

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

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

2. Flash-Off Before Topcoating

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