

TECHNICAL DATA SHEET



IC-981-60 2K Primer Surfacer

Description

IC-981-60 is a high build 2K primer surfacer that is specially formulated for good filling and isolation properties. It is very easy to sand, and has excellent adhesion to various sub-strates.

Features

- Superior filling property, total 220µm thickness
- Excellent adhesion to various substrates
- Form a very smooth surface, easy to sand



Required Products

- IC-981-60 Primer Surfacer
- IC-9788 Hardener Series
- IC-950 Reducer Series

Compatible Surfaces

- Properly prepared gel coated fiberglass
- Properly prepared OEM finishes
- Properly prepared E-coat
- Properly prepared bare metal, steel and aluminum
- Body Fillers
- Epoxy Primers
- Self-etch Primers

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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-981-60	100	100
IC-9688/9788/9888	25	15
IC-940/950/960/970	20-25	12-15

Note:

IC-9688/IC-940 is for temperatures between 5-15°C

IC-9788/IC-950 is for temperatures between 15-25°C

IC-9888/IC-960 is for temperatures above 25°C

IC-970 is for temperatures above 35°C or when refinishing large surfaces.

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



Pot Life

1-1.5 hrs at 25°C



Spray Viscosity

18-22 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

2 half wet + 2 wet coats



Film Thickness

180-220 μm total



Drying Times

	20°C	60°C
Flash off	10-15 min	-
Dry to sand	3-4 hrs	50 min



Product Specifications

Color: Grey

Shelf Life: 24 months at 25°C

Theoretical Coverage: 300-350 m^2/L at 1 μm thickness

Ready to use density: 1330 g/l

Weight of ready to use solids: 62.0 %



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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