



www.medallionrefinish.com

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## RS-796 / 797

## TECHNICAL DATA

### “Velocity Series” 2.1 V.O.C. 2K Acrylic Urethane Primer

#### DESCRIPTION:

**RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** is a high build, versatile two component system that can be utilized as a primer surfacer and a sealer. **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** dries fast and sands easily without loading the sandpaper. This primer can be sprayed on the backside of properly cleaned e-coated panels without sanding. Formulated with corrosion resistant properties eliminates self-etch primer on cut through and other small bare metal areas. **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** has excellent adhesion and solvent resistance with all topcoat paint systems.

#### FEATURES:

- ✓ Excellent flow out
- ✓ Ultra high build
- ✓ Excellent color hold-out
- ✓ Superior impact resistance
- ✓ Fast cure; can be sanded in 1 hour
- ✓ Guaranteed performance



#### COMPATIBLE SUBSTRATES:

Properly prepared steel  
All properly prepared rigid and semi rigid auto body parts  
All brands of polyester fillers and glazing putties  
Clean, properly sanded O.E.M. or refinish coatings  
Properly prepared aluminum  
Properly cleaned, unsanded inside surfaces of new e-coat parts

**Note:** Recommended that outer surfaces be scuff sanded before applying primer

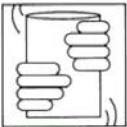


#### INSTRUCTIONS:

Shake and stir the **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** thoroughly before mixing.

#### GUN SETUP:

Conventional Gravity	1.4mm (sealer)	1.6-1.8mm (primer)	40-45 psi @ gun
Siphon	1.4mm (sealer)	1.6-1.8mm (primer)	40-45 psi @ gun
HVLP gravity	1.4mm (sealer)	1.6-1.8mm (primer)	8-10 psi @ gun





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#### MIXING:

High Build Primer Surfacer 2.1 V.O.C.

4 parts **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** to 1 part  
**RS-797 2K Acrylic Urethane Primer Surfacer Activator**

Primer Sealer 2.8 V.O.C.

4 parts **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** to 1 part  
**RS-797 2K Acrylic Urethane Primer Surfacer Activator** to

1 part **Zero V.O.C. Universal Reducer**



**RS-793 Flexible Parts & Anti-Chip Primer Activator** can be used for flexible parts and metal parts for added resilience.

*(Note) For spray temperatures over 100°F (37.8°C) add 1 oz. of **RS-1899 Retarder Solvent** to improve flow, leveling and cure through.*

For faster cure and sand times, add up to 1 oz. of **RS-2050 Super Kick** per paint cup. Accelerating primer will reduce pot life according to amount used.

#### Reducers:

**MRS-165**

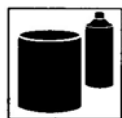
Fast Zero V.O.C. Universal Reducer

**MRS-175**

Medium Zero V.O.C. Universal Reducer

**MRS-185**

Slow Zero V.O.C. Universal Reducer



#### TINTING:

**RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** can be tinted using Rubber Seal Universal Primer Tints or any single stage mixing toner (solid colors only) at no more than 5% by weight (approx. 50 grams per quart of unreduced **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer**).



#### SURFACE PREPARATION:

Wash area with soap and warm water. Thoroughly clean area with **RS-608 Slow Wax and Grease Remover** or **RS-609 Wax and Grease Remover**. **RS-610 Water Base Pre-clean** can be used where VOC restrictions are in effect.

Sand area according to body filler manufacturer's recommendations. Reclean with **RS-608**, **RS-609** or **RS-610**.



*For optimum adhesion and corrosion protection, bare metal surfaces should be coated with a Self Etching Primer or an Epoxy Primer Sealer before applying primer surfacer.*

#### APPLICATION:

Apply 2-3 full wet coats of **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** using a good quality spray gun. Allow 10-15 minutes flash time between coats. Allow 60-90 minutes @ 70°F (21°C) air dry before sanding. **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** can be force dried



**RS-796-TDS**  
Revised 5/08



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#### SANDING:

Allow **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** to thoroughly cure before sanding. Sand primer surfacer with 180-220 grit sandpaper. If applying a sealer over the primer surfacer, finish sand with 320-400 grit sandpaper. If applying topcoat directly over the **RS-796 2.1 V.O.C. 2K Acrylic Urethane Primer** finish sand with 400-500 grit sandpaper when applying basecoat and 320-400 grit sandpaper for single-stage system.

#### TECHNICAL DATA



Color	Grey
Activator/Hardener	797/793
Reducer	MRS-165, MRS-175 or MRS-185
Mix Ratio	4:1 Reducer Optional
Pot Life	90 minutes
Number of Coats	2-3
Flash Time	15 minutes
Recoat w/o sanding	N/A
Dry to Sand	
Air Dry 70°F (21°C) 50% RH	60-90 mins. @70°F (21°C)
Force Dry	15-20 mins. @140°F (60°C)
Gun Set-Up Gravity Feed (HVLP)	1.4mm (sealer) 1.6-1.8 (primer)
Air Pressure @ Gun (HVLP)	8 – 10 psi
Air Pressure @ Gun (Conventional)	40 -45 psi
V.O.C. Limit	2.1 lbs/gal (252 g/l) Primer
Coatings V.O.C.	2.8 lbs/gal (336 g/l) Sealer
Sprayable V.O.C.	1.94 lbs/gal (232 g/l)
	1.8 lbs/gal (216 g/l)
% Solids Sprayable by Weight	61% Primer
Coverage Sq. Ft. / gal @ 1 mil*	50% Sealer*
	726 Primer
	605 Sealer*
Package	Gallon
Number per case	4
Shelf Life	12 months

Material Safety Data Sheet (MSDS) is available on our website

[www.medallionrefinish.com](http://www.medallionrefinish.com)

RUBBER-SEAL

Medallion  
Refinish System

TM

RS-796-TDS  
Revised 5/08