



Technical Data Sheet

KEY823 WATERBORNE PRIMER/SEALER

PRODUCT DESCRIPTION:

KEY823 is a water based primer sealer designed for excellent adhesion to properly prepared plastics or steel surfaces. This product dries quickly and can be topcoated with various waterborne or solvent based products.

MIXING INSTRUCTIONS:

1. Ready to spray or can be reduced with 5-10% distilled water.

NOTE: STIR THOROUGHLY BEFORE EACH USE. IF USING ON A MIXING BANK, MIX FOR 2-5 MINUTES.

SURFACE PREPARATION:

1. Rusted or corroded metal should be sand blasted and thoroughly cleaned. Remove all wax, grease, dirt, oil or other contaminants before applying primer.
2. Plastic or painted surfaces: wash thoroughly with hot soapy water and dry thoroughly.
3. All surfaces: clean with KEY90 and dry with a lint free cloth.
4. All surfaces to be repaired: sand area with 80 grit and featheredge with 180 on broken film areas.
5. Finish all repair areas with 180 grit before applying primer.

APPLICATION:

1. Use 35-50 P.S.I. at gun.
2. Apply 1-2 medium wet coats allowing 10-20 minutes between coats.
3. Allow 1-2 hours before sanding.

NOTE: When using as an isolator allow to stand overnight.

4. When wet sanding, allow a minimum of thirty minutes after sanding before topcoating.

NOTE : *It is helpful to use a heat lamp and plenty of air movement to flash primer properly. Good air movement is always suggested for proper product performance.*

TOPCOATING

1. Can be topcoated with various waterborne or solvent based paint systems.

TECH DATA

Pot Life:	N/A
Mix Ratio:	Ready to spray
Film Build:	1-2 mils
Color:	Black
Sprayable V.O.C.:	0.5 lbs/gal
Weight/Gallon:	10.8
Flash Point:	N/A

NOTE: Primer should be applied at a minimum temperature of 70 F. Good air movement is necessary to properly flash the primer. To accelerate drying times, use infrared heat in conjunction with good air movement.