



GENERAL INFORMATION

SP1600 Sprayable Polyester Primer, low VOC, high build polyester primer surfacer, which is compatible with and provides excellent adhesion to fiberglass and primed surfaces such as aluminum and steel. SP1600's high build formulation dries quickly to touch and has exceptional sanding and filling characteristics.



1. COMPONENTS

- SP1600 Sprayable Polyester Primer
- MEKP Liquid Hardener



2. MIXING RATIO

For 2.1 lb/gal (250 g/L) Low VOC Compliance

- Mix one (1) quart SP1600 to (1/2) half ounce MEKP Liquid Hardener.

NOTE: Combine components by volume. Mix thoroughly and strain before using.



3. POT LIFE

30 - 40 minutes at 75°F / 50% RH

Note: Pot life shortens at temperatures above 75°F.



4. SURFACE PREPARATION

1. Clean surface of all contaminants with Wax & Grease Remover. Wipe dry with a clean cloth.

2. Grind repair area. Sand and featheredge with 180 to 320 grit abrasive.

3. Remove sanding debris by blowing off repair area and cleaning with Wax & Grease Remover. Wipe dry with a clean cloth. Do not topcoat unless surface is completely dry.

Note: Do not apply over uncured substrates or uncatalyzed enamel paint films

5. APPLICATION

- Apply 2 - 3 medium wet coats.
- Do not use at temperatures below 55°F

6. AIR PRESSURE:

Reduced Pressure: 20 - 35 psi at the gun

HVLP: 10 - 20 psi at the gun



7. GUN SET UP:

Reduced Pressure: 1.7mm - 2.2mm

HVLP: 1.7mm - 2.2mm

8. SPRAY GUN CLEAN UP

- Clean spraygun thoroughly with lacquer thinner after use of SP1600.



9. FLASH / DRY TIMES

AIR DRY @ 75°F (25°C)

Flash Between Coats	3 - 5 Minutes
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NOTE: SP1600 can be sanded in one hour depending on temp.

FORCE DRY @ 130-140°F (25°C)

Flash Between Coats	3 - 5 Minutes
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NOTE: SP1600 must be sanded within 4 hours after application to avoid

10. TECHNICAL DATA

FOR USA (NATIONAL RULE & LOW VOC) / CANADA

RTS REGULATORY DATA	1 Quart : 0.5 ozs	
	No Reducer	
	LBS./GAL.	g/L
Actual VOC	2.0 Max.	243 Max
Regulatory VOC (less water and exempt solvents)	2.1 Max.	250 Max.
Density	13 - 15	1560 - 1800
	Weight %	Volume %
Total Solids Content	82 - 85	66 - 70
Total Volatile Content	15 - 18	30 - 34
Water	<0.1	<0.1
Exempt Compound Content	3 - 7	3 - 7
Coating Category	Primer	

NOTE: US/Canadian Regulations allow for the use of exempt compounds for VOC calculations.

FOR REST-OF-WORLD (outside US and Canada):

RTS REGULATORY DATA	1 Quart : 0.5 ozs	
	No Reducer	
	LBS./GAL.	g/L
VOC	2.3 Max.	280 Max
Density	13 - 15	1560 - 1800
	Weight %	Volume %
Total Solids Content	82 - 85	66 - 70
Total Volatile Content	15 - 18	30 - 34
Water	<0.1	<0.1
Coating Category	Primer	

NOTE: Rest-of-World considered areas outside US/Canada.