Art.-No.:6.4450.0020

4450

2K Acrylic Primer

Characteristics

High build, fast drying primer of excellent corrosion resistance. Wet-on-wet processing is possible. Excellent adhesion to ferrous substrates, steel, GFK, aluminium and galvanised substrates. Can be recoated with all usual 1K and 2K paint systems.

V.O.C. Value

EU limiting value for the product (cat. B/c): 540 g/l (2007)
This product contains max. 533 g/l VOC [4.45 lbs/gal]

Tech Tip

When used as adhesion promoter on hard aluminium ensure a coat thickness of 20-25 µm.
Not intended for overcoating with solvent based 2 layers metallic basecoats.

Application

Air / Flowjar – Spray gun
Spraying pressure: 3 - 5 bar
Spraying nozzle: 1.1 -1.4 mm
Spraying operations: 2 - 3

Airless / Airmix
Spraying pressure: 120 - 150 bar
Spraying nozzle: 0.28 - 0.33 mm
Spraying operations: 2

Coat thickness / dry film: 25 - 80 µm according to the application process.

Drying
Object Temp. 20°C: dust dry after 35 - 40 min., set to touch after 85 - 95 min.
Object Temp. 60°C: dust dry after 10 - 15 min., set to touch after 20 - 30 min.

Process conditions from + 10°C and up to 80 % relative air humidity.

Technical Data

Consumption	8 - 10 m²/l (30 µm coat thickness)
Colour	light grey
Mixing ratio	10 : 1 by weight; 7 : 1 by volume
Hardener	4CR 0407
Dilution	4CR 0505 (15 - 20 %)
Spraying viscosity 20°C	18 - 22 s 4 mm DIN, Airless 40 - 50 s 4 mm DIN

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Pot life	8 - 10
Curing time / Flash off time	10 min.

Storage and Transportation

At least 3 yers shelf life in tightly closed original containers.

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