FINAL SYSTEMS™

Technical Data Sheet

Date: 06-October-2026
Product Code: FL2019

ULTIMATE 2K HB PRIMER 4:1

ULTIMATE 2K HB Primer 4:1 is a versatile high-build primer suitable for use on a variety of substrates. It can be applied as a compact primer for minimal sanding, wet-on-wet primer or as a high-build primer filler to help level imperfections. The primer dries quickly, provides excellent build, and sands easily for efficient surface preparation. ULTIMATE 2K HB Primer 4:1 is available in Black, Grey and White.

Preparation

Surfaces must be clean, dry and free from dust, grease, oil or millscale etc. Carry out test spray before application.
Can be applied under solvent and waterborne basecoats.

Application

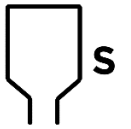
ULTIMATE 2K HB Primer 4:1 is a versatile primer and can be applied as either a High Build Primer, Compact Primer or Wet-On-Wet Primer. To get the desired primer results please follow the appropriate application methods.

<u>Application Methods:</u>
High Build Primer – page 2
Compact Primer – page 3
Wet-On-Wet Primer – page 4

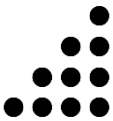
	Health and safety “For professional use only” Important: When using any new product, consult the “Health and Safety” data sheet. Always read the risks and precautions stated on the product label.

High Build Primer Application

<table>
<tr><td> </td><td colspan="2">ULTIMATE 2K HB Primer 4:1
Mix Ratio 4 : 1 : 10%

4 part FL2019 ULTIMATE 2K HB Primer 4:1
1 part FL2050 ULTIMATE 2K HS Fast Hardener
10% FL2021/FL2022 Final Systems 2K Thinner</td></tr>
<tr><td>  </td><td>Spray Viscosity

32 - 34 seconds DIN4 at 20°C</td><td>Spray Pressure

30 – 35 PSI</td></tr>
<tr><td> </td><td colspan="2">Spray Gun Fluid Tip
HVLP Gravity feed fluid tip 1.6 - 1.8 mm</td></tr>
<tr><td>  </td><td colspan="2">Film Thickness
120 – 140 microns</td></tr>
<tr><td> </td><td colspan="2">No. of coats 2
Pot Life Approx. 1 - 1 ½ hours at 20°C depending on hardener speed</td></tr>
<tr><td> </td><td colspan="2">Drying Times at 20°C

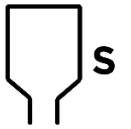
Flash Off (Between Coats) — 5 to 10 minutes
Flash Off (Before Baking) — 5 to 10 minutes
Air Dry — 3 to 4 hours

<table><tr><th>Hardener</th><th>Bake Time (60°C)</th><th>IR Drying Time</th></tr><tr><td>Fast</td><td>20 minutes</td><td>8-10 minutes</td></tr></table>
Accelerators such as Final Systems Rocket Fuel should NOT be used with ULTIMATE 2K HB Primer 4:1.
ULTIMATE 2K HS Hardener Fast speed is suited to this product.</td></tr>
</table>

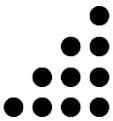
ULTIMATE 2K HB Primer 4:1

Compact Primer Application

<table>
<tr><td> </td><td colspan="2">ULTIMATE 2K HB Primer 4:1
Mix Ratio 4 : 1 : 20%

4 part FL2019 ULTIMATE 2K HB Primer 4:1
1 part FL2050 ULTIMATE 2K HS Fast Hardener
20% FL2021/FL2022 Final Systems 2K Thinner</td></tr>
<tr><td>  </td><td>Spray Viscosity

20 - 24 seconds DIN4 at 20°C</td><td>Spray Pressure

30 – 35 PSI</td></tr>
<tr><td> </td><td colspan="2">Spray Gun Fluid Tip
HVLP Gravity feed fluid tip 1.4 - 1.6 mm</td></tr>
<tr><td>  </td><td colspan="2">Film Thickness
60 – 70 microns</td></tr>
<tr><td> </td><td colspan="2">No. of coats 2
Pot Life Approx. 1 - 1 ½ hours at 20°C depending on hardener speed</td></tr>
<tr><td> </td><td colspan="2">Drying Times at 20°C

Flash Off (Between Coats) — 5 to 10 minutes
Flash Off (Before Baking) — 5 to 10 minutes
Air Dry — 3 to 4 hours

<table><tr><th>Hardener</th><th>Bake Time (60°C)</th><th>IR Drying Time</th></tr><tr><td>Fast</td><td>20 minutes</td><td>8-10 minutes</td></tr></table>
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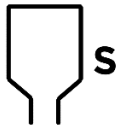
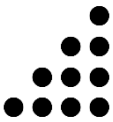
ULTIMATE 2K HS Hardener Fast speed is suited to this product.</td></tr>
</table>

Wet-On-Wet (WOW) Application

	ULTIMATE 2K HB Primer 4:1 Mix Ratio 4 : 1 : 30% 4 part FL2019 ULTIMATE 2K HB Primer 4:1 1 part FL2050 ULTIMATE 2K HS Fast Hardener 30% FL2021/FL2022 Final Systems 2K Thinner	
	Spray Viscosity 16 - 18 seconds DIN4 at 20°C	Spray Pressure 30 – 35 PSI
	Spray Gun Fluid Tip HVLP Gravity feed fluid tip 1.3 - 1.4 mm	
	Film Thickness 30 – 35 microns	
	No. of coats 1 Pot Life Approx. 1 - 1 ½ hours at 20°C depending on hardener speed	
	Drying Times at 20°C Flash Off (Before Baking) Air Dry	 5 to 10 minutes 30 to 40 minutes

Hardener	Bake Time (60°C)	IR Drying Time
Fast	10 minutes	8-10 minutes

Accelerators such as Final Systems Rocket Fuel should NOT be used with ULTIMATE 2K HB Primer 4:1.
ULTIMATE 2K HS Hardener Fast speed is suited to this product.

Wet-On-Wet Primer must be overcoated within 12 hours.

Technical Information

24 month shelf life when correctly stored in closed original container. Always replace and firmly close lid immediately after use.

Flash Point	31°C
Composition	Acrylic Resins
Colour	Black, Grey or White
Gloss	Matt
VOC (EC)	<540g/L in RFU (Ready for Use) form
Sanding – Dry Flat	P320 - P500
Sanding – Wet Flat	P600 - P800

Health & Safety

Refer to relevant Health & Safety or Material Safety Data Sheets.

The technical data contained herein is based on our present knowledge and experience. We cannot be held liable for any errors, inaccuracies, omissions or editorial failings that result from technological changes or research between the date of issue of this document and the date the product is acquired. Before using the product, the user should carry out any necessary tests to ensure that the product is suitable for the intended application. All users should contact the seller or the manufacturer of the product for additional technical information concerning its use if they think that the information in their possession needs to be clarified in any way, whether for normal use or a specific application of the product. Our guarantee applies within the context of the statutory regulations and provisions in force, current professional standards and in accordance with the stipulations set out in our general sales conditions. The information detailed in the present technical data sheet is given by way of indication and is not exhaustive. The same applies to any information provided verbally by telephone to any prospective or existing customer.