



# FIBERTHANE

## PRIMER

Two package, 2.8 VOC, polyurethane filler designed to fill and/or hide imperfections on metal, castings, structural foam plastics, wood and marine products. It also promotes adhesion of topcoats to the substrate.

### ADVANTAGES

- Complies with 2.8 VOC EPA solvent emission regulations
- Versatile as a filler, a primer surfacer or as a primer
- Excellent filling properties on castings and metal for the machine tool and general metal industry. Designed for heavy film applications
- Excellent filling and basecoat properties on a wide range of structural foam plastics as well as FRP, SMC, and marine applications.
- Easy sanding
- Promotes good salt spray, humidity and chemical resistance on metal surfaces when topcoated with FIBERTHANE enamels
- Air dry or force dry cure. Low energy cure
- Free of lead and chromate hazards
- No critical

### PRODUCT #

Primer	Qt. 200111908 Gal. 200111910
Catalyst	Pt. 200140207 Qt. 200140208 Gal. 200140210
Spray Reducer	Pt. 200130207 Qt. 200130208
Universal Reducer	Pt. 200130107 Qt. 200130108



### CHARACTERISTICS

- Volume Solids:** 60 ± 2%  
catalyzed and reduced
- Viscosity:**  
10-12 seconds #4 Zahn Cup  
catalyzed and reduced
- Recommended film thickness:**  
Mils Wet: 3.0 - 5.0  
Mils Dry: 2.0 - 3.0
- Spreading Rate:** (no application loss)  
310-497 sq.ft./gal @ 2.0-3.0 mill DFT
- Drying (77°F, 45% RH):**  
To Touch: 20-30 minutes  
To Handle: 1 hour  
To Sand: 4 hours  
To Recoat: 1 hour  
Force Dry: 20-30 minutes at 140°F, sand or recoat
- Curing temperature must not exceed the heat distortion temperature of the plastic substrate.
- Mixing Ratio:**  
6 part FIBERTHANE Primer  
1 part FIBERTHANE Primer Catalyst  
1/3 part FIBERTHANE Spray Reducer
- Note: Maximum total reduction is 5% by volume to maintain 2.8 VOC maximum.
- Pot Life:** 2 hours
- Flash Point:** 35°F, Pensky-Martens Closed Cup
- Package Life:** 2 years, unopened

### Air Quality Data:

Non-photochemically reactive Volatile Organic Compounds (VOC) as packaged, maximum  
2.55 lb/gal, 300 g/L  
catalyzed and reduced as above:  
2.8 lb/gal, 336 g/L

Free of lead and chromate hazards

An Environmental Data Sheet is available

### APPLICATIONS Typical Setups

#### Conventional Spray:

- Gun** .....DeVilbiss MBC  
**Air Pressure** ..... 50 psi  
**Fluid Pressure** ..... 10 psi  
**Cap/Tip** ..... 797/E or FF  
Dip, flo-coat and brushing are not recommended.

#### Cleanup:

Clean tools/equipment immediately after use with FIBERTHANE Spray Reducer. MEK and MIBK may also be used but are not HAPS compliant. Follow manufacturer's safety recommendations when using any solvent.

### SPECIFICATIONS

**General:** Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, any contamination, and surface passivation treatments to ensure optimum adhesion and coating performance properties.

**Aluminum (untreated):** Prime with FIBERTHANE Primer.

**Galvanized Steel (untreated):** Prime with FIBERTHANE Primer.

**Plastic:** Mold release must be removed from the substrate. For structural foam do not exceed 4 mils dry film. Due to the diverse nature of plastic substrates, a coating or coating system must be tested for acceptable adhesion to the substrate prior to use in production. Reground and recycled plastics along with various fire retardants, flowing agents, mold release agents, and foaming/blowing agents will affect coating adhesion.

**Steel:** Remove rust, mill scale, and oxidation products. For best results, treat the surface with a proprietary surface chemical treatment of zinc or iron phosphate to improve corrosion protection.

**Cast Iron:** Fill with FIBERTHANE Primer and sand. Apply Sealer.

**Machine tool castings:** Apply a light coat highlight the defects. Then apply multiple coats until the desired filling is achieved. Up to 15 mils dry film can be applied in multiple steps.

