



Technical Data Sheet

12-24-KEY821 ACRYLIC PRIMER SURFACER GRAY

PRODUCT DESCRIPTION:

KEY821 Acrylic Primer Surfacer is a one-component high build primer made of the highest quality acrylic available. This primer dries fast and sands easily within 30 minutes of application. This primer provides excellent filling and adhesion as well as superior color holdout. KEY821 can be topcoated with lacquers, enamels, and polyurethanes after sealing. Designed to be used only with high quality virgin lacquer thinner at 1:1 mix ratio. Mixed properly with good lacquer thinner KEY821 resists settling.

FEATURES:

1. Very fast dry, sand within 30 minutes
2. Superior adhesion to: Cured finishes, Body fillers, Sanded fiberglass, Bare steel
3. Superior filling and sanding properties
4. Superior color holdout
5. Easy 1:1 mix ratio (use only virgin lacquer thinner)
6. Low cost
7. KEY821 Gray is tintable with 10% color

SURFACE PREPARATION:

1. Wash area to be primed with detergent (any non-silicon soap) and hot or cold water.
2. Clean area with KEY90 Wax-n-Grease Remover.
3. Apply primer as needed, after sanding primer clean with KEY90 Wax-n-Grease Remover.

MIXING INSTRUCTIONS:

1. Shake or stir KEY821 thoroughly before reducing (if shaking, allow to set 20-30 minutes before reducing and spraying).
 2. Reduce equal parts of KEY821 primer with virgin lacquer thinner (KEY SF10/20/25, to be V.O.C. compliant).
-Note: Thinners containing reclaimed solvents can adversely affect primer performance.

APPLICATION INSTRUCTIONS:

1. Use 35 P.S.I. air pressure at gun.
2. Apply 2 to 3 medium wet coats allowing ample flash time between coats.
3. Allow primer to dry 30 minutes before sanding depending on weather conditions.
4. Finish sand with 320 grit or finer sand paper.

CLEANING:

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

TECHNICAL DATA:

Coverage 1 mil:	381 sq. ft
Mix Ratio:	1:1
Sprayable Viscosity:	24 sec. #2 Zahn
Flash Point:	-21 F
Film Build (DFT):	1.5 mils per double coat
Dry to Sand:	30 minutes
Color Holdout:	Excellent
Fill Properties:	Excellent
Solids by Weight:	40%
Solids by Volume:	23.8%
V.O.C. (Sprayable) using Lacquer Thinner of 1.3 lbs. Per gallon and 1:1 mix ratio:	4.81 lbs. Per gallon
Unreduced V.O.C.:	4.3 lbs. Per gallon