

CAR REFINISH PAINTS

4+1 EXPRESS PRIMER (2K) (533-7F13)

Materials	4+1 Express Primer		533-7F13
	4+1 Hardener		871-0A90
	Universal Thinner	fast	803-9350
	Universal Thinner	normal	803-9391
	Universal Thinner	slow	803-9316
Application / Properties :	It is designed for fast jobs that need to be completed on the same day. It is a high filling primer. It is fast to dry. It is easy to sand and dry sandpaper. Sanding can be done on the same day. It has excellent resistance to solvents and heavy weather conditions. Its propagation feature to the topcoat is excellent. It is very good adhesion to hair and galvanized surfaces. Stock stability is excellent.		
Substrate/Pretreatment	Cleaning	Sanding	Subsequent Cleaning
Well Cured Old Paint Work	822-9305	P 240-320	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
Applicable Topcoats	All kind of acrylic, cellulosic and synthetic Dyo products.		

PROCESSING DATA**4+1 EXPRESS PRIMER (2K) (533-7F13)**

Mixing ratio Primer	4:1:1 100 % 4+1 Express Primer (533-7F13)
Hardener	25 % 871-0A90
Reducer	25% 803-9391
Potlife at 20 °C	1 hours
Spray viscosity(DIN CUP4) 20°C	20-24 seconds
Gravity gun nuzzle	1.4-1.6 mm
Suction gun nuzzle	1.6-1.8 mm
Pressure	3-4 bar
Spraycoats	2
Dry film thickness	70-80 microns
Flash off time 20°C	5-10 minutes
Drying at 20°C 60°C	2 hours 30 minutes
Infra red short wave long wave	7 minutes 10 minutes
Sanding (wet) (dry)	P600-800 P360-400
Comments	The hardeners and thinners to be used should be selected according to the ambient temperature and the size of the part to be painted. Drying time should be extended depending on the number of coats in applications over 150 microns.
Shelf life	In its unopened container minumum 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.

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. All rights reserved.