PRO FORM™

Product Data Sheet

Direct to Metal 2K Urethane High Build Primer

PF 490, PF 493, PF 494

A direct to metal, high build, premium quality, two component, acrylic urethane primer. Primer offers excellent corrosion protection, adhesion and great sand scratch holdout. Higher solids formula provides improved fill and build properties. Primer is available in gray, white, and black. Mix gray, white, or black together to create a shaded primer.

PRODUCT			ACTIVATOR:		
PF 490-1	GRAY	U.S. GALLON (3.78L)	PF 492		0.5 U.S. PINT (236 ml)
PF 490	GRAY	U.S. QUART (946 ml)	PF 492XS	SLOW	0.5 U.S. PINT (236 ml)
PF 493-1	BLACK	U.S. GALLON (3.78L)	PF 491		U.S. QUART (946 ml)
PF 493	BLACK	U.S. QUART (946 ml)	PF 491XS	SLOW	U.S. QUART (946 ml)
PF 494-1	WHITE	U.S. GALLON (3.78L)			
PF 494	WHITE	U.S. QUART (946 ml)			

ALWAYS REFER TO MSDS PRIOR TO USING THIS PRODUCT AND TAKE PROTECTIVE MEASURES TO ENSURE SAFE USE

COMPATIBLE PREPARED SUBSTRATES:

- Properly cleaned, sanded and treated steel
- Properly cleaned, sanded and treated galvanized steel
- Properly cleaned, sanded and treated aluminum or fiberglass
- Cured and sanded OEM finishes
- Cured and sanded Body Filler

CAUTION: Test the compatibility of this product with your paint system. Do not use in temperatures below 16°C (60°F). Use below these temperatures will affect dry times and performance.

SURFACE PREPARATION:



1. Wash area thoroughly with soap and water to remove contaminates that solvent based cleaners cannot remove effectively. All substrates must be de greased and sanded. All rust must be removed
2. Clean repair area with PF 605 Wax & Grease Remover. Clean plastic surfaces with PF 606 Plastic Parts Cleaner. Wipe dry while the surface is still wet.
3. If necessary sand repair with 80 grit followed by 180 grit to feather at broken film areas. Clean area with PF 605 Wax & Grease Remover.
4. Completely sand surface with 180-220 grit sandpaper and re-clean with PF 603 Final Wipe.

MIXING DIRECTIONS:



High Build	Primer	Activator
	PF 490-1, PF 493-1, PF 494-1	PF 491, PF 492
	PF 490, PF 493, PF 494	PF 491XS, PF 492XS
	4 Part Primer	1 Parts Activator

*No induction period necessary

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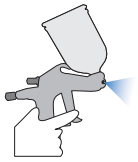
Medium Build	Primer	Activator	Reducer
4 : 1 : ½ MIX RATIO	PF 490-1, PF 493-1, PF 494-1 PF 490, PF 493, PF 494 4 Part Primer	PF 491, PF 492 PF 491XS, PF 492XS 1 Parts Activator	PF 682C, PF 683C, PF 684C PF 682C, PF 683C, PF 684C 1/2 Part Reducer

REDUCERS:

Reducing is not recommended. However, if desired, up to 20% by volume of Zero V.O.C. Urethane Grade Reducers can be used

PF 684C	(Fast)	20°C (70°F)
PF 683C	(Medium)	20°C - 27°C (70°F - 80°F)
PF 682C	(Slow)	29°C - 32°C (85°F - 90°F)

APPLICATION:



1. Apply 2-3 coats with 10 minutes flash time @ 24°C (75°F) @ 50 % relative humidity between each coat. Allow to dry 45-60 minutes before sanding (3 full wet coats is 4-5 mils dry). For best results do not exceed 5 mil dry film thickness.
2. Pro Form recommends a final blocking with 600 grit or finer sandpaper before topcoating.

NOTE: In hot humid conditions above 27°C (85°F) the use of slow activator is required. Film thickness, flash times, and temperature may affect sanding times. In extreme heat, the use of reducer (10% max) may be needed.

