

**Description**

HIT 1K/Primer Sealer is a 1K low VOC, Phenolic Alkyd Primer with built in corrosion resistance and excellent adhesion onto properly prepared hot or cold roll steel and over properly prepared 2K painted surfaces.

Suggested Uses

As a wet on wet sealer or primer surfacer.

Over hot roll or cold roll steel, fiberglass and sanded 2K coatings where:

- High level of corrosion resistance is needed.
- Excellent adhesion is needed.
- High productivity is required.
- Excellent performance when applied with airless, air-assist airless, airless, pressure pot, cup gun, brush or rolled.
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Components

- #77850-1 1K Primer/Sealer Black
- #77851-1 1K Primer/Sealer White
- #77852-1 1K Primer/Sealer Gray
- #77853-1 1K Primer/Sealer Red

Field Applications

- Structural steel
- Work panel trucks
- Trailers and frames
- Construction equipment
- Many OEM applications
- Oil Field Equipment

Mixing Ratio

Mix: 1K Low VOC High Performance Primer comes ready for use, but can be reduced 0%-10% with selected reducer.

Application

Apply:	One to two medium wet coats, allow 5-10 minutes flash between coats.	
Spray Gun:	HVLP Gravity Feed	1.4 – 1.7mm tip and needle
	Pressure Pot HVLP	1.0 – 1.2mm tip and needle
	Air Assist Airless	1.0 – 1.2mm tip and needle
	Conventional	1.5 – 1.8mm tip and needle
	Airless	310 – 610 – 313 – 613 nozzle
Film Build:	50-75 microns	(2.0 – 3.0 mils.)

**Dry Times**

Dust Free:	20-30 minutes @ 20° C (68° F)
Dry to Topcoat:	30-45 minutes @ 20° C (68° F)
Force Dry:	30 minutes @ 60° C (140° F) light sanding needed.

Surface Preparation**Ferrous metals:**

Best Case	Sandblast - Blow all dust and contaminates off and apply primer within 8 hours.
Second Best Case	Hot Phosphate wash system, blow dry and apply primer. Within 8 hours.
Third Best Case	Careful mechanical abrasion. Clean all dust, oil residue, finger prints and contaminates before and after mechanical abrasion with a clean drying wax and grease removal solvent making sure all residue is removed then apply primer within 4 hours.

Aluminum: Only suitable if Epoxy Primer is applied first

Galvanized Steel: Only suitable if Primer is applied first.

VOC

Regulatory VOC	238.3 g/l (1.98 lbs./gl.)
Actual VOC	131.3 g/l (1.09 lbs./gl.)

Solids

By Volume	51.7%
By Weight	40.6%

Specific Gravity 1.51 kg/l (12.66 lbs./gl.)

Coverage 304.86 square feet per gallon @ 100% transfer efficiency @ 50 microns (2 mils.) 28.3 square meters per gallon @ 100% transfer efficiency @ 50 microns (2 mils)

Repainting After 24 hours @ 20° C (68° F) light sanding needed.

Storage Stability One year, stored in closed package, in cool dry place, away From any sources of heat.

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