

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

V2012 Polyurethane Acrylic Primer HS 4:1

PRODUCT

Polyurethane Acrylic primer HS V2012 4:1 – Filling and isolating primer for galvanized steel.
Hardener 1:4 for Polyurethane Acrylic Primer V2012.
Reducer for polyurethane acrylic systems.

PRODUCT DESCRIPTION

High quality 2-pack acrylic anticorrosive undercoat with excellent adhesion to steel, aluminum, galvanized steel, polyester body fillers and putties, and old coatings. Designed especially for car refinish.

- ✓ Excellent adhesion to difficult substrates.
- ✓ Easy to mixing and apply.
- ✓ Exceptional vertical stability.
- ✓ Good filling and isolation properties.
- ✓ Easy to sanding.

Colour – White, Light Grey, Black.

Gloss – Matt.

VOLATILE ORGANIC COMPOUNDS

VOC = 2.1 lbs/gal.

SUBSTRATE PREPARATION

V2012 primer can be applied over:

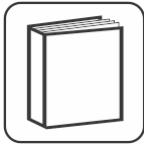

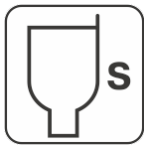
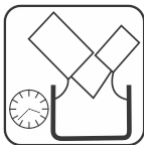

- ✓ Steel and aluminum after sanding and degreased.
- ✓ Galvanized steel after sanding and degreased.
- ✓ Sanded polyester glass laminates (GFK/GRP).
- ✓ 2-pack polyester putties, polyester spraying fillers.
- ✓ Wash primers.
- ✓ 2-pack acryl fillers.
- ✓ 2-pack epoxy fillers.

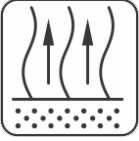




- ✓ Old finishes in good condition after sanded and degreased.

Good Surface preparation is necessary to achieve the best results of repairs. Recommended abrasive paper with gradation as follows:

- grinding by hand (dry or wet) : P280÷P320 (GRP P400).
- grinding by machine (dry) : P180÷P220.

APPLICATION PROCESS

	<p>Application For car refinish as a filling primer or isolating coating.</p>						
	<p>Mixing Ratio by volume</p> <table style="width: 100%; border: none;"> <tr> <td style="width: 60%;">Primer</td> <td style="text-align: right;">4</td> </tr> <tr> <td>Hardener</td> <td style="text-align: right;">1</td> </tr> <tr> <td>Thinner</td> <td style="text-align: right;">10% - 15%</td> </tr> </table> <p>Mix well until smooth mixture is achieved</p>	Primer	4	Hardener	1	Thinner	10% - 15%
Primer	4						
Hardener	1						
Thinner	10% - 15%						
	<p>Spraying Viscosity 30÷40 seconds at 20°C (68°F).</p>						
	<p>Pot Life Approx. 60 minutes at 20°C (68°F).</p>						
	<p>Number of layers 2÷3 layers; 130÷300µm depending on the size of the gun nozzle.</p> <p>Parameters for RP spray gun Nozzle: 1,6÷2,0 mm; Pressure : 2,0-2,5 bar.</p> <p>Parameters for HVLP spray gun Nozzle: 1,5÷1,9 mm; pressure inside the nozzle: 0,7 bar.</p>						

	<p>Evaporation Time</p> <p>Between coats: 10-15 minutes Before baking: 15 minutes</p> <p>Evaporation time depends on temperature and film thickness.</p>
	<p>Curing time at 20°C: Thick coating /130÷300 µm/ is ready to sand after drying overnight. Thin film /60÷130 µm/ is ready to sand after 3÷4 h.</p> <p>Curing time at 60°C object temperature: Thick coating /130÷300 µm/ is ready for sand after baking for 35÷40 minutes and cooling down (about 2 h). Thin film /60÷130 µm/ is ready to sand after baking for 25÷30 minutes and cooling down (about 2 h).</p> <p>Temperature below 20°C(68°F)significantly decreases the hardening time.</p>
	<p>IR Drying</p> <p>Thick coating /up to 180µm/: 15÷20 minutes under short wave. Thin film /up to 130 µm/: 10÷15 minutes under short wave.</p> <p>Drying time may change depending on the type of heater.</p>
	<p>Dry Sanding:</p> <p>Grinding Machine: P360÷P500. Hand Sanding: P280÷P360.</p>
	<p>Wet Sanding:</p> <p>Hand Sanding: P600÷P1000.</p>

FURTHER WORK

V2012 primer can be directly over coated with:

- ✓ 2-pack acrylic topcoats.
- ✓ 1-pack basecoats.

GENERAL NOTES

- ✓ Do not exceed recommended doses of hardener!
- ✓ The best repair results you can achieve at room temperature. Temperature in body shop and temperature of a product should be the same.
- ✓ When working with 2K products, clean the guns and equipment immediately after use.
- ✓ The rooms should be well ventilated.

Caution: *To maintain safety, always follow the instructions given in the MSDS for the products.*

STORAGE

Store the product components in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.

Note: *After each use the container with products shall be immediately closed! Protect hardener against freeze and humidity!*

WARRANTY PERIOD

Polyurethane Acrylic Primer HS V2012 4:1 - 12 months from the date of Manufacture.
Hardener 1:4 for Polyurethane Acrylic Primer V2012 – 12 months from the date of Manufacture.

Specific VOC limits need to be referenced to verify local compliance. Altering the solvent or dilution ratio may impact VOC compliance. User is solely responsible to ensure product use and application is in accordance with all applicable regulatory, legislative, and municipal requirements.

All information are based upon the precise laboratory studies and many years of experience. The good market position does not release us from the constant supervision of our products quality. However we are not responsible for the final effects of the improper storage or application of our products, as well as for work inconsistent with the good craft practice.

TROTON Sp. z o.o.