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

<table>
<thead>
<tr>
<th>Colour Mixing Ratio</th>
<th>S2025W White</th>
<th>S2025 Grey</th>
<th>S2025B Black</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>100%</td>
<td>100%</td>
<td>100%</td>
</tr>
<tr>
<td></td>
<td>75%</td>
<td>50%</td>
<td>25%</td>
</tr>
<tr>
<td></td>
<td>50%</td>
<td>50%</td>
<td>50%</td>
</tr>
<tr>
<td></td>
<td>100%</td>
<td>100%</td>
<td>100%</td>
</tr>
</tbody>
</table>

**TECHNICAL DATA**

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

**Viscosity**
- Base: 40 - 65 s/ DIN 4
- Mixed: 100%

**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

<table>
<thead>
<tr>
<th>Temperature °C</th>
<th>Hardener</th>
</tr>
</thead>
<tbody>
<tr>
<td>-5 - 15°C</td>
<td>S2031</td>
</tr>
<tr>
<td>5 - 25°C</td>
<td>S2030</td>
</tr>
<tr>
<td>15 - 35°C</td>
<td>S2032</td>
</tr>
<tr>
<td>25 - +40°C</td>
<td>S2033</td>
</tr>
</tbody>
</table>
### 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

<table>
<thead>
<tr>
<th>Component</th>
<th>High Build Primer</th>
<th>Primer Surfacer</th>
</tr>
</thead>
<tbody>
<tr>
<td>S2025:Hardener</td>
<td>4:1</td>
<td>4:1</td>
</tr>
<tr>
<td>20:42 Thinners</td>
<td>nil</td>
<td>&lt; 10%</td>
</tr>
</tbody>
</table>

### Mixing by Weight (grams)

<table>
<thead>
<tr>
<th>Component</th>
<th>High Build Primer</th>
<th>Primer Surfacer</th>
</tr>
</thead>
<tbody>
<tr>
<td>S2025 Primer</td>
<td>200</td>
<td>200</td>
</tr>
<tr>
<td>S2032</td>
<td>29</td>
<td>29</td>
</tr>
<tr>
<td>2045 Thinners</td>
<td></td>
<td>13</td>
</tr>
</tbody>
</table>

### Viscosity DIN 4 / sec

- 50 - 65

### Working Pot-Life @ 20°C

- 1 - 2 hours

### Compliant HVLP Gravity Gun

- **Gun tip size**: 1.7 - 2.0mm
- **Air Pressure at the gun**: 1.8 - 2.0 bar

### Coats

- **Build / microns**: approx 180

### Flash-off @ 20°C

- Between coats: 15 mins

### Drying Times

- **Sandable @ 20°C**: 3 - 4 hours
- **Sandable @ 60°C**: 30 mins
S2025
HIGH BUILD PRIMER (4:1)

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:

<table>
<thead>
<tr>
<th>Order Code</th>
<th>Format</th>
<th>Colour</th>
<th>Ready to use VOC (g/l)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>High Build Primer</td>
<td>Primer Surfacer</td>
</tr>
<tr>
<td>S2025W/1</td>
<td>1L Tin</td>
<td>White Primer</td>
<td>450 g/l</td>
</tr>
<tr>
<td>S2025W/3T</td>
<td>3L Tin</td>
<td>White Primer</td>
<td>450 g/l</td>
</tr>
<tr>
<td>S2025W/4</td>
<td>4L Tin</td>
<td>White Primer</td>
<td>450 g/l</td>
</tr>
<tr>
<td>S2025/1</td>
<td>1L Tin</td>
<td>Grey Primer</td>
<td>446 g/l</td>
</tr>
<tr>
<td>S2025/3T</td>
<td>3L Tin</td>
<td>Grey Primer</td>
<td>446 g/l</td>
</tr>
<tr>
<td>S2025/4</td>
<td>4L Tin</td>
<td>Grey Primer</td>
<td>446 g/l</td>
</tr>
<tr>
<td>S2025B/1</td>
<td>1L Tin</td>
<td>Black Primer</td>
<td>472 g/l</td>
</tr>
<tr>
<td>S2025B/3T</td>
<td>3L Tin</td>
<td>Black Primer</td>
<td>472 g/l</td>
</tr>
<tr>
<td>S2025B/4</td>
<td>4L Tin</td>
<td>Black Primer</td>
<td>472 g/l</td>
</tr>
</tbody>
</table>
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.