

Technical Information

20-24, 20-34, 20-94



High build application

Process for primerfiller, high build application

- High solids containing primer filler, fast drying and easy sandability
- Repairs with larger bare metal areas should prior be treated with 27-10 2K Wash primer
- Can be intermixed to get different grey shades, according to the grey shade poster. Formulas available in formula finder.

Application

	Mixing Ratio	100 % by volume	20-24, -34, -94
	4:1+10 %	25 % by volume	50-05, -15
		10 % by volume	60-05, -10, -20, -30, -40
	Spray viscosity at 20°C	DIN 4: 22-25 s	
	Potlife at 20°C	30 min	
	HVLP spray gun		
	Nozzle size	1.6-1.8	
	Application pressure	2 bar	
	Nozzle pressure	0.7 bar	
	Compliant gravity-feed spray gun		
	Nozzle Size	1.6-1.8	
	Application Pressure	2 bar	
	Number of spray coats	3 -4	
	Film thickness	100-200 µm	

Safety advice:

2004/42/IIIB(cII)(540)530: The EU limit value for this product (product category: IIB.cII) in ready to use form is max 540 g/l of VOC. The VOC content of this product is 530 g/l.

The products are suitable for professional use only.

It cannot be ruled out that this product contains particles < 0.1 µm.

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.



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Drying

		50-05, 60-05	50-15, 60-10, -20, -30
	Drying at 20°C	2-3 h	8 h
	Drying at 60°C		40 min
	Infrared (short wave)		8 min
	Infrared (medium wave)		10-15 min

Sanding

		
	Sanding manual, wet	P800
	Orbital sanding, dry	P400 / P500

Please note: For automotive refinish, repair instructions of vehicle manufacturers, in particular regarding installed sensor technology, must always be observed in addition to the processing instructions given within this document.

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