

**Product Description: Stratum Ultra R/I Urethane Primer**

**PRODUCT CODES:** PG-0247...Gray | PG-0248...Off White | PG-0249...Lite Telegray | PG-1246...Mist White  
PG-3249...Buff Yellow | PG-9241...Black

**DESCRIPTION:** The Stratum Ultra Urethane Primer is a two-component, high performance, high solids primer for original equipment manufacturers that require excellent gloss holdout (wet on wet), adhesion, chip resistance, and corrosion resistance. This primer system includes the latest generation of rust inhibitor technologies.

**PHYSICAL PROPERTIES:**

Weight Solids: 61% to 72%  
Volume Solids: 43% to 53%  
Resin Type: Urethane  
Gloss: Semi-Gloss  
Theoretical Coverage: 690 to 840 square feet at 1 mil  
Weight per Gallon: 12.5 pounds  
Blended Viscosity: #2 Zahn - 28 to 30 seconds at 77° F  
EPA VOC: 3.5 pounds per gallon

**SURFACE PREPARATION:** The service expectancy of a coating is primarily dependent upon good surface preparation. The surface to be coated should be free of mill scale, rust, oil, and other contaminants, including salt deposits. Stratum may be applied over steel, aluminum, fiberglass, or galvanized steel. Due to inconsistencies in galvanizing, please check with your local Vogel Industrial representative for recommendations and substrate testing.

Steel: Bare steel areas should be treated with an iron phosphate conversion coatings and adequate rinsing.  
Aluminum/Galvanized: Aluminum and galvanizing should be treated with appropriate metal cleaners and conditioners. For optimum adhesion, hot rolled steel should have the mill scale removed by an abrasive blast to SSPC-SP-6 to an average profile of 1.5 mils and then coated before flash rusting occurs.

**ACTIVATION:**

Mixing Ratio: 6A:1B with either PG-0231, IG-0267, IG-0268 or IG-0299  
Sweat-In Time: None  
Pot Life: Approximately 2 hours at 77° F

**REDUCTION:**

Airless: For airless application no reduction is necessary.  
Conventional Air: For conventional air spray some reduction may be necessary. Use Butyl Acetate or Toluol for reducing purposes.

**APPLICATION:**

Airless: Airless tip sizes should be in the .011 to .017 range. Adjust pressures accordingly for best atomization and transfer efficiencies. Air-assist airless pressures will be in the 800 to 1000 pound range for fluid and 30 to 50 pound range for atomizing air.  
Conventional Air: Pressures are dependent upon the type of gun and fluid nozzle, but typically will be in the 45 to 60 pound range for proper atomization.  
In-Line Heat: In-line heat may be utilized up to 100°F to improve application. Caution must be exercised to turn heat off during breaks and shut downs to avoid locking up the paint lines due to decrease in material pot life.  
Dry Film Thickness: For best results, dry film thicknesses should be 1.0 to 2.0 mils above surface profile. This will require wet film thicknesses of about 3.0 to 4.0 mils. Apply in one wet coat.

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- DRY TIMES:** Recoat times may vary according to film thicknesses and curing conditions, but typically Stratum can be recoated after tack free or approximately 15 to 30 minutes. Stratum can also be force dried to desired hardness at 160°F. After 48 hours or force drying care must be taken to ensure adequate inter-coat adhesion. Typically the primer will then need to be thoroughly scuff sanded after 48 hours for inter-coat adhesion.
- CLEAN UP:** Use butyl acetate or ketones to flush application lines and equipment.
- PERFORMANCE:** Typical, tested on B-1000 panels at 1.0 to 1.3 mils DFT
- Salt Spray: ASTM B-117 – 1,000 hours – less than 1 mm creep
- Fluid Testing: #2 Diesel – 500 hours – no corrosion or blistering  
10W30 Oil – 500 hours – no corrosion or blistering  
Water – 500 hours – no corrosion or blistering
- Gravelometer: ASTM D-3170 – 6A Excellent (SAE J400)
- SAFETY PRECAUTIONS:** Contains aliphatic polyisocyanate, hexamethylene, diisocyanate, and butyl acetate when blended. Avoid contact with skin. Vapor and spray mist harmful. Use proper respiratory protection, including positive air supplied respirators. Refer to SDS for specific information. All information subject to change without notice.