



# 2.1 VOC 1K Primer Surfacer-Grey P330-2300

**Description** P330-2300 is a grey, 2.1 low VOC 1K primer surfacer for use in compliant areas where a rapid primer surfacer is required.

<b>Products</b>	2.1 VOC 1K Primer Surfacer-Grey:	P330-2300	
	Thinner:	P830-2034	Compliant Thinner-Fast
		P830-2035	Compliant Thinner-Medium
		P830-2036	Compliant Thinner-Slow

**Suitable for use over:**  
Cleaned and sanded steel, galvanized and aluminum, sanded and cleaned fiberglass and SMC, cleaned and sanded cured OEM and refinish coatings. SX1071 Etch Primer must be applied to bare metal prior to the application of P330-2300.

**Compatible Topcoats:** VALUE-PRO VBX, VBPX, VUX

**Surface Preparation**  
SWX350 H2O-So-Clean, SXA330 Wax and Grease Remover, SX1009 2.9 VOC Bug and Tar Remover.

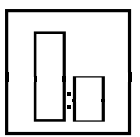
### Sanding



Bare metal: Machine sand 180 - 220 grit

Old finishes: Machine sand 320 - 400 grit on primers and old finishes

### Mixing



Primer:	P330-2300	2 Part
Thinner:	P830-203x	1 Part

Pot Life: 8 hours @ 70°F/21°C      Thoroughly stir before each use.

### Application



HVLP	8 - 10 psi at the air cap
Compliant	29 - 40 psi at the gun
Conventional	40 - 50 psi at the gun
Fluid tip:	1.6 - 1.8 mm or equivalent

Refer to manufacturer's inlet pressure requirements.

---

## Coats



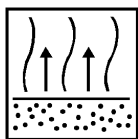
2 - 3 coats

Dry Film Build Per Coat Applied      1.0 mils

Square ft. coverage at 1 mil              247 Sq. ft., gal. @ 100% transfer

---

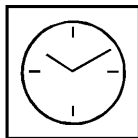
## Flash Time



5-10 minutes between coats @ 70°F/21°C

---

## Drying



30 - 45 minutes to sand and topcoat at 70°F (21°C)

15 - 20 minutes at 140°F (60°C) metal temperature and cool down to sand and topcoat.

---

## I.R

10 - 15 minutes and cool down to sand and topcoat

---

## Clean Up

Clean up equipment immediately after use, using Value-PRO thinner or another suitable solvent. Dispose of waste in accordance with applicable regulations.

---

Primer-Surfacer	Primer-Surfacer
RTS Combinations:	P330-2300 : P830-203x
Volume Ratio:	2 : 1
Applicable Use Category	Primer
VOC Actual (g/L)	54
VOC Actual (lbs/gal)	.45
VOC Regulatory (less water less exempt (g/L)	248 - 249
VOC Regulatory (less water less exempt) (lbs/gal)	2.07 - 2.08
Density (g/L)	1202 - 1248
Density (lbs/gal)	10.0 - 10.4
Volatiles wt. %	72.8 - 73.9
Water wt. %	0.1
Exempt wt. %	68.3 - 69.5
Water vol. %	0.1
Exempt vol. %	78.2 - 78.2

---

See Material Safety Data Sheet and Labels for additional safety information and handling instructions  
EMERGENCY MEDICAL OR SPILL CONTROL INFORMATION:  
USA (412) 434-4515; CANADA (514) 645-1320; MEXICO 91-800-00-214

---