



Technical Data Sheet

12-24-KEY810/811 SELF-ETCHING PRIMER FILLER

PRODUCT DESCRIPTION:

KEY810/811 is a unique two-part self-etching, self-leveling bare metal primer filler. KEY810/811 is designed to give maximum adhesion and corrosion resistance on all type of bare metal. What makes this bare metal primer unique is that it fills as it primes. Can be used over steel, aluminum, and galvanized steel.

COMPONENTS:

KEY810 Primer Filler

KEY811 Self-Etching Primer Catalyst

MIXING INSTRUCTIONS:

1 part - KEY810 Primer

1 part - KEY811 Catalyst

SURFACE PREPARATION:

Rusted or corroded metal should be sand blasted and thoroughly cleaned. Remove all wax, grease, dirt, oil or other contaminants before applying primer. New metal or painted surfaces: pre-clean, sand and pre-clean again before applying primer.

APPLICATION:

1. Use 35-40 P.S.I. at gun.
2. Apply 2 medium wet coats (1.5 to 2.0 DFT)
3. Allow 30-60 minutes dry time before applying topcoat.
4. Can be sanded if necessary.
5. Use mixed material within 8 hours.

TOPCOATING

Can be topcoated with the following paint systems:

1. 2K Urethane Primer Surfacer
2. Lacquer Primer Surfacer
3. Epoxy Primer/Sealer
4. 2K Urethane Sealer
5. Acrylic Enamel
6. All Basecoat/Clearcoat Systems
7. All Urethane Single Stage Systems

PRECAUTIONS

1. At least 1.5 to 2.0 mils. (one full wet coat) dry film is necessary for proper adhesion and corrosion protection.
2. DO NOT apply over reversible substrates such as lacquer paint, lacquer primer, uncatalyzed enamels, uncured catalyzed enamels, or uncured urethanes.
3. If KEY810/811 is not recoated within 16 hours it should be scuff sanded with 320 grit or finer sandpaper.
4. Some translucent topcoats may require a sealer in order to achieve acceptable color hiding.

CLEANUP

Use good quality lacquer thinner (KEY5/10/15/20/25) or urethane reducer (KEY80/81/82/83) to thoroughly clean all equipment.

TECH DATA

Pot Life, Mixed:	8 Hours
Mix Ratio:	1:1
Induction Time:	10 Minutes
Film Thickness (DFT):	1.5 - 2.0 mils
Color:	Light Gray Green
Weight solids (RTS):	20.8%
Volume Solids (RTS):	9.0%
Coverage:	140 Sq. Ft.