



Technical Data Sheet

RP15 RAPID REPAIR PRIMER

DESCRIPTION:

RP15 Rapid Repair Primer provides the quick dry to sand times needed to accomplish a true rapid repair process. This 2K Primer cures fast, sands easy and has excellent topcoat holdout.

PRODUCT & ADDITIVES:

PRODUCT	ITEM #	SIZE
RP15 Rapid Repair Primer	5421	Gallon
RP15 Rapid Repair Primer	5424	Quart
RH15 Rapid Repair Hardener	5434	Quart
RH15 Rapid Repair Hardener	5439	Half Pint

COMPATIBLE SUBSTRATES:

RP15 may be applied over properly prepared OEM finishes, catalyzed finishes, body fillers and putties as well as properly prepared SMC and 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 and product label are available upon request.

MIXING RATIOS:



4 parts RP15 Rapid Repair Primer
1 part RH15 Rapid Repair Hardener

Note: Shake RP15 Rapid Repair Primer thoroughly before mixing.



WARNING: Due to the rapid curing characteristic of this primer it has a very short pot life. The pot life may be extended by using Autokote X-Tend Pot Life Extender.

GUN SETUP:

TYPE	FLUID TIP	SPRAYING PRESSURE
Conventional Gravity	1.2 mm - 1.3 mm	25 - 30 psi @ gun
HVLP Gravity	1.3 mm - 1.4 mm	28 - 32psi @ gun
Mini Spray Gun	1.0 mm - 1.3 mm	10 - 20 psi @ gun

SURFACE PREP:

Sand area to be primed with #180 to #220 grit sandpaper.
Clean area to be primed thoroughly of all dirt, grease, wax and oil using Autokote Final-Kleen.



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NUMBER OF COATS: Apply 2 to 3 coats of RP15. Allow to dry 1 minute @ 78°F (25°C) or until flashed between coats.

FLASH TIMES: 1 minute @ 78°F (25°C) or until completely flashed.

PURGE TIMES: 0 minutes.

DRYING TIMES:



METAL TEMP	DRY TIME
78°F (25°C)	15 - 20 minutes
140°F (60°C)	5 minutes
Note: After drying at the above recommended times, final sand with #320 to #500 grit sandpaper.	

RECOATABILITY: After 30 minutes air dry @ 78°F (25°C) or after cool down from 140°F (60°C) cure.

CLEANING EQUIPMENT: Clean equipment immediately with Autokote lacquer thinner.

TECHNICAL DATA:



Color	Grey
Activator/Hardener	RH15 Rapid Repair Hardener
Reducer	N/A
Mix Ratio	4:1
Pot Life	15 - 20 minutes @ 78°F (25°C)
Number of Coats	2 - 3 full wet coats
Flash Time	1 minute @ 78°F (25°C)
Purge Time	0 minutes
Dry Time	<i>Air Dry</i> 15 - 20 minutes @ 78°F (25°C) <i>Force Dry</i> 5 minutes @ 140°F (60°C)
Gun Set-Up	Refer to Table on Page 1
Air Pressure at Gun	Refer to Table on Page 1
V.O.C. Limit	5.0 lbs/gal (600 g/l)
Regulatory V.O.C.	2.27 lbs/gal (272 g/l)
Actual V.O.C.	1.45 lbs/gal (173 g/l)
% Solids RTS by weight	59% @ 4:1
Package	Quart, Gallon
Case Quantity	6 Quarts, 4 Gallons
Shelf Life	12 months

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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