DRIVING SURFACE PERFECTION™

TECHNICAL DATA SHEET

Version: 2.0

S2025

HIGH BUILD PRIMER (4:1)



TECHNICAL DATA SHEET & PROCESS GUIDE

A multi-purpose primer offering the functionality of '2 products in 1' - primer filler and primer surfacer. It is suitable for spot repairs to full panel applications. Use with SYSTEM 20 hardeners.

PROPERTIES

- Excellent opactiy and coverage
- Excellent film build surface levelling properties
- Can be air dried, low baked or IR Cured
- Easy to sand with high gloss holdout

Available Colours • Grey • Black • White

U-POL GREY-SHADE is an economical tool to achieve specific shades of grey undercoat resulting in savings on basecoat usage. Use this mixing guide to achieve different shades of grey using White, Grey or Black. For more details visit www.u-pol.com

Colour Mixing Ratio					
S2025W White	100%		75%		
S2025 Grey		100%		50%	
S2025B Black			25%	50%	100%

TECHNICAL DATA

Substrates

- Original Paint
- Mild Steel
- E-coat
- etch primer (for galv/ aluminium)
- SMC
- U-POL Polyester Fillers

	Base	Mixed
Viscosity		40 - 65 s/ DIN 4
Solid content	76.00%	71.00%
Specific gravity g/cm³	1.69	1.54

APPLICATION GUIDE

Tools Required

- SYSTEM 20™ Degreaser
- HVLP Gravity Gun
- MAXIMUM Abrasives
- MAXIMUM Painters Overalls

Hardener Selection

Please note this product is compatible with the S2030 to S2033 range

Temperature ºC	Hardener
-5 -15°C	S2031
5 - 25°C	S2030
15 - 35°C	S2032
25 - +40°C	S2033

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Substrate Preparation

To achieve best results, good preparation is essential. Degrease with U-POL Precleaner (S2000, S2001 or S2002). Abrade the surface:

Original cured paint: wet flat with P320 or dry flat with P280.

Bare Metal (mild steel): abrade with P180.

Aluminium and zinc coated steel: must first be coated with 1-2 light coats of ACID#8 1K Etch Primer and allowed to dry for 20 minutes.

GRP, SMC, Glass fibre, Polyester Filler: dry flat with P240.

E-Coat: no abrasion required

Before applying primer, clean lightly once more with SYSTEM 20 Degreasers and dry thoroughly.

Mixing Ratio	**High Build Primer**	**Primer Surfacer**
S2025: Hardener	**4**:1	**4**:1
20:42 Thinners	nil	< 10%
	Mixing by Weight (grams)	
S2025 Primer	200	200
S2032	29	29
2045 Thinners		13
Viscosity DIN 4 / sec	50 - 65	40 - 45
Working Pot-Life @ 20°C	1 - 2 hours	1 - 2 hours
Compliant HVLP Gravity Gun		
Gun tip size	1.7 - 2.0mm	1.6 - 1.8mm
Air Pressure at the gun	1.8 - 2.0 bar	
Coats	1 - 2 coats	2 - 3 coats
Build / microns	approx 180	100 - 120
Flash-off @ 20°C		
Between coats	15 mins	10 mins
Drying Times		
Sandable @ 20°C	3 - 4 hours	3 - 4 hours
Sandable @ 60°C	30 mins	30 mins

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Sanding

Dry Sanding / Abrasive	P320 - P400	P500 - P600
Wet Sanding / Abrasive	P320 - P400	P500 - P600

Over Painting S2025 Primer formulation can be directly topcoated with most solvent and water-based basecoats or solid colours.

STORAGE & VOC INFORMATION

Shelf Life 2 years from date of manufacture in sealed original containers.

Recommended Storage Temperature 5°C - 25°C

Recommended Application Temperature As per the Hardener Selection table above.

Equipment Cleaning Clean gun Immediately after use with SYSTEM 20 thinner or gunwash.

Important Remarks Do not use activated product beyond pot life.
Activated material should not be returned to the original can of non-activated material. After 10 minutes standing, the paint may need mild agitation to reliquify before 2nd and 3rd coat applications.

VOC Information

The EU limit for this product (product category: IIB.(b) in ready to use form is 540 g/litre. The VOC content of this product in ready to use form is:

			Ready to use VOC (g/l)	
Order Code	**Format**	**Colour**	**High Build Primer**	**Primer Surfacer**
S2025W/1	1L Tin	White Primer	450 g/l	517 g/l
S2025W/3T	3L Tin	White Primer	450 g/l	517 g/l
S2025W/4	4L Tin	White Primer	450 g/l	517 g/l
S2025/1	1L Tin	Grey Primer	446 g/l	513 g/l
S2025/3T	3L Tin	Grey Primer	446 g/l	513 g/l
S2025/4	4L Tin	Grey Primer	446 g/l	513 g/l
S2025B/1	1L Tin	Black Primer	472 g/l	506 g/l
S2025B/3T	3L Tin	Black Primer	472 g/l	506 g/l
S2025B/4	4L Tin	Black Primer	472 g/l	506 g/l

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IMPORTANT: FOR PROFESSIONAL USE ONLY. Read full instructions before use.

This product contains hazardous materials and therefore appropriate personal protective equipment should always be used. Please refer to the label and consult the safety data sheet for full handling instructions and personal protection information. U-POL disclaims any liability where the user does not wear the recommended personal protective equipment. The above data is for information only and may change without prior notice. It is the Buyers responsibility to ensure the suitability of the products for their own use and check the information is up to date. The recommendation of use of our products and application in our technical data sheets are based on our knowledge and experience. These data sheets are available via your local stockist or via the U-POL website at WWW.U-POL.COM. U-POL is not responsible for the results obtained by others over whose methods we have no control and thereof U-POL is not liable for consequential or incidental damages including loss of profits.

U-POL Ltd
4th Floor, The Grange, 100 High Street
London, N14 6BN
WWW.U-POL.COM

UK Sales
T: +44 (0)20 8492 5920
F: +44 (0)20 8150 5605
uk.sales@u-pol.com

International
T: +44 (0)20 8492 5900
F: +44 (0)20 8150 5605
sales@u-pol.com

Technical
T: +44 (0)1933 230 310
F: +44 (0)1933 425 797
technicaldepartment@u-pol.com