Velocity FINISHES

Tech Data

3600 HS 2K Urethane Primer

3600 2K Urethane Primer 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. 3600 offers excellent filling properties with minimal coats, fast dry, excellent adhesion, easy sanding and superior color holdout. 3600 does not shrink and can be tinted with basecoat tints.

Products

3600	2K Urethane Primer
3670	Fast Activator
3680	Medium Activator

Application

Surface Preparation, Bare Substrates

Solvent wash surface with a good grade wax and grease remover and wipe dry with a clean cloth.

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 wax and grease remover. 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

4 Parts 3600	2K Urethane Primer
1 Part 3670, 3680	Activator

Mixing Directions, Normal Build

4 Parts 3600	2K Urethane Primer
1 Part 3670, 3680	Activator
1 Part Reducer	Urethane Grade Reducer

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

1.5 to 2 hours for high build and normal build.
2 to 2.5 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	4:1
Package	64%	Mixing Ratio, Normal Build	4:1:1
Ready to Spray, High Build	57.3%		
Ready to Spray, Normal Build	49.7%		
		Pot Life	1.5 to 2 hours
		Viscosity @ Gun	20-40 #2 Zahn
Volume Solids		Recommended Film Thickness	2.5 mil
Package	40.%	Flash Point	72ºFTCC
Ready to spray, High Build	36.2%		
Ready to spray, Normal Build	32.1%	Coverage, High Build	648 sq ft/gal
		Coverage, Normal Build	535 sq ft/gal
VOC @ Gun, High Build	4.3 lbs/gal	Air Pressure @ Gun	45-50 psi
VOC @ Gun, Normal Build	4.5 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