

CAR REFINISH PAINTS

5+1 ACRYLIC PRIMER (2K) (435-7D13)

Materials	5+1 Acrylic Primer		435-7D13
	5+1 Hardener		871-0A90
	Universal Thinner	fast	803-9350
	Universal Thinner	normal	803-9391
	Universal Thinner	slow	803-9316
Application / Properties :	<div><div>- It has an excellent durability against solvents and negative air conditions.</div><div>- Easy sandability. After 2 hours of applications at air temperature it can be easily sand.</div><div>- It has fast drying.</div><div>- It's filling property is perfect</div></div>		
Substrate/Pretreatment	Cleaning	Sanding	Subsequent Cleaning
Well Cured Old Paint Work	822-9305	P 320-360	822-9305
O.E.M Spare Parts (with primer)	822-9305	P 320-360	822-9305
Bare Metal	822-9305	P 80-150	822-9305
Zinc plated steel	1K Wash Primer (520-7510) should be applied.		
Aluminium	Firstly 1K Wash Primer (520-7510) should be applied.		
Polyester (fiberglass) surfaces	435-7D13 5+1 Acrylic Primer should be applied on polyester surfaces directly.		
Applicable Topcoats	All kind of acrylic , cellulosic and synthetic Dyo products.		
Remarks	<div><div>- For air drying a minumum temperature of +15°C is required.</div></div>		

PROCESSING DATA	5+1 ACRYLIC PRIMER (2K) (435-7D13)
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Mixing ratio	5:1:1
Primer	100 % 5+1 Acrylic Primer (435-7D13)
Hardener	25 % 871-0A90
Reducer	25% 803-9391
Potlife at 20 °C	1 hours
Spray viscosity(DIN CUP4) 20°C	28-32 seconds
Gravity gun nuzzle	1.8-2.2 mm
Suction gun nuzzle	1.7-1.8 mm
Pressure	3-5 bar
Spraycoats	2
Dry film thickness	70-80 microns
Flash off time 20°C	5-10 minutes
Drying at 20°C 60°C	120 minutes 30 minutes
Infra red short wave long wave	7 minutes 10 minutes
Sanding (wet) (dry)	P600-800 P400-500
Comments	Choose hardeners and reducers according to temperature and size of object to be painted.
Shelf life	In its unopened container mininum 2 year at room temperature.
Health and Safety Aspects	Please carefully read the health and safety instructions given on product container label. Users of this product are responsible to eliminate the related application wastes accordingly. Also, necessary precautions must be taken during transportation usage and storage.

**Comply with the guidlines on working with Polyurethanes, i.e. Hardeners 871-0160/0271/0273/0274 contain isocyanate.
Use only in well ventilated areas.Wear air breathing apparatus.**

This technical information being to the latest standard of technology and contained in this leaflet is to be understood as advice only and not binding in any respect.All details about working with our products should be adapted to prevailing local conditions and materials used. Best results could only be obtained by using appropriate application parameters and equipment. Patents , if any , must be observed.
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