

TECHNICAL DATA SHEET



IC-972-50 1K Primer Surfacer

Description

IC-972-50 1K Primer Surfacer features easy application, excellent covering power and easy sanding. It provides full insulation of primers and polyester putties and at the same time, it can enhance the adhesion between the coatings to ensure that the subsequent topcoat can be firmly attached and not easily fall off.



Features

- Excellent filling property
- Fast drying time, dry to sand in 35 minutes
- Easy to sand

Required Products

- IC-972-50 Primer Surfacer
- IC-944 Reducer

Compatible Surfaces

- Properly prepared gel coated fiberglass
- Properly prepared OEM finishes
- Properly prepared E-coat
- Properly prepared steel & aluminum
- Rigid Plastics
- Body Fillers
- Epoxy Primers
- Self-etch Primers

IC-972-50 1K Primer Surfacer

Preparation of Substrate

- Wash the area to be painted with soap and water, then clean with IC-800 degreaser.
- Sand the old finishes with 240-360 grit dry by hand or machine or 600-800 grit wet.
- Reclean with IC-800 degreaser. The use of a tack rag is recommended.



Mixing Ratio

Product	Vol	Weight
IC-972-50	100	100
IC-944	100	70

Note:

Please shake for 30 s before mixing, and mix well and strain before application.



Pot Life

Indefinite in a sealed cup



Spray Viscosity

16-20 s with DIN 4 cup at 25°C



Spray Guns

Type	Nozzle Size	Pressure	Spray Distance
HVLP Gravity-feed Spray Gun	1.5-1.7 mm	1.8-2.0 bar	15-20 cm
Compliant Gravity-feed Spray Gun	1.6-1.8 mm	3.0-4.0 bar	20-25 cm

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Number Of Coats

1 half wet + 1 wet coat



Film Thickness

30-40 μm per coat



Drying Times

	20°C	60°C
Flash off	5-10 min	-
Dry to sand	35-40 min	10-15 min



Product Specifications

Color: Grey

Shelf Life: 24 months at 25°C

Theoretical Coverage: 250-300 m^2/L at 1 μm thickness

Ready to use density: 1106 g/l

Weight of ready to use solids: 35.2 %



Sanding

After fully cured, it will be necessary to sand the primer with 400-800 grit abrasives.

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HEALTH AND SAFETY



Please refer to Material Safety Data Sheets for full Health and Safety details and product can labels.

- Hardeners contain isocyanate and therefore particular safety precautions must be taken.
- Goggles must be worn when mixing and using to prevent accidental splashing into the eye. If contact occurs with eyes give prolonged irrigation with water and get medical attention immediately.
- Good ventilation and extraction must be provided in the working environment.
- Wear suitable protective equipment to prevent skin contact with this material.
- When spraying this product the operator (and persons in vicinity) must wear suitable air-fed breathing apparatus.
- Do not smoke whilst using this material.

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