Tech Data

AP-8020 Production Prime

AP-8020 Production Prime is a two-component acrylic urethane primer surfacer formulated to be applied as a high build sanding primer, or a final non-sanding primer•sealer. AP-8020 offers fast dry, excellent adhesion, easy sanding and superior color holdout. AP-8020 does not shrink and can be tinted with basecoat tints.

Products

AP-8020	Production Prime
AH-6070	Uni Activator Fast
AH-6080	Uni Activator Medium
AR-2040	Uni Reducer Fast
AR-2050	Uni Reducer Medium
AR-2060	Uni Reducer Slow
AR-2100	E-Z Blend

Application

Surface Preparation, Bare Substrates
Solvent wash surface with a good grade wax and grease remover such as AS-2900 and wipe dry with a clean cloth. Apply three single wet coats of AP AP-8300 Series Epoxy Primer according to instructions on data sheet.

Surface Preparation, Prepainted Substrates
Wash surfaces with a mild detergent and hot water. Rinse with clean water and wipe dry with a clean cloth. Solvent clean with AS-2900 Clean Ease. Wipe dry with a clean cloth. Sand original paint and repair damaged areas with a good quality non-staining body filler. For spot repairs, scuff sand area where primer will be applied. For overall refinishing, scuff sand the entire car with 320 grit sandpaper or fine scuff pad.

Mixing Directions, High Build, Sealer
5 Parts AP-8020	Production Prime
1 Part AH-6070, AH-6080	Uni Activator Series

Mixing Directions, Normal Build
5 Parts AP-8020	Production Prime
1 Part AH-6070, AH-6080	Uni Activator Series
1 Part AR-2040, AR-2050, AR-2060	Uni Reducer Series

Application, High Build and Normal Build
Adjust air pressure at the gun to 30-45 psi for siphon feed guns. Use less pressure to minimize over spray on small jobs. Apply 2-3 medium wet coats at a gun distance of 8 -12 inches as needed to fill voids and block sand with 180 to 280 grit treated sandpaper. Allow 10 to 20 minutes flash time between coats. Recoat times will vary with temperature, air movement and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system. Finish sand repaired area with 320 grit sandpaper using a DA Sander or hand sand.

Application, Sealer
Adjust air pressure at the gun to 30-45 psi for siphon feed gun. Use less pressure to minimize over spray on small jobs. Apply 1 or 2 wet coats at a gun distance of 8-12 inches. Allow 30 minutes flash time before top coating. Recoat time will vary with temperature, air movements and film thickness. Insufficient flash time will promote slow hardness development of the topcoat system.

Drying Schedule

Dry times are based on recommended film thickness and are dependent on ambient temperature. Excessive film thicknesses, low temperature and poor air movement will retard dry times.

Air Dry	High Build	Normal Build	Sealer
Dust Free	15-20 min	10-15 min	5-15 min
Tack Free	25-30 min	15-20 min	15-20 min
To Topcoat	60 min	45-60 min	30 min

Pot Life

Three to four hours for high build and normal build.
Four to five hours for sealer.

Accelerator

To improve cure and reduce the sanding time, or for faster cure in colder conditions, add 2 to 4 ounces of AH-X99 Accelerator to one gallon of catalyzed primer. **Caution:** The addition of cure accelerator can significantly reduce working pot life.

Technical Data

Weight Solids		Mixing Ratio, High Build	5:1
Package	59.8%	Mixing Ratio, Normal Build	5:1:1
Ready to Spray, High Build	57.3%		
Ready to Spray, Normal Build	49.7%		
		Pot Life	3 to 5 hours
		Viscosity @ Gun	20-40 #2 Zahn
Volume Solids		Recommended Film Thickness	2.5 to 8.0 mil
Package	40.2%	Flash Point	72°FTCC
Ready to spray, High Build	37.7%		
Ready to spray, Normal Build	33.3%	Coverage, High Build	600 sq ft/gal
		Coverage, Normal Build	520 sq ft/gal
VOC @ Gun, High Build	4.7 lbs/gal	Air Pressure @ Gun	45-50 psi
VOC @ Gun, Normal Build	4.8 lbs/gal	Gloss	Flat

Performance Data

Flexibility	Excellent	Direct Impact	Excellent	Chip Resistance	Excellent
Salt Resistance	Excellent	Humidity Resistance	Excellent	Hardness	3H
Color Holdout	Excellent	Settling Resistance	Excellent	Water Resistance	Excellent