



WORLD CLASS™ WATERBORNE FLEXIBLE PRIMER

TECHNICAL DATA SHEET



Check local VOC regulations to ensure compliance of all products in your area.

DESCRIPTION

World Class™ Waterborne Flexible Primer is a water-based flexible surfacer designed for automotive bumper refinishing.

FEATURES

- Superior flexibility and adhesion
- Works as a barrier coat to prevent lifting
- Excellent filling properties
- Easy to sand
- VOC compliant and environmentally friendly
- Saves time and labor
- Ready to spray – no mixing

SUITABLE SUBSTRATES

- Properly prepped OEM finishes.
- Fully cured and prepped refinish material.
- Properly prepped bare plastic (TPO requires the use of an adhesion promoter).
- Plastic repair materials
- Sanded polyester filler & glazing putties.

TYPICAL PROPERTIES

Part:	Product Name:	Color:	Container:
50184	World Class Waterborne Flexible Primer	Neutral Gray	Quart
Weight Solids:	46.1%		
Volume Solids:	33.4%		
Actual VOC:	0.71 #/gal (85 g/l)		
Regulatory VOC:	1.65 #/gal (198 g/l)		

HANDLING AND APPLICATION

Note:

Certain plastics including TPO require the use of an adhesion promoter before coating.



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PREPARATION:

1. Clean surface with **Scuff & Clean** and rinse with water.
2. Next clean with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner** per directions.
3. Sand area to be coated with 320-400 grit paper and clean again with **Plastic & Leather Prep** or **XXX Universal Surface Cleaner**.

MIXING:

Shake or stir product thoroughly before use. **World Class™ Waterborne Flexible Primer** is ready to spray. DO NOT THIN!

APPLICATION:

Prior to spraying, flush gun with **XXX Universal Gun Cleaner** or deionized water.

Using 30-35 psi with non-HVLP equipment or 8-10 psi at the cap with HVLP equipment, apply two medium wet coats, allowing 5-10 minutes flash time between coats.

Dry time is dependent on relative humidity, air circulation and temperature. Curing can be accelerated with a fan or an infrared curing system placed 3-4 feet from the surface. Allow 10 minutes before baking. DO NOT EXCEED 140°F OR BAKE FOR LONGER THAN 30 MINUTES.

Sand **World Class™ Waterborne Flexible Primer** with 320 grit sandpaper and finish with 400-600 grit.

World Class™ Waterborne Flexible Primer can be top coated with **Bumper Coater**, **Factory Pack** and other automotive refinish materials.

CLEANUP:

Clean spray equipment immediately with **XXX Universal Gun Cleaner** or materials compliant in your area.

For further repairing, refinishing and retexturing information see technical document RAB-2.

STORAGE:

World Class™ Waterborne Flexible Primer should be stored in a cool dry place with adequate ventilation away from heat, sparks and flames. Protect from freezing. The shelf life for **World Class™ Waterborne Flexible Primer** is 5 years when stored under normal conditions.



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RELATED PRODUCTS:

Part:	Product Name:	Size:
38391	Scuff & Clean	Gallon
38398	Scuff & Clean	16 oz. Tube
38351	Plastic & Leather Prep	Gallon
38353	Plastic & Leather Prep	16 oz. Aerosol
38354	Plastic & Leather Prep	Quart
77763	XXX Universal Gun Cleaner	20 oz. Aerosol
77771	XXX Universal Surface Cleaner	Gallon
77774	XXX Universal Surface Cleaner	Quart

Technical Consultation Service

Our Technical Staff is ready to assist you with any questions. You are invited to take advantage of our extensive experience, laboratory services and trained field service representatives. Call (800) 831-1122 for answers to your questions. Hours of operation are Monday through Thursday 8:00 am until 5:00 pm EST and on Friday 8:00 am until 4:30 pm EST.

Disclaimer:

The information supplied in this document is for guidance only and should not be construed as a warranty. All implied warranties are expressly disclaimed. All users of the materials are responsible for assuring that it is suitable for their needs, environment and use. All data subject to change as SEM deems appropriate.

Users should review the Safety Data Sheet (SDS) and product label for the material to determine possible health hazards, appropriate engineering controls and precautions to be observed in using the material. Copies of the SDS and product label are available upon request.