



# Big Sky® Product Information Sheet

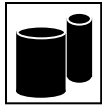
Technical Support (800) 328-4892

P.I. Sheet #1000

## PS5012™ (Gray) 2K Urethane 2.1 VOC Primer/Sealer

READ ENTIRE PRODUCT INFORMATION SHEET PRIOR TO USE. IF ANY QUESTIONS ARISE, PLEASE CALL TECHNICAL SUPPORT.

### COMPONENTS (REQUIRED)



1. PS5012A™ (Gray) Urethane Primer
2. PS5012B™ Urethane Primer Activator
3. TH0870™ Reducer (sealer option only)

### SPECIALTY COMPONENTS (OPTIONAL)

1. Big Sky® Universal Tints (sealer option only)
2. PE35ACC™ Accelerator
3. TH035™ Specialty Low VOC Reducer

### DESCRIPTION:

Our 2.1 VOC two component urethane primer meets the strictest VOC regulations. This primer is designed to provide high film build, ease of sanding, and excellent color holdout. PS5012™ is tintable (when used as sealer), chromate free, and can be used as a primer surfacer and a sealer.

### SURFACE PREPARATION

**NOTE:** Be sure to completely remove all rust or oxidation prior to applying primer. Rust and/or oxidation can be removed by sand blasting, grinding, or sanding. Liquid metal cleaners may also be used followed by the appropriate metal conditioner or conversion coating. Sky Fleet™ Epic Prime™ primer may also be used as sprayable metal conditioners.

#### Bare Substrates:

- Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Finish sand with 180 grit sandpaper
- TH5950™ Strong Wax & Grease Remover and a red scuff pad may be used to remove light surface oxidation on aluminum. Follow by re-cleaning the aluminum to remove sanding residue with TH5950™ Strong Wax & Grease Remover.

#### Prepainted Substrates:

- Wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean, dry cloth. Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Sand repair area and featheredge as needed, finishing with 320 grit sandpaper.
- Re-clean repair with TH5952™ Fast Evaporating Surface Cleaner to remove sanding residue before priming. On larger areas, the use of TH5951™ Mild Wax & Grease Remover may be desired.

#### Sealer Option:

- Wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean, dry cloth. Solvent clean with TH5950™ Strong Wax & Grease Remover or TH5951™ Mild Wax & Grease Remover.
- Sand repair areas, finishing with 400 grit sandpaper or finer.
- Re-clean repair with TH5951™ Mild Wax & Grease Remover or TH5952™ Fast Evaporating Surface Cleaner to remove sanding residue before sealing.

### COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, aluminum, and galvanized steel
- Epic Prime™
- PS3008™ ViperGripII™ Metal Etch Primer
- Thoroughly sanded OEM
- Thoroughly sanded and cured paint
- Cured body filler (the use of stain free body fillers on light colors will reduce the chance of yellowing)
- Sanded fiberglass (apply 1-coat of Epic Prime™ epoxy primer prior to PS5012™ for maximum adhesion.)

### MIX BY VOLUME



#### **As a Primer (VOC 2.1 lbs/gallon as applied)**

- 4 Parts PS5012A™ Urethane Primer
- 1 Part PS5012B™ Urethane Primer Activator

**Note: 4:1 mix yields a heavy build of 2.5 mils ± .5 per coat**

**Note: A 10% reduction, using TH035™ low VOC reducer, may be desired for better level & flow.**

Mix Ratio in Ounces (As a Primer)						
Primer	4	8	16	24	32	64
Activator	1	2	4	6	8	16

#### **As a Sealer (VOC 3.46 lbs/gallon as applied)**



- 4 Parts PS5012A™ Urethane Primer
- 1 Part PS5012B™ Urethane Primer Activator
- 1 Part TH0870™ Reducer

**Note: A 4:1:1 mix yields a film build of 1.5 mils ± .5**

**Note: If further reduction is desired, use TH035™ low VOC reducer to maintain VOC.**

Mix Ratio in Ounces (As a Sealer)						
Primer	4	8	16	24	32	64
Activator	1	2	4	6	8	16
Reducer	1	2	4	6	8	16

### TINTING

- Tint only when using sealer option.
- See Primer Tint Chart Form #1015 for colors and formulas.
- Use no more than 3 oz. of Big Sky® Tints per quart of PS5012™.
- Tint first, than add activator at a 4:1 mix ratio. Then reduce.

### SPECIALTY COMPONENTS



**Accelerator** – CR22ACC™ Accelerator can be used to reduce the sand time. PE35ACC™ Accelerator will extend pot life and reduce sand time.

- Use approximately ½ ounce per mixed quart of primer.
- The use of CR22ACC™ Accelerator will reduce pot life.

### POT LIFE



**Catalyzed Primer:** 1 hour at 75°F

**Sealer:** 1½ hours at 75°F

- **Note:** Accelerator, reducer, and temperature will affect pot life.
- Clean equipment immediately after use.