**For more complete information refer to MSDS (Material Safety Data Sheets) at [www.fiberlay.com](http://www.fiberlay.com) or call (206) 782-0660**

\*VOC compliance limits vary from state to state; please consult local Air Quality rules and regulations.



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**Testing:** Due to the wide variety of substrates, surface preparation methods, application methods, and environments, the customer should test the complete system

## PRODUCT LIMITATIONS

- FIBERTHANE Primer must be catalyzed at 6:1 ratio to achieve proper performance. DO NOT VARY CATALYST RATIO. The catalyst ratio has been established for optimum hardness, flexibility, gloss, and chemical solvent resistance.
- Do not spray hot. Heat shortens pot life. Do not pump catalyzed material from drums into circulating system. Friction heat developed by pumps and circulation will shorten pot life.
- Protect FIBERTHANE Primer, Catalyst, and Reducer from moisture as water affects pot life and properties. Store indoors.
- Do not package FIBERTHANE coated products in airtight plastic bags unless completely cured. Since FIBERTHANE Enamels continue to cure for several weeks, the buildup of organic solvents and reaction by-products could cause improper cure and adhesion failure in use.
- If not topcoated within 7 days room temperature cure, scuff sand before topcoating to insure proper intercoat adhesion.
- For high gloss finishes, an intermediate sealer coat may be required.

## CAUTIONS: FLAMMABLE!

Thoroughly review product label for safety and cautions prior to using this product. A Material Safety Data Sheet is available from Fiberlay, Inc.

### LABEL CAUTIONS SEE CONTENTS STATEMENT ON LABEL.

Contents are FLAMMABLE. Vapors may cause flash fires. Keep away from heat, sparks, and open flame. During use and until all vapors are gone: Keep area ventilated - Do not smoke - Extinguish all flames, pilot lights, and heaters - Turn off stoves, electric tools and appliances, and any other sources of ignition. **VAPOR HARMFUL.** Use only with adequate ventilation. Wear an appropriate properly fitted vapor/particulate respirator (NIOSH approved) during and after application, unless air monitoring demonstrates vapor/mist levels are below applicable limits. Follow respirator manufacturer's directions for respirator use. Avoid contact with eyes and skin. Wash hands after using. Keep container closed when not in use. Do not transfer contents to other containers for storage.

### FIRST AID

If **INHALED:** If affected, remove from exposure. Restore breathing. Keep warm and quiet. If on **SKIN:** Wash affected area thoroughly with soap and water. Remove contaminated clothing. Launder before re-use. If in **EYES:** Flush eyes with large amounts of water for 15 minutes. Get medical attention. If **SWALLOWED:** Call Poison Control Center, hospital emergency room, or physician immediately.

**SPILL AND WASTE:** Remove all sources of ignition. Ventilate and remove with inert absorbent. Incinerate in approved facility. Do not incinerate closed container. Dispose of in accordance with Federal, State, and Local regulation regarding pollution. **DELAYED EFFECTS FROM LONG TERM OVEREXPOSURE.** Contains solvents which can cause permanent brain and nervous system damage. Intentional misuse by deliberately concentrating and inhaling the contents can be harmful or fatal. Contains Zinc Chromate which can cause cancer. This product must be mixed with other components before use. Before opening the packages, **READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS.**

**CAUTIONS: FLAMMABLE!  
DO NOT TAKE INTERNALLY.  
KEEP OUT OF THE REACH  
OF CHILDREN.  
FOR INDUSTRIAL USE ONLY!**

### WARNING:

This product contains chemicals known to the State of California to cause cancer and to cause birth defects or other reproductive harm.

**This product must be mixed with other components before use. Before opening this packages, READ AND FOLLOW WARNING LABELS ON ALL COMPONENTS.**

WARRANTY: Fiberlay products have a variety of uses and applications. It is presumed that the user is acquainted with the intended application and procedures for accomplishing the desired result. We recommend that users inspect and test the product before use to satisfy that it is suitable for the intended use. No instructions are hereby offered or implied by Fiberlay, Inc., its employees, agents or dealers and no liabilities for unsatisfactory results are accepted. Nothing herein constitutes any warranty express or implied, including any warranty of merchantability or fitness for a particular purpose, nor is any protection from any law or patent to be inferred. The exclusive remedy for any proven claim is limited to replacement of product and in no event shall Fiberlay, Inc. be liable for special, incidental or consequential damages.