

# ACRYLIC HIGH BUILD

## Acrylic Lacquer Primer Surfacer



TECHNICAL DATA SHEET

Acrylic High Build Primer Surfacer fill well and dry extremely fast for easy sandability after just 20-30 minutes. Designed for use over properly prepared substrates, these primer surfacers provide good color holdout for a variety of topcoats.

- National Rule Compliant
- Dries super fast for quick sanding within minutes
- Builds fast in two coats
- Excellent fill qualities
- Three color choices for better topcoat coverage

### COATING TYPE:

Acrylic lacquer primer surfacer

### PRODUCT CODE:

1315 – Light Gray  
1715 - Black  
1815 – Red Oxide

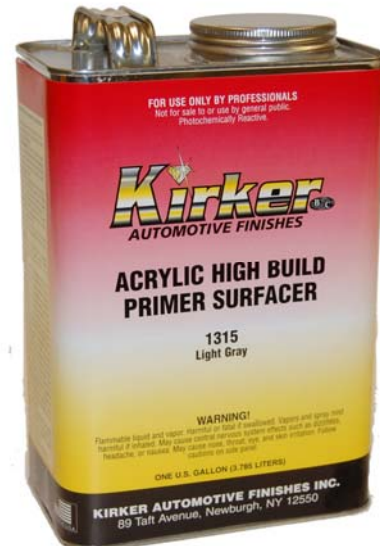
### ACTIVATOR:

Not Required

### THINNERS:

R-305 – Fast (Below 65°F)  
R-300 – Medium (65°F – 85°F)  
R-304 – Slow (Above 85°F)

*\* To remain National Rule Compliant, these low-VOC lacquer thinners must be used*



### PHYSICALS:

<b>Appearance:</b>	Flat finish, varies with color
<b>Weight per Gallon:</b>	9.37 – 10.05 lbs (Varies with color)
<b>Package Measure:</b>	1 U.S. gallon / 128 fl. oz. (3.785 liters)
<b>RTS VOC:</b>	Max: 4.8 lbs/gallon



**SURFACE PREP:**

Acrylic High Build Primer Surfacer may be applied over a variety of substrates.

**For bare metal:**

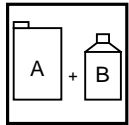
Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 180 grit, and then re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

If priming over large areas of bare metal, a chemical pre-treatment (such as Kirker's R-6820 Self-Etching Reducer) is recommended. This etching acid/solvent blend should be applied one section at a time with a clean cloth, and then wiped down with another clean, dry cloth.

**For factory finishes:**

Remove all traces of wax, grease, silicone, oil and other contaminants with detergent wash, followed with a solvent wash (such as Kirker's 650 Wax & Grease Remover). Abrade substrate with 320 - 400 grit, and then re-clean with final wash cleaner (such as Kirker's 600 Surface Wash).

Be sure to mask all adjacent panels to prevent dry overspray.



**MIXING:**

Mix ratio: 1:1 by volume. Thoroughly mix one (1) part primer (1315, 1715 or 1815) with one (1) part Low VOC Lacquer Thinner (R-305, R-300 or R-304) depending on air flow and temperature at time of application.

NOTE: To remain National Rule Compliant, these special Low-VOC lacquer thinners must be used.

Temperature range	Less than 70° F	Between 70° F - 80° F	More than 80° F
Low-VOC Thinner	R-305 (fast)	R-300 (medium)	R-304 (medium)

There is no pot life for this primer, however it is always recommended that you mix only as much material as is necessary to complete the immediate job.



ACRYLIC HIGH BUILD	3oz	8 oz.	12 oz.	16 oz.
LOW-VOC THINNER	3 oz.	8 oz.	12 oz.	16 oz.
<b>TOTAL MIXTURE</b>	<b>6 oz.</b>	<b>16 oz.</b>	<b>24 oz.</b>	<b>32 oz.</b>



**GUN SETTINGS:**

GUN TYPE	TIP SIZE	AIR PRESSURE
Conventional Siphon Feed:	1.6 mm – 1.8mm	40-50 psi at the gun
Conventional Gravity Feed:	1.6 mm – 1.8 mm	40-50 psi at the gun
HVLP	1.4 mm – 1.6 mm	8-10 psi at the tip

Always refer to gun manufacturer's recommendations for additional details on suggested tip size, air pressure and other adjustments.



**APPLICATION:**

Apply in double wet coats until desired build is attained.

Allow primer to flash completely between coats.



**DRY TIMES / RECOAT:**

Allow a minimum of 5-10 minutes for Acrylic High Build Primer Surfacer to dry between coats.

Acrylic High Build Primer will dry dust free within 10-15 minutes, may be recoated after approximately 20 minutes and may be sanded after 20-30 minutes, depending on temperature and airflow.

*Air-dry times may vary slightly depending on shop temperatures, airflow and total film thickness. All dry times listed are approximate, at 70° - 75°F.*

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**CLEANUP:**

Close all containers tightly after each use. Clean gun and spray equipment with gun wash or other appropriate solvent products immediately after application to prevent damage.

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**HEALTH / SAFETY PRECAUTIONS:**

THIS PRODUCT IS INTENDED FOR USE BY PROFESSIONALS ONLY.

USE THIS PRODUCT ONLY WITH ADEQUATE VENTILATION: Wear appropriate, properly fitted NIOSH/MSHA approved respirator as directed by the manufacturer. Protect hands with impervious rubber gloves. Always wear eye and face protection. Individuals with lung or breathing problems should neither use nor be exposed to this product, its vapors or spray mist. READ ALL WARNINGS ON ALL LABELS BEFORE USING.

This product is designed to be mixed with other components. Mixture will have hazards of both components. Before opening the packages, read all warning labels. Follow all precautions. See Material Safety Data Sheet for additional safety information.

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**WARRANTY:**

All recommendations for the use of Kirker products are based on tests and experience believed to be reliable. Since the methods of use, conditions of application, and the application itself are beyond our control, product warranty is restricted to replacement of material only. No other warranty, written or oral, is expressed or implied.

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**FOR ADDITIONAL INFORMATION:**



89 Taft Avenue, Newburgh, NY 12550  
Toll free: 800-307-7951  
Fax: 845-562-8986  
[www.KirkerAutomotive.com](http://www.KirkerAutomotive.com)  
[info@kirkerautomotive.com](mailto:info@kirkerautomotive.com)