

# 9860 Legacy Universal Primer



## GENERAL INFORMATION

9860 is a Primer / Filler designed to offer superior fill, productive dry, ease of sanding, and excellent adhesion at National Rule Regulations.



## 1. COMPONENTS

- 9860 Universal Primer
- 9730 Fast Activator
- 9740 Medium Activator
- 9750 Slow Activator



## 2. MIXING RATIO

Mix four (4) parts 9860 with one (1) part 9730, 9740 or 9750 (4:1)



## 3. POT LIFE @ 77°F (25°C)

When properly covered at 77°F (25°C), 9860 will maintain a sprayable viscosity for 30 min to 1 hour, depending on activator selection.



## 4. CLEAN UP

Reducers or any acceptable wash thinner with a conductivity in excess of 2000 picosiemens/meter. Thinner or reducers of low conductivity should be avoided as they present an increased risk of combustion via static ignition.



## 5. SURFACE PREPARATION

- Wash surface with mild detergent and rinse with water. Dry surface.
- After drying, sand and featheredge surface where needed.
- Wipe with a post sanding cleaner following manufacturer's directions.



## 6. SUBSTRATES

- Properly treated steel, aluminum and galvanized metals.
- Fiberglass
- SMC
- Properly sanded OEM finishes
- Epoxy Primers
- Etching Primer



## 7. APPLICATION

Number of Coats: 1-3  
 Application Density: Medium-wet to wet  
 Overlap: 50%  
 Flash: 5- 10 min or until surface is dull  
 Film Thickness Range:  
 Dry: 2.0 mils - 3.0 mils  
 Wet: 4.0 mils - 6.5 mils  
 Application Conditions  
 Minimum Temp: 50°F (Substrate Temp.)  
 Max Temp: 100°F (Substrate Temp.)  
 Ambient Humidity: Less than 80% preferred



## 8. FLASH / DRY TIMES

Ambient Application (Reported at 77°F and 80% Humidity)

Flash Between Coats	10 minutes
To Sand/Polish	1 hour
To Topcoat	1 hour

### Force Dry (Convection Heat of 145°F)

Purge time before applying heat	10 minutes
Force Dry Time	20 minutes @ 145° F
Sand and Buff	After cool down



## 9. GUN SET UP

### CONVENTIONAL SPRAY EQUIPMENT

Gravity Feed: 1.4 mm - 1.8 mm tip  
 Siphon Feed: 1.6 mm - 2.0 mm tip

### HVLP (HIGH VOLUME LOW PRESSURE) SPRAY EQUIPMENT

Anest Iwata LPH 400: 1.5 mm - 1.9 mm tip  
 Sagola 450G: 1.5 mm - 1.9 mm tip  
 Sata NR 95 & 2000: 1.5 mm - 1.9 mm tip  
 Binks MG1: 1.5 mm - 1.9 mm tip  
 Geo 92 & 97: 1.5 mm - 1.9 mm tip  
 C.A. Technology: 1.5 mm - 1.9 mm tip  
 Devilbiss GTI: 1.5 mm - 1.9 mm tip



## AIR PRESSURES

### Conventional @ Gun

	PANEL	OVERALL
Gravity Feed	30-40 psi	40-50 psi
Siphon Feed	35-50 psi	50-65 psi

### HVLP @ Cap

8-10 psi	10 psi
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## 10. PHYSICAL DATA

Density	12.49 lbs/gal (unactivated)
Solids By Weight	69.29 %
Solids By Volume	46.26 %
VOC (Volatile Organic Content)	3.72 lbs/gal
Viscosity	33" Zahn #2
Flash Point	-4° F
Theoretical Coverage	742 F2/gal @ 1 mil thickness