

## 996 2K 4:1 High Build Primer TDS

Available in Grey/Beige

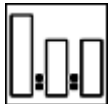
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### DESCRIPTION

2K-4:1 HS High Build Primer is a top quality, 2 pack acrylic primer-filler, available in a range of colours, it contains anti-corrosive pigments and is chromate-free. It has excellent application properties, is quick drying and is easy to sand. It is suitable for many different substrates including correctly prepared bare steel, fibreglass and sound original finishes. For maximum adhesion to aluminium an etch primer should first be applied. It is suitable for use under a wide variety of topcoats particularly 2K acrylics and basecoat clear systems.

### PREPARATION OF SUBSTRATE

- 1- Bare steel: Clean with pre cleaning solvent, sand with P180 and clean again with pre cleaning solvent.
- 2- Aluminium and Galvanised Substrates: As for bare steel but then apply an etch primer and allow to dry for 1 hour prior to application of the 2K 4:1 HB High Build Primer.
- 3- Fibre Glass: Remove release agent with warm soapy water. Rinse, dry and clean with pre cleaning solvent. Sand surface with P180. Clean again with pre cleaning solvent.
- 4- Previously Painted Surfaces in sound condition: Clean with suitable pre cleaning solvent, sand with P180 and clean again with pre cleaning solvent.



#### MIXING

Mix

by volume 4 parts 2K 4:1 HB High Build Primer: 1 part 2K Primer Hardener. Up to 30% by volume of 2K Fast Thinner may be added as required. The recommended spray viscosity is 18 sec. DIN 4 @ 20 ° C.

The mixing ratio by weight is 7 parts 2K 4:1 HB High Build Primer: 1 part 2K Primer Hardener. Up to 20% by weight of 2K Fast Thinner may be added as required.



#### DRYING

Air

**Drying:** At 20°C the film is dust dry after 30 minutes, may be handled with care after 90 minutes and may be re-coated after drying overnight (8hours).

**Stoving:** 25 minutes at 60°C (panel temperature)  
12 minutes at 80°C (panel temperature)

**Infra-Red:** 10-15 minutes using conventional infrared.

**Note:** Air-drying and stoving times can be reduced by using Rocket Fuel.

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## F40 2K 4:1 High Build Primer TDS

Available in Grey/White/Beige

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**RE-WORKING:** After cooling following the above stoving schedules, defects and runs can be removed using P1200 Wet or Dry. The paint surface can then be polished using a fine polishing paste or an ammonia-free compound.

**FLASH POINT:** 22°C – 32°C

**STORAGE:** Unmixed, correctly stored material, in firmly closed original containers, has a shelf life of over 1 year. Contents of opened containers should be used up quickly. Always replace hardener caps immediately. Hardened mixtures cannot be stored.

**HEALTH AND SAFETY:** Please refer to Health and Safety Data Sheet.

The technical data contained herein is based on our present knowledge and we experience and 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.

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