SPRAY GUN AND PRESSURE:

Gun Type	Fluid Tip	Air Pressure
Siphon Feed	1.6 - 2.0 mm	40 - 50 psi
Gravity Feed	1.6 - 1.8 mm	35 - 45 psi
HVLP	1.6 - 1.8 mm	10 psi

POT LIFE @ 75°F (24°C):

Regular Activator 1-1.5 Hours

Slow Activator 2 - 2.5 Hours

NOTE: Pot life will shorten as temperatures increase. Products are not recommended for use in temperatures below 16°C (60°F).

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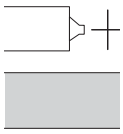
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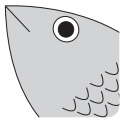
PF 490, PF 493, PF 494

ADDITIVES:



Accelerator:

Use up to a maximum of 1 fl oz. of PF 655 Super Kick Accelerator per spayable quart. The addition of PF 655 will reduce cure time up to 50%, Pot life will also be reduced by up to 50%. The use of PF 655 will not increase the V.O.C.'s.



Fish Eye:

Do not use fish eye eliminator in this product.

DRY & FLASH TIME:



Dry times at 24°C (75°F) and 50% relative humidity

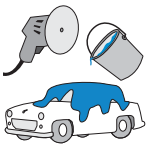
Flash Time	5-10 minutes
To Sand	60-90 minutes
To topcoat	60-90 minutes



Force Drying At 60°C (140°F)

Purge Time	15 minutes
Bake Time at 60°C	20 minutes

REPAIRING & RECOATING:



Direct to Metal 2K Urethane High Build Primer must be sanded prior to recoating after 24 hours drying @ 24°C (75°F).

CLEAN UP:



Clean equipment immediately with Gun Wash or PF 686C Acrylic Lacquer Thinner.

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TECHNICAL DATA:

	PF 490	PF 493	PF 494
APPEARANCE	Gray	Black	White
WT/GAL	12.72 lbs	12.82 lbs	12.74 lbs
VISCOSITY (mixed)	20-35 seconds #2 Zahn mixed		
VOLUME SOLIDS (mixed)	44.83%	44.60%	44.85%
VOLUME SOLIDS (mixed) ** slow	44.58%	44.36%	44.61%
WEIGHT SOLIDS (mixed)	61.71%	61.76%	61.76%
WEIGHT SOLIDS (mixed) ** slow	61.29%	61.34%	61.34%
Coverage @1 mil Wet (appx)	717 sq ft	713 sq ft	717 sq ft
Flash Point	-4°C (24.8°F)		

V.O.C. (RTS):

	Regulatory	Regulatory	Material	Material
	V.O.C. in lbs/gal	V.O.C. in g/L	V.O.C. in lbs/gal	V.O.C. in g/L
PF 490	2.1	250	2.1	250
PF 490 **slow	2.1	250	2.1	250
PF 493	2.1	250	2.1	250
PF 493 **slow	2.1	250	2.1	250
PF 494	2.1	250	2.1	250
PF 494 **slow	2.1	250	2.1	250

PRECAUTIONARY INFORMATION

Refer to product label and Safety Data Sheet for health and safety information before using this product.

SAFETY CONSIDERATION

Safety Data Sheets are available at www.proformproducts.com or upon request at info@proformproducts.com. These are provided to help our customers satisfy their own handling, safety and disposal needs, and those required by local applicable health and safety regulations. Our Safety data sheets are updated regularly, therefore, please review the most current Safety Data Sheet before handling or using any product.

TECHNICAL INFORMATION:

The technical information, recommendations and other statements contained in this document are based upon tests or experience that Pro Form believes are reliable, but the accuracy or completeness of such information is not guaranteed.

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PRODUCT USE:

Many factors beyond Pro Form's control and uniquely within user's knowledge and control can affect the use and performance of a Pro Form product in a particular application. Given the variety of factors that can affect the use and performance of a Pro Form product, user is solely responsible for evaluating the Pro Form product and determining whether it is fit for a particular purpose and suitable for user's method of application.

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