

TECHNICAL INFORMATION

FOR PROFESSIONAL USE ONLY

V-PRO EXPRESS 4:1

FAST AIR-DRYING, UNIVERSAL ACRYLIC PRIMER

PRODUCTS

V-PRO EXPRESS 4:1 – Fast Acrylic Filler
Hardener for Acrylic Filler V-PRO EXPRESS 1:4
Thinner for Acrylic Systems MASTER

PRODUCT DESCRIPTION

High-quality, 2-component fast acrylic primer with Air Dry technology, suitable for application both as a sandable filler primer and in wet-on-wet technique. Thanks to the content of anti-corrosion agents, the primer can be applied directly to bare metal. Its universal use combined with a very short curing time (1 h / 20°C, no baking required) allows for significant time and energy savings in the repair process. The primer offers excellent stability on vertical surfaces and strong adhesion to various substrates.

- Very short curing time (1 h / 20°C, no baking required)
- Very good filling properties
- Suitable for wet-on-wet application
- Can be applied over cathaphoretic coatings without sanding
- Very good coverage
- Good anti-corrosion properties
- Strong adhesion to various types of substrates



COLOURS: grey, black, white

GLOSS GRADE: satin

VOLATILE ORGANIC COMPOUNDS

VOC for the mixture = 540 [g/l]

This product meets the EU directive (2004/42/EC/II B) that sets the VOC value for its category (c), at 540 g/l.

SURFACE PREPARATION

Acrylic Primer can be applied over:




- Steel and aluminium after flatting and degreasing.
- Zinc coated steel after flatting and degreasing.
- Undamaged cathaphoretic coatings after degreasing, without sanding
- Sanded polyester-glass laminates (GFK/GRP).
- Polyester putties.
- Epoxy primers.
- Wash primers.
- Old finishes in good condition after flatting and degreasing.




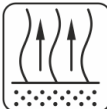



Good surface preparation is necessary for achieving best results.

Following sandpaper gradations are recommended:

- sanding by hand (dry): P280÷P400; (wet) P400-P800.
- sanding by machine (dry): P240÷P400.

APPLICATION PROCESS

USE			NUMBER OF LAYERS AND SPRAY GUN PARAMETERS							
	For automotive repairs as a filler primer (sandable) and for application using the wet-on-wet technique.		<p><u>Filling version (for sanding):</u> 2 layers; approx. 70-80 µm per dry layer</p> <p>Spray gun parameters: HVLP/RP Nozzle: 1,6÷1,8 mm Inlet pressure: 2,0÷2,2 bar.</p> <p><u>Wet-on-wet version::</u> 1.5 layers; approx. 30 µm per dry layer.</p> <p>Spray gun parameters: HVLP/RP Nozzle: 1,2÷1,4 mm; Inlet pressure: 2,0÷2,2 bar.</p>							
	MIXING RATIO by volume									
	<table><tr><td>Primer</td><td>4 parts</td></tr><tr><td>Hardener</td><td>1 part</td></tr></table> <p>Thinner:</p> <table><tr><td>filling version</td><td>0÷5%</td></tr><tr><td>Wet-on-wet version</td><td>20÷30%*</td></tr></table> <p>Stir thoroughly until achieving homogenous mixture.</p> <p><i>*) For wet-on-wet application of black primer, use the maximum dilution, i.e. 30%.</i></p>	Primer	4 parts	Hardener	1 part	filling version	0÷5%	Wet-on-wet version	20÷30%*	
Primer	4 parts									
Hardener	1 part									
filling version	0÷5%									
Wet-on-wet version	20÷30%*									

	SPRAYING VISCOSITY Filling version (0÷5% thinner): 25÷35 seconds at 20°C/DIN4 Wet-on-wet version (20÷30% thinner): 15÷17 seconds at 20°C/DIN4		HARDENING TIME Hardening time at 20°C: Filling version (140-160 µm): ready for sanding after 1 hour. <i>Temperature below 20°C significantly increases the hardening time.</i> Hardening time at 60°C: Approx. 10 minutes for a dry film thickness of 140–160 µm
	POT LIFE Filling version: approx. 35 minutes at 20°C. Wet-on-wet version: approx. 85 minutes at 20°C.		
	FLASH-OFF TIME Between layers: 5-10 minutes Before applying solvent base: approx. 20 minutes Before applying waterborne base: approx. 30 minutes Flash-off time depends on temperature and layer thickness.		
	DRY SANDING Machine sanding: P360÷P500. Hand sanding: P400÷P500. The wet-on-wet version doesn't require sanding!!		IR DRYING 10÷15 minutes of short waves for the thickness of 140÷160 µm. Do not exceed 60°C. Use as recommended by the equipment manufacturer. Wait about 10 minutes before starting the heater drying.
	WET SANDING Machine sanding: P600÷P1000. Hand sanding: P800÷P1000. The wet-on-wet version doesn't require sanding!!		

FURTHER WORK	
2K acrylic fillers can be directly coated with: <ul style="list-style-type: none"> • 2K top coats, • 1K base coats. 	Additionally, they can be overcoated with: <ul style="list-style-type: none"> • 2K polyester putties, • 2K acrylic primers.
GENERAL NOTES	
<ul style="list-style-type: none"> • Do not exceed recommended doses of the hardener! • The best repair results can be achieved at room temperature. The temperature in the body shop and the temperature of the product should be similar. • For correct primer application at temperatures above 25 °C, the use of SLOW hardener and SLOW MASTER thinner is recommended in order to maintain proper flash-off and curing times. • When working with 2K products, it is recommended to use personal protection equipment. Protect the eyes and respiratory system. • The rooms should be well ventilated. • Clean the guns and equipment immediately after use. 	
Caution: To maintain safety, always follow the instructions given in the MSDS for the products.	
STORAGE	
Store the product components between 15 to 25°C in a sealed container, in dry and cool places, away from fire and heat sources, as well as direct sunlight.	
Note: 1. After each use the container with product should be immediately closed! 2. Protect the hardener from frost and dampness!	
WARRANTY PERIOD	
V-PRO EXPRESS 4:1 Acrylic Filler	– 12 months from the date of production
Hardener for Acrylic Filler V-PRO EXPRESS 1:4	– 12 months from the date of production
Thinner for Acrylic Systems MASTER	– 24 months from the date of production

PRODUCT	ART. No.
V-PRO EXPRESS 4:1 Acrylic Filler	(0,8l+0,2l) standard: 16864, 16863, 16865 (0,8l+0,2l) slow: 17328, 17326, 17327 (3,6l): 16868, 16867, 16869
Hardener STANDARD for Acrylic Filler V-PRO EXPRESS 1:4 Hardener SLOW for Acrylic Filler V-PRO EXPRESS 1:4 (>25°C)	(0,9l): 16870 (0,9l): 17330
Thinner STANDARD for Acrylic Systems MASTER Thinner SLOW for Acrylic Systems MASTER (>25°C)	(1l; 5l): 300002253, 300002790 (1l; 5l): 6152, 6153

LIMITATION OF LIABILITY
The information contained in the TDS is up-to-date and correct on the day the information is released.

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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.

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