



# Technical Data Sheet

## PRIMEKOTE 1K HIGH BUILD PRIMER

### DESCRIPTION:

Primekote 1K High Build Primer is an acrylic primer surfacer formulated for use on rigid or flexible substrates with fast drying, high build, and easy to sand characteristics. For corrosion protection when applying over bare metal use Etchkote 1K Self Etching Primer prior to applying Primekote.

\*SHAKE PRIOR TO USING

### PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
Primekote 1K High Build Primer - White	3106	Aerosol
Primekote 1K High Build Primer – Med Grey	3126	Aerosol
Primekote 1K High Build Primer - Black	3136	Aerosol

### COMPATIBLE SUBSTRATES:

- \* Properly prepared OEM finishes
- \* Body fillers & putties
- \* Etchkote 1K Self Etching Primer
- \* Properly prepared SMC
- \* Properly prepared fiberglass

### SAFETY ASPECTS:



Users should review the Safety Data Sheet (SDS) and product label for the material to be used to determine possible health hazards, appropriate engineering controls and precautions to be observed in the use of the material. Copies of the SDS are available on the ordering portal. Click on the SDS button located under each product. You can also locate the SDS on the tech center website or call the technical department and request them.

### SURFACE PREP:

Clean area to be primed thoroughly of all dirt, grease, wax and oil using Autokote Aqua-kleen followed with Autokote Pre-kleen Wax & Grease Remover.

Sand area to be primed with #180 to #320 grit sandpaper.



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**DIRECTIONS:**



1. Clean area to sanded and primed with Autokote Aqua-Kleen followed with Autokote Pre-Kleen Wax & Grease Remover.
2. Sand are to be primed with 180 – 320 grit sandpaper.
3. Clean area to be primed with Autokote Final-Kleen Wax & Grease Remover.
4. Shake Primekote 1K High Build Primer well! Shake at least 2 minutes after mixing ball is heard.
5. Hold can 6-8 inches from surface. Apply 2-3 medium wet coats allowing complete flash off between coats. Multiple coats will produce better color holdout than a single heavy coat.
6. Invert can and purge after each use.
7. San with 320 grit or finer and topcoat

**NUMBER OF COATS:**

Apply 2-3 coats of Primekote. Allow to flash completely between coats.

**DRYING TIMES:**



METAL TEMP	DRY
85°F/25°C	15-20 minutes

**Note:** After drying at the above recommendations, final sand with 320 grit or finer grit sandpaper.



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### TECHNICAL DATA:



Color	White, Grey, Black
Number of Coats	2 – 3 medium wet coats
Flash Time	5 – 10 minutes
Dry Time	15 – 20 minutes
Coating V.O.C.	
AK.3106 – White	4.38 lbs/gal 525.22 g/L
AK.3116 – Lt Grey	4.39 lbs/gal 525.65 g/L
AK.3126 – Grey	4.45 lbs/gal 533.30 g/L
AK.3136 - Black	4.39 lbs/gal 526.54 g/L
Package Size	15oz Aerosol
Shelf Life	12 months unopened
Case Quantity	12

*All data given below are MAXIMUM THEORETICAL VALUES based on the product AS CURRENTLY FORMULATED. Variations may occur on individual batches due to adjustments made during production.*

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