LEGACY FINISHES

9870
Legacy 2.1 VOC Universal Primer

GENERAL INFORMATION
9870 is a Primer / Filler designed to offer superior fill, productive dry, ease of sanding, and excellent adhesion at 2.1 VOC.

1. COMPONENTS
- 9870 Universal Primer
- 9730 Fast Activator
- 9740 Medium Activator
- 9750 Slow Activator

2. MIXING RATIO
Mix four (4) parts 9870 with one (1) part 9730, 9740 or 9750 (4:1)

3. POT LIFE @ 77°F (25°C)
When properly covered at 77ºF (25ºC), 9870 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	50ºF (Substrate Temp.)
Max Temp	100ºF (Substrate Temp.)
Ambient Humidity	Less than 80% preferred

8. FLASH / DRY TIMES
Ambient Application (Reported at 77ºF and 80% Humidity)

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

Force Dry (Convection Heat of 145ºF)

Purge time before applying heat	10 minutes
Force Dry Time	20 minutes @ 145º 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

10. PHYSICAL DATA

VOC (PKG) per US gal.	1.61
Viscosity #4 DIN (RTS)	22-28 sec.
Solids by Wt. (RTS)	62.91%
Solids by Vol. (RTS)	48.69%
Sq. Ft. Coverage/ US Gal. @1 mil (RTS)	781
Total HAPS (lb. HAPS/solid gal.)	0.77
VOC (RTS) per US gal.	2.10 max.