

# Technical Data Sheet








## 2.1 VOC Urethane Primer Tintable Wet-On-Wet Sealer TPI00GL

**Application:** TPI00GL can be used as a wet-on-wet urethane primer sealer, which is both tintable and compliant in regulated low VOC areas.



**Properties:** This product has excellent flow and leveling and provides good topcoat holdout.

- Remarks:**
- This product is four components and requires both a hardener and a reducer. Additionally, single-stage topcoat color (black) must be used for tinting.
  - TPI00GL is not direct-to-metal therefore an etch primer or epoxy pretreatment is required.
  - An adhesion promoter is required when refinishing raw plastic parts.

### 1. Application

 <p>Mixing ratio 4:1:10-20%</p> <p>(Four parts include primer base + single-stage color)</p>		<p><b>Medium Grey:</b> 90 parts by volume TPI00GL; 10 parts by volume single-stage black color; 25 parts by volume TH105 or TH110; 10-20 parts by volume "exempt reducer" or "non-exempt reducer"</p> <p><b>Dark Grey:</b> 80 parts by volume TPI00GL; 20 parts by volume single-stage black color; 25 parts by volume TH105 or TH110; 10-20 parts by volume "exempt reducer" or "non-exempt reducer"</p>
	<p>Spray viscosity</p>	<p>12 - 14 seconds (Ford #4 at 68°F / 20°C)</p>
	<p>Gravity gun nozzle HVLP Spraying pressure</p>	<p>1.4 - 1.5 mm 6 - 10 psi at air cap</p>
	<p>Number of spray coats Film build</p>	<p>1 - 2 medium wet coats 1.0 - 2.0 mils total dry film build</p>
	<p>Flash-off at 68°F / 20°C before topcoating</p>	<p>30 - 45 minutes</p>
	<p>Potlife at 68°F/20°C</p>	<p>45 - 60 minutes</p>
	<p>VOC as packaged (TPI00GL) VOC as applied (without tint)</p>	<p>208 gms/liter (1.7 lbs/gal) &lt;250 gms/liter (2.1 lbs/gal) with VOC "exempt reducer" <b>NOTE:</b> If non-VOC exempt reducer is used, VOC will be 2.4-2.5 lbs./gallon.</p>

### 2. Flash-Off Before Topcoating

	<p>68°F/20°C 140°F/60°C</p>	<p>30 - 45 minutes 10 - 15 minutes</p>
	<p>Infra red short wave Infra red medium wave</p>	<p>2 - 3 minutes Not Recommended</p>