

Limco 846

1K Acrylic Primer



Description:

Limco 846 1K Acrylic Primer is a non-settling, fast drying, easy sanding, flexible primer that meets the National Rule and provides excellent adhesion plus good color hold-out.

Materials:

Limco Primer: 846 Gray
Limco Reducer: VR0
LR0

Substrate/Pretreatment:**Cleaning****Sanding****Second Cleaning**

Well cured old paint work

203 Clesol

220 grit

139 Final Wash Cleaner

O.E.M. primed spare parts

203 Clesol

220 grit

139 Final Wash Cleaner

Bare steel

203 Clesol

80 - 180 grit

139 Final Wash Cleaner

Galvanized steel

Precoat with 834 or 801

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—

Aluminum

Precoat with 834 or 801

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Fiberglass plastic parts (without gelcoat)

R-M 903 Antistatic

220 grit

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Polyester body filler

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—

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Topcoats:

Limco Synthetic Enamel
Limco Acrylic Enamel
Limco Urethane
Limco 3.5 VOC Urethane
Limco Basecoat
Limco 3.5 VOC Industrial Urethane Single Stage
Limco Supreme Basecoat

Remarks:











846 is a high filling, fast sanding 1K laquer primer. Best results are obtained when thinner coats, with 5 - 10 minutes flash between coats, are observed. Excessive film builds of lacquer primer can lead to soft topcoats or premature film failures.

Always check local VOC laws to ensure using Limco products are compliant in your area.

UNDERCOATS

TECHNICAL DATA

T E C H N I C A L D A T A

Usage Data	Primer/Primer Surfacer
 Mixing ratio	1:1
 Primer	1 part 846
 Reducer	1 part VR0 or LR0
Potlife at 68°F/20°C	
N/A	
 Spray viscosity Ford #4 68°F/20°C	12 - 15 secs.
 Gravity gun nozzle	1.5 mm or .059"
Siphon gun nozzle	2.2 mm or .087"
 Spray pressure at the gun	35 to 50 psi
Gravity gun nozzle HVLP	1.5 mm or .059"
Siphon gun nozzle HVLP	2.2 mm or .087"
Spray pressure HVLP at the cap	
10 psi	
 Application — # of coats	2 or 3
 Flash-off time 68°F/20°C	5 to 10 mins.
Film build	2.0 to 3.0 mils
Coverage,RFU	203 sq. ft./gal. @ 2.0 mils
 Drying at 68°F/20°C	20 mins.
140°F/60°C	—
 Infra red short wave	—
med. wave	—
Sanding:	
Wet by Hand	N/A
Dry by Hand	320 grit
Dry by Machine	280 grit
Pct. solids by wt.	51%
Pct. solids by vol.	32%
VOC as packaged	4.6 lbs./gal. (550 gms/liter)
VOC as applied	4.6 lbs./gal. (550 gms/liter)
Comments:	For highly flexible plastic parts, the use of Limco 891 is recommended. The mix ratio is 2 parts 846 to 1 part 891, then 1-2 parts VR0 or LR0 (depending on temperature, size of the area being primed and the flexibility desired.)