## EQUIPMENT SETUP



### Primer

	Fluid Tip	Air Pressure (PSI)
HVLP Gravity	1.4 – 1.8mm	7 – 10 at the cap
HVLP Siphon	1.8 – 2.2mm	7 – 10 at the cap
High Efficiency Gravity	1.4 – 1.8mm	30 – 40 (PSI) Inlet Pressure
High Efficiency Siphon	1.8 – 2.2mm	30 – 40 (PSI) Inlet Pressure

### Sealer

HVLP Gravity	1.4 – 1.6mm	7 – 10 at the cap
HVLP Siphon	1.6 – 1.8mm	7 – 10 at the cap
High Efficiency Gravity	1.4 – 1.6mm	30 – 40 (PSI) Inlet Pressure
High Efficiency Siphon	1.6 – 1.8mm	40 – 50 (PSI) Inlet Pressure

## PRIMER APPLICATION



- Apply over properly prepared surfaces.
- Apply in single full wet coats, allowing 5-10 minutes flash between coats.
- If double coating, allow 20-minutes flash between coats.
- For best results, do not apply more than 3 coats.

### Brushable / Rollable Option

- Mix according to directions.
- Apply 1 even coat of PS5012™ Primer, making sure to cover the repair area completely into the featheredge.
- If a 2<sup>nd</sup> coat is applied, allow a 5-10 minute flash between coats.
- Apply the 2<sup>nd</sup> coat within ¾ inch of the first coats outer edge.
- For best results, do not apply more than 3 coats.

## SEALER APPLICATION

- Apply 1 single wet coat of properly mixed PS5012™ Urethane Sealer (tinted or not) to create a uniform base.
- Allow to flash for 30 – 45 minutes before applying topcoats.

## DRY TIME TO SAND



### Primer Option:

- Primer must be sanded prior to topcoating.
- Air Dry: 1 ½ - 2 hours at 75°F per coat before sanding.
- If 3 coats are applied, allow to dry overnight.
- Baking: Allow a 15-minute flash, then bake at 150°F for 45-minutes. Allow to cool before sanding.
- Infrared: Allow a 15-minute flash, then bake at 140°F for 20-minutes. Allow to cool before sanding.

### Sealer Option:

- Does not require sanding prior to topcoat unless PS5012™ has dried for longer than the recommended recoat time.
- If not topcoated within 6-hours, scuff with gray scuff pad or 600 grit sandpaper.

## DRY TIME TO TOPCOAT

### Primer Option:

- Primer must be sanded before topcoating.
- PS5012™ does not require sealing, except to make a uniform color base. Finish sand with 600 grit sandpaper when not using a sealer.
- Topcoat within 24-hours of dry sanding or 4-6 hours after wet sanding.
- If PS5012™ has set for longer than the recommended recoat time, re-sand with 600 grit sandpaper, or finer, for maximum adhesion.

### Sealer Option:

- 30 – 45 minutes at 75°F prior to topcoating

## COMPATIBLE TOPCOATS

- Acrylic Urethanes
- Acrylic Enamels
- Polyurethane Color
- Basecoat Color
- Synthetic Enamels

## SPECIAL NOTES

- Use in shop temperatures that are maintained above 75° for the first 20-hours of the dry cycle.
- Ensure surfaces are up to shop temperature prior to work.
- Ensure proper metal conditioning/preparation procedures in early stages are followed.
- Ensure proper flash times, dry times, sanding procedures, and all directions for topcoats are followed.
- Use a mixing cup for accurate volume measurements.
- Allow primer to flash between coats to insure better drying and minimize shrinkage.
- Mix only what will be used in 1-hour over areas that are going to be heavily re-sanded.
- Multiple coats of primer should be used only if heavy sanding is going to be done.
- Heat lamps may be desired on featheredge break throughs with primer option only.

## PHYSICAL DATA

Primer (4:1 Mix Ratio)	
Dry to Sand	2-hours
Film Thickness	2.5 ± .5 mils per coat
Volume Solids	40.6%
VOC Applied	2.10 lbs/gallon
# of Coats	2
Theoretical Coverage	652 @ 1 mil DFT

Sealer (4:1:1)	
Dry to Topcoat	30-45 minutes
Film Thickness	1.2 ± .5 mils
Volume Solids	33%
VOC Applied	3.46 lbs/gallon (maximum)
# of Coats	1
Theoretical Coverage	530 @ 1 mil DFT

## CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

## DISPOSAL

Dispose of all paint and paint related materials in accordance with state and local regulations.

## SAFETY & HEALTH

Read and follow all technical product information, labels, and MSDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

## MSDS REFERENCE

Primer – MSDS #9  
Activator – MSDS #6  
Reducer – MSDS #1

## COMPANY INFORMATION

ChemSpec USA  
9287 Smucker Road  
Orrville, Ohio 44667  
Toll Free: (800) 328-4892  
Fax: (330) 669-3965  
Website: [www.chemspecpaint.com](http://www.chemspecpaint.com)

**Refer to all labels on products and information sheets for hazards and proper handling procedures for each component. Read the Material Safety Data Sheets (MSDS) supplied with the materials.**

**KEEP OUT OF REACH OF CHILDREN**