



KEYSTONE AUTOMOTIVE INDUSTRIES
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Technical Data Sheet

12-24-KEY812 1K SELF-ETCHING PRIMER

PRODUCT DESCRIPTION:

KEY812 is a 1K self-etching metal primer. KEY812 is designed to give maximum adhesion and corrosion resistance on all type of bare metal. Can be used over steel, aluminum, and galvanized steel.

MIXING INSTRUCTIONS:

Ready to spray

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.

APPLICATION:

1. Use 35-40 P.S.I. at gun.
2. Apply 1-2 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.

TOPCOATING

Can be topcoated with the following paint systems:

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

PRECAUTIONS

1. Avoid application over reversible substrates such as lacquer paint or primer.
2. If KEY812 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:	8 Hours
Mix Ratio:	Ready to spray
Induction Time:	N/A
Film Thickness (DFT):	N/A
Color:	Light Gray Green
Weight solids (RTS):	
Volume Solids (RTS):	
Coverage:	