

A high build two component polyester primer with good filling characteristics. Primer can be tinted up to 10% by volume with most polyester basecoat tints. Superior adhesion to properly prepared substrates such as steel, galvanized steel, aluminium, fibreglass, and body fillers. Liquid hardener included.

| PRODUCT | SIZE | COLOR | HARDENER |
|-----------------|-----------------------|--------------|---------------------|
| PF 627 | 946 ml (U.S. Quart) | Gray | 1 oz |
| PF 627-1 | 3.78 L (U.S. Gallons) | Gray | PF 147 (2X 2 fl oz) |
| PF 628 | 946 ml (U.S. Quart) | Buff | 1 oz |
| PF 628-1 | 3.78 L (U.S. Gallons) | Buff | PF 147 (2X 2 fl oz) |
| PF 629 | 946 ml (U.S. Quart) | Black | 1 oz |
| PF 629-1 | 3.78 L (U.S. Gallons) | Black | PF 147 (2X 2 fl oz) |

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:

- Steel
- Galvanized steel
- Aluminium
- Fibreglass
- Body fillers

ADVANTAGES:

- High build
- No shrinkage
- Easy sanding

SURFACE PREPARATION:

1. Wash surface with soap and water.
2. Clean metal surfaces with PF 605 Wax and Grease Remover (Strong).
3. Sanding: Body Filler & Putty: Rough sand with 80 grit then 180-220 grit and then featheredge with 320 grit. Untreated steel, galvanized steel and bare aluminium: Sand with 180-220 grit. Pre-painted surfaces: Sand and featheredge using 80, 180, 280 and finish with 320 grit paper on orbital sander.
4. Completely final sand surface with 320-400 grit paper and re-clean with PF 603 Wax & Grease Remover - Mild.

MIXING DIRECTIONS:

2% by weight. Mixing Ratio: 100:2

100 parts of Primer : 2 parts of liquid hardener. Mix thoroughly.

Caution: Do not return catalyzed material to can. To avoid contamination, keep cap closed after use.

SPRAY GUN AND PRESSURE:

| <i>Gun Type</i> | <i>Fluid Tip</i> | <i>Air Pressure</i> |
|-----------------|------------------|---------------------|
| Primer Gun | 1.8 - 4.0 mm | 35-40 psi |

Apply two or three medium wet coats as needed. Allow to flash 5-10 minutes between coats. Heavy wet coats should not be applied. Dry spray must be removed before recoating. Allow to dry approximately 1 hour before sanding at 24°C (75°F). Finish sand with 220 grit paper followed by 320-400 grit (wet or dry).

| DRY TIMES @24°C (75°F): | |
|--------------------------------|--|
| FLASH | 5-10 minutes |
| TO SAND | 1 hour 30 minutes, 4-6 hours over etch primer |
| TO TOPCOAT | 1 hour 30 minutes, 4-6 hours over etch primer |
| FORCE DRYING: | |
| PURGE TIME | 10 minutes |
| BAKE TIME | 30 minutes @ 60°C (140°F) |
| POT LIFE | 20-25 minutes @ 24°C (75°F). If needed add 5-10% PF 602 Acetone to extend 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 627, PF 627-1 | PF 628, PF 628-1 | PF 629, PF 629-1 |
|-----------------------------------|---------------------------|---------------------------|---------------------------|
| Physical State | Paste | Thick liquid, paste | Thick liquid, paste |
| Color: | Gray | Buff | Black |
| Odour: | Hydrocarbon odour | Characteristic odour | Characteristic odour |
| Solubility : | Negligible | Negligible | Negligible |
| Flash point: | -4°C (24.8°F) | -4°C (24.8°F) | -4°C (24.8°F) |
| Auto ignition temperature: | >200°C (>392°F) | >190°C (>374°F) | >190°C (>374°F) |
| VOC: | 1.7 lb/uscg • 203.704 g/L | 1.69 lbs/uscg • 202.5 g/L | 1.69 lbs/uscg • 202.5 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

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.