primer. Performs with most solvent and water based basecoat/clearcoat systems or urethane topcoats.

PRODUCT	SIZE	COLOR	ACTIVATOR
PF 490	946 ml (U.S. Quart)	Gray	PF 492 236 ml (0.5 Pint)
PF 493	946 ml (U.S. Quart)	Black	PF 492 236 ml (0.5 Pint)
PF 494	946 ml (U.S. Quart)	White	PF 492 236 ml (0.5 Pint)
PF 490-1	3.78L (U.S. Gallon)	Gray	PF 491 946 ml (U.S. Quart)
PF 493-1	3.78L (U.S. Gallon)	Black	PF 491 946 ml (U.S. Quart)
PF 494-1	3.78L (U.S. Gallon)	White	PF 491 946 ml (U.S. Quart)

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

- Direct to metal surfaces
- Cleaned, sanded existing finishes

ADVANTAGES

- Excellent filling
- Easy sanding

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 Plastic Parts Cleaner. For plastic, metal and pre-painted parts, PF 692 Waterborne Degreaser can also be used. 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. Apply primer immediately after cleaning.

MIXING DIRECTIONS:



High Build (4:1)

4 parts of Primer : 1 Part of Activator



Medium Build (4:1:1)

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

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

Direct to Metal 2K Urethane High Build Primer

PF 490, PF 493, PF 494, PF 492,
PF 490-1, PF 493-1, PF 494-1, PF 491

REDUCERS:

NOTE: Reducer selections is based on booth / spray conditions.

PF 684C	(Fast)	20°C (70°F)
PF 683C	(Medium)	20°C - 27°C (70°F - 80°F)
PF 682C	(Slow)	29°C - 32°C (85°F - 90°F)

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 affect drying time. Maximum film thickness of this product should not exceed 25 mils wet.

DRYING TIMES:

All drying times refer to shop temperature at 20°C (68°F) / 50% humidity. Higher or lower temperatures will affect dry times.

Flash:	15 minutes
Sanding:	1 1/2 to 2 hours

For optimal results, a final sanding with 600 grit or finer paper is recommended.

Force Drying:	Purge Time: 15 minutes	Bake time @ 60°C (140°F): 20 minutes
Recoating:	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 with 600 grit paper before top coating.	
Fish Eye:	Do not use Fish Eye eliminator in this product.	
Pot Life:	1-1½ hours. Important Note: Some mixing bases may shorten the pot life.	
Cleaning Instructions:	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:

	PF 490, PF 490-1	PF 493, PF 493-1	PF 494, PF 494-1
Physical State	Liquid		
Color:	Gray	Black	White
Odour:	Solvent odour	Hydrocarbon odour	Hydrocarbon odour
Solubility :	Negligible	Negligible	Negligible
Flash point:	4°C (39°F) (estimate; low-est flash point ingredient)	9°C (48°F) (estimate; low-est flash point ingredient)	4°C (39°F) (estimate; low-est flash point ingredient)

Direct to Metal 2K Urethane High Build Primer

PF 490, PF 493, PF 494, PF 492,
PF 490-1, PF 493-1, PF 494-1, PF 491

Auto ignition temperature:	>200°C (>392°F)	Not available	>200°C (>392°F)
VOC:	2.58 lbs/usg • 309.2 g/L	2.46 lbs/usg • 294.78 g/L	2.57 lbs/usg • 308. g/L
VOC (R.T.S)	2.064 lb/usg - 247.32 g/L	1.96 lbs/usg • 234.86 g/L	1.99 lbs/usg • 238.46 g/L

PF 491, PF 492 (Activator)	
Physical State	Liquid
Color:	Clear to pale yellow
Odour:	Camphor-like
Solubility :	Reacts slowly with water to liberate CO ₂ gas
Flash point:	4°C (39°F) (estimate; lowest flash point ingredient)
Auto ignition temperature:	438°C (820.4°F)
VOC:	0 lbs/usg • 0 g/L

	PF 490, PF 490-1	PF 493, PF 493-1	PF 494, PF 494-1
Mixed Viscosity:	20-30 "Zahn#2	20-30 "Zahn#2	20-30 "Zahn#2
Volume Solids (Mixed):	41.47 %	44.48 %	43.09 %
Weight Solids (Mixed):	57.55 %	58.81 %	60.04 %
Coverage @ sq.ft/gallon:	665	713.46	691.16

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 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.

WARRANTY, LIMITED REMEDY, DISCLAIMER AND LIMITATION OF LIABILITY

Pro Form Products Ltd. ("Pro Form") makes no warranty, either express or implied, and specifically excludes any implied warranties or conditions of quality, whether of merchantability, fitness or otherwise. On any claim, irrespective of the legal theory invoked, Pro Form's total liability shall not exceed the purchase price of the product. At its option, Pro Form may instead replace or repair the product. In no event shall Pro Form be liable for any damages of any type, or for loss. 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.