

Line: 2k primers Category: Primer products	Type: 5:1 acrylic primer (surfacers) Code: 1051.05 (Light grey); 1051.06 (Dark grey)
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Name or commercial logo: **SURFACER ACRILICO 8515**

Nature: two-component chemical paste with a base of inert mineral fillers and additives dispersed in solvents and acrylic resins with high content of solids (HS); low emission of COV. It polymerizes through polysocyanic resins in concentration in ratio 5:1.

Use: coating intended to be applied for the first coat as spray filling primer. Featured by good anticorrosive qualities, it can directly be applied on steel and iron sheets, on galvanized sheets (electrolytic/galvanized) previously roughened; on surfaces previously handled with polyester 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. It is compatible with water-based coats. After sanding and careful cleaning of the surface, it can be applied also on aluminum parts.
















- Peculiarities:**
- high-filling capacity, low viscosity, it can be diluted till 10% with emission of COV that doesn't exceed the parameters provided by Directive 2004/42/CE;
 - high flexibility and thixotropy, the primer makes a self-leveling final surface, very ductile for sanding and characterized by trifling fall;
 - ACRYLIC SURFACER 8515 can be used both for total paintings (or full boarding) and for patches and retouchings. It can be mixed, not over 10%, with bases of solvent acrylic systems in order to obtain a tone similar to the finishing paint. In this case, it can be used only for uses not regulated by the aforementioned directive;
 - quick-drying, both at air and in oven, in order to quick the drying, the primer can be exposed at quick-drying systems or at IR rays.

Physical features:

Aspect:	Dense liquid	Supply viscosity:	21,4 Pa*s (Brookfield: RV 4, rpm 5)
Color:	Light grey or Dark grey	Dry residue (mix A+B):	71% (±2%)
Odour:	Typical of solvent	Theoretical yield (mix A+B+C):	4,6 m ² /l per 100 µm
Specific weight:	1,680 kg/l (± 0,050 kg/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
	ACRYLIC SURFACER 8515 ready for use (+20% HARD SA 1515 hardener +10% ACRYLDIL thinner):	487

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 antisolicones thinner for washing (our type NOSIL SN/184).		
	Primer ACRYLIC SURFACER 8515: 100 ml 100 g Hardener HARD SA 1515: 20 ml 11,6 g Thinner ACRYDIL: 10 ml 5,4 g	Mix carefully in an empty container, filter and pour into airbrush cup.	
	Pot life at 23 °C: 100'		Apply viscosity FC Ø 4 at 23 °C: 30"
	Type Ø nozzle pressure Standard: 1,7 - 1,9 3,5 bar HVLP / LVLP 1,7 2,2 bar		N. coats: 1 to 3 Max thickness recommended (dry film): 250 µm Time between coats: 8' - 10'
	Dust free at 23 °C: 20'		Ready for sanding: At air at 23 °C: 5 h In oven at 60 °C: 45'
	Ready for sanding short waves: 10'		Total desiccation: 28 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:

- Read carefully the Safety Data Sheet before use;
- Product specifically for PROFESSIONAL USE;
- Do not apply the product with humidity levels higher than 70%;
- During use 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 boarding;
- In the presence of polyacrylic bases or paints, make only retouchings;
- Do not apply on thickness over 150 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.

