

TECHNICAL DATA SHEET



IC-991

2K Fast Drying Primer

Description

IC-991 is a high solid 2K primer surfacer that is specially formulated to give an excellent balance between filling and efficiency. It can be fully cured in just 25 min, which provide body shops with efficient solution on quick repair. It also produces a very smooth surface to ensure easy sanding. It can be used for spot and panel repair.



Features

- Hyper-fast drying, fully cured in 25 min
- Form a very smooth surface, easy to sand
- Suitable for spot and panel repair

Required Products

- IC-991 Primer Surfacer
- IC-961 Hardener
- IC-950 Reducer Series

Compatible Surfaces

- Properly prepared gel coated fiberglass
- Properly prepared OEM finishes
- Properly prepared E-coat
- Rigid Plastics
- 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-991	100	100
IC-961	25	17
IC-940/950/960/970	25	15

Note:

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

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

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

10-15min at 25°C



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

2-3 coats



Film Thickness

30-40 μm per coat



Drying Times

	20°C	60°C
Flash off	3-5 min	-
Dry to sand	25-35 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: 1229 g/l

Weight of ready to use solids: 56.2 %



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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