

# 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

## IC-981-60 2K 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-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

## IC-981-60 2K Primer Surfacer



### Number Of Coats

2 half wet + 2 wet coats



### Film Thickness

180-220  $\mu\text{m}$  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  $\text{m}^2/\text{L}$  at 1 $\mu\text{m}$  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.

## IC-981-60 2K Primer Surfacer

### 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.

The products are suitable for professional use only. The data contained in this publication are based on our current knowledge and experience. The Information is given for information purposes only and we are not liable for its correctness, accuracy and completeness. The intellectual property in this document, including patents, trademarks and copyrights, is protected. All rights reserved. Published technical data and instructions are subject to change without prior notice. All rules set forth in this clause shall apply accordingly for any future changes and amendments. You can obtain the latest version of technical data sheet from our website at [www.wonder-global.com](http://www.wonder-global.com) or directly from your supplier.

**Revised: September 2024**