

Line: 2k primers Category: Primer products	Type: 5:1 acrylic primer (sufacer) Code: 1051.02 (Grey); 1051.03 (White); 1051.04 (Black)
---	--

Name or commercial logo: **PRIMER SURFACER**

Nature: two-component chemical paste with a base of inert mineral fillers and additives dispersed in unsaturated acrylic resins with high content of solids (HS). They polymerize through polysocyanic resins in concentration in ratio 5:1.

Use: bivalent products intended to be used as coats immediately applied before the finishing coat, to guarantee the adhesion of the finishing coat, in order to obtain an uniform surface filling the small imperfections on the surface itself (spray filling primer). By increasing the dilution rate, they can be used as insulating primers. Featured by good anticorrosive qualities, they can directly applied on steel and iron sheets, on galvanized sheets (electrolytic/galvanized) previously roughened, on surfaces previously handled with polyester or epoxy fillers or primers and on UP-GF surfaces. If applied on old varnishes, make sure that they are completely dried and that they are not of acrylic thermosetting or elastic natured. They are compatible with water-based coats.

- Peculiarities:**
- high-filling capacity, high flexibility and thixotropy, excellent sanding, the primers can be used both for total paintings (or full boarding) and for patchings and retouchings;
 - the 3 primers can be mixed in order to obtain the underlying tone that favors the best tone of the finishing coat;
 - quick-drying, both at air and in oven, PRIMER SURFACER can be exposed at quick-drying systems or at IR rays.

Physical features:









Aspect: Color: Odour: Specific weight:	Dense liquid Grey, White or Black Typical of solvent. 1,540 kg/l (± 0,030 kg/l) - Gray 1,580 Kg/l (± 0,030 Kg/l) - White 1,490 Kg/l (± 0,030 Kg/l) - Black	Supply viscosity: Dry residue (mix A+B): Theoretical yield (mix A+B+C)	33,8 Pa*s (Brookfield: RV 4, rpm 5) 71% (±2%) m ² /l per 100 µm <u>Grey</u> <u>White</u> <u>Black</u> Spray filling primer: 4,4 4,3 4,5 m ² /l Primer (surface): 4,1 4,0 4,2 m ² /l
---	---	--	---

<u>Directive 2004/42/CE:</u>	all. II B/c - Primer, Surfacer/filler and general (metal) primer, maximum VOC content limit value expressed in g/l (ready for use product 1.1.2007):	540
	PRIMER SURFACER ready for use (<u>white</u>) (+20% CAT 2K FILL hardener +35% ACRYLDIL thinner):	White: 537
	PRIMER SURFACER ready for use (<u>grey</u> and <u>black</u>) (+20% CAT 2K FILL hardener +25% ACRYLDIL thinner):	Grey: 499 Black: 498

Applicative data:

	If applied on bare metal, sand the surface with paper grain P 120; if applied on polyester fillers and primers or on old varnishes, sand the surface with paper grain P 320; if applied on brand new metal sheets sand with medium Scotch-Brite. Then eliminate any trace of grease, oils, silicone, fingerprints, glues, detaching wax (over UP-GF) and dust by mean of an antsilicones thinner for washing (our type NOSIL SN/184).										
	PRIMER SURFACER primer:	<u>Filling</u>	Grey	Black	<u>Insulating</u>	Grey	Black	<u>Filling</u>	White	<u>Insulating</u>	White
	CAT 2K FILL hardener:	100 ml	100 g	100 g	100 ml	100 g	100 g	100 ml	100 g	100 ml	100 g
	ACRYLDIL thinner:	20 ml	12,6 g	13,1 g	20 ml	12,6 g	13,1 g	20 ml	12,3 g	20 ml	12,3 g
		15 ml	8,8 g	9,1 g	25 ml	14,7 g	15,2 g	25 ml	14,3 g	35 ml	20,0 g
	Mix carefully in an empty container, filter and pour into airbrush cup.										
	Pot life at 23 °C:	<u>Filling</u>	<u>Insulating</u>			Application viscosity:		<u>Filling</u>	<u>Insulating</u>		
		30'	45'			Ford Cup Ø 4 at 23 °C:		40"	30"		
	<u>Filling primer</u>	Type	Ø nozzle	Pressure		N. coats:		<u>Filling</u>	<u>Insulating</u>		
	Standard:		1,8	4,0 bar		Max thickness / coat:		1 - 2	1		
	HVLP / LVLP:		2,2	2,5 bar		Time between coats:		110 µm	50 µm		
	<u>Insulating primer</u>	Type				Recommended thickness (dry film):		5' - 8'	220 µm		
	Standard:		1,4	3,0 bar					50 µm		
	HVLP/LVLP:		1,9	2,0 bar							
	Dust free at 23 °C:	<u>Filling</u>	<u>Insulating</u>			Ready for sanding:		<u>Filling</u>	<u>Insulating</u>		
		10'	8'			At air at 23 °C:		5 h	3 h		
						In oven at 60 °C:		45'	30'		
	When used as wet-on-wet primer, for better result dilute the hardened product (5:1) with a maximum of 25% (for the grey and black color) or 35% (for the white color) of our type ACRYLDIL acrylic thinner. Apply an half-coat of mixture on the edges and the whole surface to treat followed by an uniform coat after few minutes of waiting. Leave to wither for 30' before applying the next finishing layer (water-based paint or solvent-based paint if allowed). Given the thin coat, it's not recommended to adopt this procedure in presence of support treated by putties, although perfectly leveled.										



	Ready for sanding, short waves:	<u>Filling</u> 8'	<u>Insulating</u> 7"		Total desiccation at 23 °C:	<u>Filling</u> 30 h	<u>Insulating</u> 24 h
	Roughing out P 280 Finishing P 400		Roughing out P 320 Finishing P 500			Roughing out: P 400 Finishing: P 800	
	The product lifetime is 12 months from delivery date, if the product is stored in a dry place at temperature between 10 °C and 35 °C, in unopened original containers, away from flames and sparks, according to general sales conditions.						
Warnings & Precautions:							
	<ul style="list-style-type: none"> - Read carefully the Safety Data Sheet before use; - Product specifically for PROFESSIONAL USE; - Do not apply the product with humidity levels higher than 70%; - Observe the current legislation about the use of polyurethane products; - Do not apply the filler on cold supports, its sticking power and thixotropy would be compromised; - If applied on old varnishes, be sure they are completely dried and cracks free; avoid patchings and apply at full brush; - Do not apply on thickness over 220 µm which reduces to 100 µm when desiccation is made through IR rays, respecting times and distances provided by the supplier of the equipment. 						

Consumer information:

The information here contained are based on our knowledge at the moment. We reserve the right to make changes in the characteristic data of the product in relation with technological progress or productive developments. Due to factors beyond our control in the applicative phase of the product, the information here contained are not a form of guarantee for specific qualities of the product itself, nor its suitability for a specific application. If a responsibility is determined, this will be limited to the value of the provided products used by the consumer. We guarantee however the constancy in the quality of our products. Our responsibility concerns only the area of the General Sales Conditions. This Technical Data Sheet supersedes all the previous.

