



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 opacity 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](http://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

**Viscosity****Base****Mixed****Solid content****Specific gravity g/cm³**

40 - 65 s/ DIN 4  
76.00%  
71.00%  
1.69  
1.54

### APPLICATION GUIDE

**Tools Required**

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

**Hardener Selection**

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

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



DRIVING SURFACE PERFECTION™

TECHNICAL DATA SHEET

Version: 2.0

# S2025

HIGH BUILD PRIMER (4:1)



## TECHNICAL DATA SHEET & PROCESS GUIDE



### 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

**S2025:Hardener**

**20:42** Thinners

### High Build Primer

**4:1**

nil

### Primer Surfacers

**4:1**

< 10%

### Mixing by Weight (grams)

**S2025 Primer**

200

200

**S2032**

29

29

**2045** Thinners

13



### Viscosity DIN 4 / sec

Working Pot-Life @ 20°C

50 - 65

1 - 2 hours

40 - 45

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

Build / microns

1 - 2 coats

approx 180

2 - 3 coats

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



### TECHNICAL DATA SHEET & PROCESS GUIDE



#### 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:

Order Code	Format	Colour	Ready to use VOC (g/l)	
			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



DRIVING SURFACE PERFECTION™

TECHNICAL DATA SHEET

Version: 2.0

# S2025

HIGH BUILD PRIMER (4:1)



## TECHNICAL DATA SHEET & PROCESS GUIDE

**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](http://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

4<sup>th</sup> Floor, The Grange, 100 High Street  
London, N14 6BN  
[WWW.U-POL.COM](http://WWW.U-POL.COM)

### UK Sales

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

### International

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

### Technical

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