OCTORAL

PH254

HIGH PRODUCTION NON-SANDING PRIMER WHITE GS903

GENERAL INFORMATION

PH254 High Production Non-Sanding Primer White GS903 is a multi use polyurethane High Solid (wet on wet) primer. This primer can be used as a general non sanding primer or for properly cleaned ridged unsanded OEM e-Coated panels. For the automotive refinish market, small and larger repairs. Available in White, Mid Grey and Black, White and black can be combined to produce all six Grey Shades, these formulas are accessed on our COINS system. PH254 High Production Non-Sanding Primer White GS903 can be directly applied to properly prepared automotive plastic parts such as, PP-EDM, TPO, ABS, PUR & PA when Octoral PA65 1K Plastic Primer is mixed instead of the thinners.

MIXING RATIO

3 : 1 Primer : MS Hardener + 10% Uni Thinner
3 : 1 Primer : HS Hardener + 10% Uni Thinner
5 : 1 Primer : HS420 Hardener + 25% Uni Thinner

GUN SET UP

	NOZZLE (MM)	AIR PRESSURE (BAR / PSI)
HVLP	1,3-1,4	2/29
HE	1,3-1,4	2/29

APPLICATION

1 coat 30 - 35 µm (1,2-1,4 mil)

FLASH OFF AND DRY TIMES

AIR DRY 20°C / 68°F		FORCED DRY 60°C / 140°F	
Flash off	12 minutes	**Flash off**	Do not forced dry
Dust free	-	**Dust free**	Do not forced dry
Dry to handle	-	**Dry to handle**	Do not forced dry
Dry to tape	-	**Dry to tape**	Do not forced dry
Dry to sand	-	**Dry to sand**	Do not forced dry
Dry to polish	-	**Dry to polish**	Do not forced dry

In case the PH254 High production Non Sanding primer is used in combination with PA65 1K Plastic primer, the adhesion on plastic substrates will develop in time. Optimal adhesion will be achieved after 48 hrs curing, when taking into account the specified layer thickness, flash-off times and drying times.

SUBSTRATES

Properly cleaned unsanded ridged OEM e-Coat panels.
Properly cleaned and sanded original OEM paint system.
Properly cleaned and sanded GRP Glass Fibre Reinforced Polyester laminates PW170 Washprimer. Bare metal not exceeding 10 cm² (PW170 Washprimer recommended).

Painting Plastic Parts: PH254 High Production Non-Sanding Primer White GS903 can be applied directly to properly cleaned and prepared automotive plastic parts. Use the mixing ratios as above and replace the Uni Thinner % with Octoral PA65 1K Plastic Primer. Use over common automotive plastics. This mixture combination can also be used over properly cleaned un-sanded ridged OEM e-Coat panel.

If the gelcoat of the GRP is broken through to the fibres, do NOT use PH254 High Production Non-Sanding Primer White GS903.

COMPONENTS

H35 MS Hardener Medium
H36 MS Hardener Slow
H55 HS Hardener Medium
H56 HS Hardener Slow
H25 HS420 Hardener Medium
H26 HS420 Hardener Slow
TA910 Uni Thinner Medium
TA920 Uni Thinner Slow
PE420 HS420 Special Thinner
PA65 1K Plastic Primer
TA855 Spot Repair Thinner
TA875 Fade-Out Thinner

PE420 HS420 Special Thinner (Recommended for tempertures above 25ºC).

POT LIFE AT 20°C / 68°F

60 minutes

ADDITIVES

AE001 Elastic 2K (add 5-35% volume)

SURFACE PREPARATION

Wash surface with TD80 Octobase Eco Degreaser or mild detergent and water, rinse with water and dry the surface. Wipe surface with TD20 Silicone Remover and wipe dry with a clean cloth before the product flashes off. Final sanding, if needed, P400 if the complete panel will be primed, spot repairs / local priming; final sanding with P500. Wipe surface with TD20 Silicone Remover and wipe dry with a clean cloth before the product evaporates. Plastic surface preparation, refer to the PA65 1K Plastic Primer TDS for full details on the recommended preparation for plastic parts.

Mask entire vehicle to eliminate unwanted overspray.

After 48 hrs thorough sanding with P400 - P500 is needed before the topcoat system can be applied.

NEXT LAYER

W00 - W999 Octobase Eco Plus System
F00 - F98 Octocoat HS420 System
A00 - A98 Octocryl System

In order to obtain the best result we recommend the use of HS420 clears.

valspar AUTOMOTIVE

Revision Date: January 2023

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PHYSICAL DATA

EU REGULATIONS		
VOC Code		2004/42/IIB(c)(540)480
Product sub category (according directive 2004/42/EC) and max VOC content (ISO 11890-1/2) of the ready to use product.		IIB/c. Primer - Surfacer/fi ller and general (metal) primer. EU limit values: 540 g/l. (2007) This product contains a maximum of 480 g/l VOC.
Chemical Base	2K Polyurethane Primer	
Physical Properties	**Viscosity (RTS)**	15 - 17 Dincup 4 / 20°C
	Specific Gravity (kg/l)	1,325
	Flash Point Closed Cup	28°C / 82°F
	Volume % Solids	41,88
	Film Thickness	30 - 35 m
		1,2 - 1,4 mil
	Theoretical Coverage Ready To Spray	14 m²/L/30 m
		570 ft²/Gal/1,2 mil
	Gloss	Low gloss
	Colour	White

PROTECTION

Use suitable respiratory protection *(fresh air supply respirator is strongly recommended).*

For more detailed information please visit the following link for the Safety Data Sheet:

https://sds.octoral.com/en/octoral/choose_localization

CLEAN UP

Gun Cleaner

STORAGE/SHELF LIFE

Minimum 2 years; (Under normal storage conditions 10°C - 30°C / 50°F - 90°F) (unopened container).

NOTES

All reported product properties on the TDS are determined at a temperature of 20°C unless specified otherwise.

Re-cleaning: If batch priming, when the coated object is exposed to an open environment (e.g. outside of a spray booth) the object must be re-cleaned before top-coating with TD20 Silicone Remover, after 1 hour from application and up to 48 hours. Wipe on wipe dry method. Jet washing freshly painted plastic parts is not recommended within one week of recommended paint application and curing process.

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